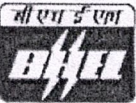


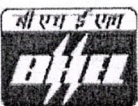
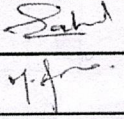
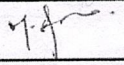
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| निष्कर्ष देना हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                |                                                                    | संस्थान क्रय विनिर्देश (सी एफ एफ पी)<br>PLANT PURCHASE SPECIFICATION<br>(CFFP - HARDWAR)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                | FF07014 Rev 01                                      |                                   |    |                             |                                          |     |
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|                                                                                                                                                                                                                       |                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                | पृष्ठ का<br>Page 1 of 5                             |                                   |    |                             |                                          |     |
| सामग्री सूचित संख्या<br>को अभिलेखित करें                                                                                                                                                                              | SUPERSEDES<br>INVENTORY NO                                                                                                                          | <b>TURNING INSERT SNMM 250724</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                |                                                     |                                   |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | <p>1. GENERAL</p> <p>This specification governs the requirements of Turning Inserts SNMM 250724 for rough machining of 9Cr1Mo steel grade Castings in Machine Shop, CFFP.</p> <p>2. APPLICATION</p> <p>Turning Insert SNMM 250724 shall be used for Rough Machining of Forgings &amp; castings of 9Cr1Mo steel grade having hardened surface, sand inclusion, cracks on Conventional Vertical Boring Machines.</p> <p>3. COMPLIANCE WITH NATIONAL STANDARD</p> <p>There is no national standard available.</p> <p>4. CHARACTERISTICS</p> <p>The different types of Inserts of different vendors along with their Grade and profile description suitable for Machine Shop Requirement are described as below:</p> <table border="1"><thead><tr><th>CI</th><th>Description / Material Code</th><th>Equivalent models of Different Companies</th></tr></thead><tbody><tr><td>4.1</td><td>Turning Insert SNMM 250724 for Rough Machining of castings of 9Cr1Mo steel grade having hardened surface, sand inclusion, cracks Code: FF7158000010</td><td>Kennametal: SNMM 250724 RH KCP40B<br/>MMC: SNMM 250724 HX MC6035</td></tr></tbody></table> |                |                                                     |                                   | CI | Description / Material Code | Equivalent models of Different Companies | 4.1 |
| CI                                                                                                                                                                                                                    | Description / Material Code                                                                                                                         | Equivalent models of Different Companies                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |                                                     |                                   |    |                             |                                          |     |
| 4.1                                                                                                                                                                                                                   | Turning Insert SNMM 250724 for Rough Machining of castings of 9Cr1Mo steel grade having hardened surface, sand inclusion, cracks Code: FF7158000010 | Kennametal: SNMM 250724 RH KCP40B<br>MMC: SNMM 250724 HX MC6035                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                |                                                     |                                   |    |                             |                                          |     |
| COPYRIGHT AND CONFIDENTIAL<br>The information on this documents is the property of Bharat Heavy Electrical Limited it must not be used directly or indirectly, in any way, detrimental to the interest of the company |                                                                                                                                                     | इस प्रलेख में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रलेख एवं आंतरिक रूप में किसी भी तरह प्रयोग, जो की कंपनी के हित में नहीं है, न किया जाये                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                |                                                     |                                   |    |                             |                                          |     |
| निष्कर्ष देना हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                | सामग्री सूचित संख्या<br>INVENTORY NO.                                                                                                               | RMS PLANNING                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | VIKALP BIBHUTI | अनुवादक TRANSLATED BY                               |                                   |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | RMS PROD                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | R.R.BAUNTHIYAL | निर्माणकर्ता WORKED BY                              | R.K.KHANDELWAL                    |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | Chairman PSC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | GM VARMA       | जांचकर्ता CHECKED BY                                | MOHD. ASAD                        |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | सहमत विभाग<br>Agreed Deptt                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | नाम<br>Name    | दिनांक एवं<br>हस्ताक्षर<br>Date and Signature       | अनुमोदित APPROVED BY<br>R.K.SINGH |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | स्वीकृति : संस्थान मानक समिति<br>APPROVED : PLANT STANDARDS COMMITTEE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                |                                                     |                                   |    |                             |                                          |     |
|                                                                                                                                                                                                                       |                                                                                                                                                     | निर्माण<br>PREPARED : RMS TOOLING                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                | जारी: फाउंड्री प्रौद्योगिकी<br>ISSUED : RMS TOOLING | दिनांक<br>DATE 13.06.19           |    |                             |                                          |     |

