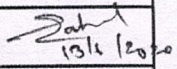
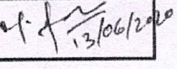
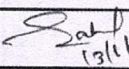
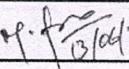


3	REVISION NO. & DATE SIGNATURE	संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF07014 Rev 02 पृष्ठ का Page 1 of 5						
	SUPERSEDES INVENTORY NO. समीचीन संख्या के अधीन संख्या	TURNING INSERT SNMM 250724							
COPYRIGHT AND CONFIDENTIAL The information on this document 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.	1. GENERAL This specification governs the requirements of Turning Inserts SNMM 250724 for rough machining of 9Cr1Mo steel grade Castings in Machine Shop, CFFP.								
	2. APPLICATION Turning Insert SNMM 250724 shall be used for Rough Machining of Forgings & castings of 9Cr1Mo steel grade having hardened surface, sand inclusion, cracks on Conventional Vertical Boring Machines.								
	3. COMPLIANCE WITH NATIONAL STANDARD There is no national standard available.								
	4. CHARACTERISTICS The different types of Inserts of different vendors along with their Grade and profile description suitable for Machine Shop Requirement are described as below:								
	<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 MMC: SNMM 250724 HX MC6035 MICRO ENGINEERING SOLUTION: SNMM250724 HG N50 </td> </tr> </tbody> </table>	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 MMC: SNMM 250724 HX MC6035 MICRO ENGINEERING SOLUTION: SNMM250724 HG N50		
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इस प्रतीक में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप में किसी भी तरह प्रयोग, जो की कंपनी के हित में नहीं है, न किया जाये									
REVISION NO. & DATE SIGNATURE	RMS PLANNING RMS PROD Chairman PSC सहमत विभाग Agreed Deptt	VIKALP BIBHUTI R.R.BAUNTHIYAL GM VARMA नाम Name	दिनांक एवं हस्ताक्षर Date and Signature						
INVENTORY NO. समीचीन संख्या	अनुवादक TRANSLATED BY निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY अनुमोदित APPROVED BY स्विकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE निर्माण : जारी : आर.एम.एस. टूलिंग PREPARED : RMS TOOLING ISSUED : RMS TOOLING दिनांक DATE 13.06.20								

दिनांक वैन हस्ताक्षर SIGN & DATE		संस्थान क्रय विनीर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF07014 Rev 02																											
			पृष्ठ का Page 2 of 5																											
सुपरसेड्स INVENTORY NO.	5. PERFORMANCE TEST																													
समग्री संश्लेषण संख्या को अधिलिखित कर्त	5.1 Vendors offering the Grade and profile already mentioned in Clause 4, need not undergo any performance test. 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. 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. 5.2.2 Vendor shall submit his offered insert on returnable basis for trial at the time submission of technical offer. 5.2.3 Representative of vendor may be present during the trial. 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 mm. Chemical composition and mechanical properties of the jobs to be machined as follows:- Chemical Properties :- <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>0.4-1.05</td> <td>0.11-1.14</td> <td>0.2-0.4</td> <td>0.05-0.08</td> <td>0.9-1.05</td> <td>0.2-0.4</td> </tr> </tbody> </table> P-0.02 Max, S-0.01 Max, Al-0.02 max <u>Mechanical Properties:</u> - 0.2% Yields strength: ≥ 520 N/mm² Ultimate Tensile strength: 680-850 N/mm² % Elongation $\geq 15\%$				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	0.4-1.05	0.11-1.14	0.2-0.4	0.05-0.08	0.9-1.05	0.2-0.4
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समग्री संश्लेषण संख्या INVENTORY NO.																														
		निर्माणकर्ता WORKED BY	R.K.KHANDELWAL																											
		जांचकर्ता CHECKED BY	MOHD. ASAD																											

BHEL भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	Revision No. / SIGN & DATE	संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF07014 Rev 02	
	SUPERSEDES INVENTORY NO.	पृष्ठ का Page 3 of 5		
भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	5.2.5 Operational Parameters:- Depth of Cut 10-12 mm , Cutting Speed – 15-20 Mtr/Min , Cutting Feed – 0.75-1 mm/rev			
	5.2.6 Following operating parameters needs to be obtained during shop trial: 5.2.6.1 Insert Life – minimum 4 Hours for single cutting edge			
भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	6. MISCELLANEOUS			
	6.1 The supplied inserts shall work with ISO Tool Holder PSDNN 5050 T25 6.2 The supply shall include the following: a) Test and guaranty certificates with minimum Guaranty Period of 12 Months .			
भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	7. INSPECTION AND REPLACEMENT			
	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. 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.			
भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	8. TEST CERTIFICATES			
	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. a. BHEL PO No. with Date b. Specification No. c. Supplier reference / trade mark d. Identification No. / Batch No. e. Characteristics as per Clause 4 f. Any other specific information which the supplier would like to convey. 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.			
Revision No. / SIGN & DATE	भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	निर्माणकर्ता WORKED BY	R.K.KHANDELWAL	13/06/20
भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	भारतीय विद्युत संचयन निगम लि. भारतीय विद्युत संचयन निगम लि.	जांचकर्ता CHECKED BY	MOHD. ASAD	13/06/20

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनीर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF07014 Rev 02 पृष्ठ का Page 4 of 5	
सामग्री सूचीत संख्या की अधिष्ठित कर्ता	SUPERSEDES INVENTORY NO	9. MARKING & PACKING 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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सामग्री सूचीत संख्या INVENTORY NO			निर्माणकर्ता WORKED BY	R.K.KHANDELWAL	 13/12/20
			जांचकर्ता CHECKED BY	MOHD. ASAD	 13/04/2020