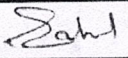
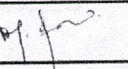


| डिजाइन नंबर<br>SIGN & DATE                                                                                                                                                                                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <b>संस्थान क्रय विनीर्देश (सी एफ एफ पी)</b><br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR) |           | <b>FF07014 Rev 01</b>   |          |          |         |           |         |           |         |         |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
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|                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                        |           | पृष्ठ का<br>Page 2 of 5 |          |          |         |           |         |           |         |         |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
| सुपरसेड<br>INVENTORY NO                                                                                                                                                                                              | <b>5. PERFORMANCE TEST</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                        |           |                         |          |          |         |           |         |           |         |         |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
| सामग्री सूचित मंत्रालय को अधिष्ठाता कर्ता                                                                                                                                                                            | <p>5.1 Vendors offering the Grade and profile already mentioned in Clause 4, need not undergo any performance test.</p> <p>5.2 For new vendors and/or vendors offering new models in any of the categories, performance test will have to be carried out as per the following criteria and methodology.</p> <p>5.2.1 Prior to the shop floor trials, the PQC, if any, and technical criteria as mentioned in technical specification are to be met.</p> <p>5.2.2 Vendor shall submit his offered insert on returnable basis for trial at the time submission of technical offer.</p> <p>5.2.3 Representative of vendor may be present during the trial.</p> <p>5.2.4 Trial shall be conducted on conventional Vertical Borer Machine having Table Dia 7.1 Mtr. with Tool Post suitable for Tool Holder of 50 X 50 X 300 with chemical composition and mechanical properties as follows:-</p> <p>Chemical Properties :-</p> <table border="1"> <thead> <tr> <th>Elements</th> <th>Ni</th> <th>Cr</th> <th>V</th> <th>Mn</th> <th>Mo</th> <th>Co</th> <th>Al</th> <th>C</th> <th>Si</th> <th>Nb</th> <th>W</th> <th>N</th> </tr> </thead> <tbody> <tr> <td>Wt. (%)</td> <td>0.6-0.8</td> <td>9.2-10.2</td> <td>0.18-0.25</td> <td>0.8-1.2</td> <td>0.9-1.05</td> <td>1.0-1.05</td> <td>0.4-1.0</td> <td>0.11-1.14</td> <td>0.2-0.4</td> <td>0.05-0.08</td> <td>0.9-1.0</td> <td>0.0-0.0</td> </tr> </tbody> </table> <p>P-0.02 Max, S-0.01 Max, Al-0.02 max</p> <p><u>Mechanical Properties:</u> -</p> <p>0.2% Yields strength: <math>\geq 520</math> N/mm<sup>2</sup></p> <p>Ultimate Tensile strength: 680-850 N/mm<sup>2</sup></p> <p>% Elongation <math>\geq 15\%</math></p> |                                                                                                        |           |                         |          | Elements | Ni      | Cr        | V       | Mn        | Mo      | Co      | Al | C | Si | Nb | W | N | Wt. (%) | 0.6-0.8 | 9.2-10.2 | 0.18-0.25 | 0.8-1.2 | 0.9-1.05 | 1.0-1.05 | 0.4-1.0 | 0.11-1.14 | 0.2-0.4 | 0.05-0.08 | 0.9-1.0 | 0.0-0.0 |
| Elements                                                                                                                                                                                                             | Ni                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Cr                                                                                                     | V         | Mn                      | Mo       | Co       | Al      | C         | Si      | Nb        | W       | N       |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
| Wt. (%)                                                                                                                                                                                                              | 0.6-0.8                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 9.2-10.2                                                                                               | 0.18-0.25 | 0.8-1.2                 | 0.9-1.05 | 1.0-1.05 | 0.4-1.0 | 0.11-1.14 | 0.2-0.4 | 0.05-0.08 | 0.9-1.0 | 0.0-0.0 |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
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| डिजाइन नंबर<br>SIGN & DATE                                                                                                                                                                                           | निर्माणकर्ता<br>WORKED BY<br>R.K.KHANDELWAL                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                                                        |           |                         |          |          |         |           |         |           |         |         |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |
| सामग्री सूचित मंत्रालय<br>INVENTORY NO                                                                                                                                                                               | जांचकर्ता<br>CHECKED BY<br>MOHD. ASAD                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                        |           |                         |          |          |         |           |         |           |         |         |    |   |    |    |   |   |         |         |          |           |         |          |          |         |           |         |           |         |         |



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| दिनांक हेतु हस्ताक्षर<br>SIGN & DATE                                                                                                                                   |                                                                                                                                                             | संस्थान क्रय विनिर्देश (सी एफ एफ पी)<br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>FF07014 Rev 01</b><br>पृष्ठ का<br>Page 3 of 5 |                                                                                       |
| SUPERSEDES<br>INVENTORY NO                                                                                                                                             | कॉपीराइट और गोपनीयता<br>COPYRIGHT AND CONFIDENTIAL<br>The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company. | 5.2.5 Operational Parameters:- Depth of Cut 10-12 mm , Cutting Speed – 15-20 Mtr/Min , Cutting Feed – 0.75-1 mm/rev<br><br>5.2.6 Following operating parameters needs to be obtained during shop trial:<br><br>5.2.6.1 Insert Life – minimum 4 Hours for single cutting edge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                  |                                                                                       |
| सामग्री सूचित संख्या को अधिपत्रित करें                                                                                                                                 |                                                                                                                                                                                                                                              | 6. MISCELLANEOUS<br><br>6.1 The supplied inserts shall work with ISO Tool Holder PSDNN 5050 T25<br><br>6.2 The supply shall include the following:<br>a) Test and guaranty certificates with minimum Guaranty Period of 12 Months .                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                  |                                                                                       |
| इस प्रालेख में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रालेख एवं अप्रत्यक्ष रूप में किसी भी तरह प्रयोग, जो की कंपनी के हित में नहीं है, न किया जाये |                                                                                                                                                                                                                                              | 7. INSPECTION AND REPLACEMENT<br><br>7.1 BHEL reserves the right to inspect material at site before despatch. The supplier shall intimate in advance about readiness of material enclosing a copy of test certificate of the material offered for inspection. However, inspection at BHEL shall be final. The supplier shall offer BHEL representative all reasonable test facilities without charge to satisfy the latter that the material being furnished is in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests elsewhere.<br><br>7.2 If the tools received at CFFP is not found in accordance with the requirements or it fails during guarantee period, it shall be rejected and the supplier will have to replace it free of cost at the earliest. |                                                  |                                                                                       |
| दिनांक हेतु हस्ताक्षर<br>SIGN & DATE                                                                                                                                   | सामग्री सूचित संख्या<br>INVENTORY NO                                                                                                                                                                                                         | 8. TEST CERTIFICATES<br><br>8.1 Unless otherwise specified, original test certificate from the original manufacturer shall be supplied with each consignment bearing the following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with despatch document.<br>a. BHEL PO No. with Date<br>b. Specification No.<br>c. Supplier reference / trade mark<br>d. Identification No. / Batch No.<br>e. Characteristics as per Clause 4<br>f. Any other specific information which the supplier would like to convey.<br><br>8.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.                                                                                                                                                                             |                                                  |                                                                                       |
|                                                                                                                                                                        |                                                                                                                                                                                                                                              | निर्माणकर्ता<br>WORKED BY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | R.K.KHANDELWAL                                   |  |
|                                                                                                                                                                        |                                                                                                                                                                                                                                              | जांचकर्ता<br>CHECKED BY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | MOHD. ASAD                                       |  |



|                                                                                                                                                                                                                             |                                                                                   |                                                                                                                                                                                                                                                                              |                |                                                                                       |              |
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| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                         |  | संस्थान क्रय विनीर्देश (सी एफ एफ पी)<br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR)                                                                                                                                                                              |                | <b>FF07014 Rev 01</b>                                                                 |              |
|                                                                                                                                                                                                                             |                                                                                   |                                                                                                                                                                                                                                                                              |                | पृष्ठ<br>Page                                                                         | का<br>4 of 5 |
| सामग्री सूचित संख्या<br>को अभिलेखित कर्ता                                                                                                                                                                                   | SUPERSEDES<br>INVENTORY NO.                                                       | <b>9. MARKING &amp; PACKING</b><br><br>The supplied inserts should be suitably packed to avoid damage during transit and storage. The packing should be that of the original manufacturer. Each item should have model No, Identification No. (if any) marked on the insert. |                |                                                                                       |              |
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| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                         |                                                                                   |                                                                                                                                                                                                                                                                              |                |                                                                                       |              |
| सामग्री सूचित संख्या<br>INVENTORY NO.                                                                                                                                                                                       |                                                                                   |                                                                                                                                                                                                                                                                              |                |                                                                                       |              |
|                                                                                                                                                                                                                             |                                                                                   | निर्माणकर्ता<br>WORKED BY                                                                                                                                                                                                                                                    | R.K.KHANDELWAL |  |              |
|                                                                                                                                                                                                                             |                                                                                   | जांचकर्ता<br>CHECKED BY                                                                                                                                                                                                                                                      | MOHD. ASAD     |  |              |



6

| निम्न सूचित संख्या<br>INVENTORY NO                                                                                                                                                                                                                                                                                                                        | निम्न सूचित संख्या<br>को अतिरिक्त करें | SUPERSEDES<br>INVENTORY NO                                                            |  | संस्थान क्रय विनिर्देश (सी एफ एफ पी)<br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR) |         | <b>FF07014 Rev 01</b><br>पृष्ठ का<br>Page 5 of 5 |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|---------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|---------|--------------------------------------------------|--|------------------------|----------------|---------------------------------------------------------------------------------------|----------------------|------------|---------------------------------------------------------------------------------------|----|----|---|---------------------------------------------------------------|--|---------|
|                                                                                                                                                                                                                                                                                                                                                           |                                        |                                                                                       |                                                                                   | <b>RECORD OF CHANGES</b>                                                                        |         |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| <table border="1"> <thead> <tr> <th>Rev Code</th> <th>No. of changes</th> <th>Sheet No.</th> <th>Nature of Change</th> <th>Sign</th> <th>Date</th> </tr> </thead> <tbody> <tr> <td>01</td> <td>01</td> <td>1</td> <td>Clause No. 4.1 modified to Change Grade from MC6025 to MC6035</td> <td></td> <td>13.6.19</td> </tr> </tbody> </table>               |                                        |                                                                                       |                                                                                   |                                                                                                 |         |                                                  |  | Rev Code               | No. of changes | Sheet No.                                                                             | Nature of Change     | Sign       | Date                                                                                  | 01 | 01 | 1 | Clause No. 4.1 modified to Change Grade from MC6025 to MC6035 |  | 13.6.19 |
| Rev Code                                                                                                                                                                                                                                                                                                                                                  | No. of changes                         | Sheet No.                                                                             | Nature of Change                                                                  | Sign                                                                                            | Date    |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| 01                                                                                                                                                                                                                                                                                                                                                        | 01                                     | 1                                                                                     | Clause No. 4.1 modified to Change Grade from MC6025 to MC6035                     |                                                                                                 | 13.6.19 |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| <b>DISTRIBUTION OF PRINTS</b>                                                                                                                                                                                                                                                                                                                             |                                        |                                                                                       |                                                                                   |                                                                                                 |         |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| Machine Shop                                                                                                                                                                                                                                                                                                                                              |                                        |                                                                                       |                                                                                   |                                                                                                 |         |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| <table border="1"> <tr> <td>निर्माणकर्ता WORKED BY</td> <td>R.K.KHANDELWAL</td> <td></td> </tr> <tr> <td>जांचकर्ता CHECKED BY</td> <td>MOHD. ASAD</td> <td></td> </tr> </table> |                                        |                                                                                       |                                                                                   |                                                                                                 |         |                                                  |  | निर्माणकर्ता WORKED BY | R.K.KHANDELWAL |  | जांचकर्ता CHECKED BY | MOHD. ASAD |  |    |    |   |                                                               |  |         |
| निर्माणकर्ता WORKED BY                                                                                                                                                                                                                                                                                                                                    | R.K.KHANDELWAL                         |  |                                                                                   |                                                                                                 |         |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |
| जांचकर्ता CHECKED BY                                                                                                                                                                                                                                                                                                                                      | MOHD. ASAD                             |  |                                                                                   |                                                                                                 |         |                                                  |  |                        |                |                                                                                       |                      |            |                                                                                       |    |    |   |                                                               |  |         |

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