

BHARAT HEAVY ELECTRICALS LIMITED

FOUNDRY DIVISION

TECHNO – COMMERCIAL BID

TENDER DOCUMENT NO. : **FYM / CONT / 2009 – 10 / 05**

NAME OF WORK : **MOULDING (MOULD & CORE MAKING) FOR CASTINGS IN STEEL, CAST IRON AND NON FERROUS AREA.**

ITEM	DESCRIPTION / NATURE OF WORK	ESTIMATED QTY.	UNIT	REMARKS
1	Moulding (mould & core making) for castings in steel, cast iron and Non Ferrous	3188	MT	

1.0 SCOPE OF WORK

MOULDING OPERATION INCLUDES :

- a) Pattern setting
- b) Mould box setting
- c) Gagger setting
- d) Setting of ingates and runner sleeves
- e) Riser setting
- f) Mould box filling with sand
- g) Mould Making

Signature of Contractor

- h) Pattern drawing
- i) Core Making
- j) Painting (2 to 3 coats)
- k) Mould closing
- l) Preheating of moulds before pouring of moulds.
- m) Sprinkling of Ferrux & Thermexo powder on risers during pouring of moulds
- n) Transporting of materials required for preparation of moulds by hand trolley from stores and yards.
- o) Knockout of castings.

CORE MAKING OPERATION INCLUDES :

- a) Core box cleaning
- b) Setting of reinforcement / gagger
- c) Filling of sand
- d) Core drawing
- e) Painting (2 & 3 Coats)

2.0 TECHNICAL TERMS AND CONDITIONS

- 1) Contractor shall not engage any female labour for the execution of this work without the written Permission of Engineer Incharge of work.
- 2) Contractor shall arrange to carry out the above-mentioned operations at Fettleing area of Foundry Division in both shifts ie, (7.00 AM to 4.00 PM) & (4.00 PM to 1.00AM) as required.
- 3) Actual quantum of work may vary within limits of $\pm 25\%$ from the estimated quantum of work.
- 4) Space and all requisite facilities like crane, compressed air, power etc. shall be made available to contractor in moulding area.
- 5) The contractor will be solely responsible for timely execution and completion of work. Contractor has to depute his own supervisor for necessary supervision and monitoring. Supervisor should have good knowledge of Foundry.

Bidders acceptance (Y / N)

Signature of Contractor

Bidders acceptance (Y / N)

- 6) Technical requirement and guidance shall be provided by BHEL Supervisor / Executive however whole responsibility of completion of works contract lies with the contractor .
- 7) If, any time, it is noticed that the party has stopped the work or not deploying adequate work force, BHEL may get the balance work done through other contractor on risk and cost.
- 8) The final acceptance / completion certificate shall be issued on finished casting weight basis by shop supervisor of moulding area and endorsed by concerned executive looking after the area.

3.0 WORK MEASUREMENT

Based on the weekly / monthly report duly signed by concerned supervisor & counter signed by shop executive.

4.0 PERSONAL PROTECTION SAFETY EQUIPMENTS REQUIRED

1. UNIFORM	3. HELMET
2. SAFETY SHOES	4. GLOVES (LEATHER)
	5. DANGRI
	4. FACE MASK RESPIRATOR

5.0 PROCEDURE FOR SUBMISSION OF TENDER QUOTATION :

Tender quotations to be submitted in two bid system.

Signature of Contractor

6.0

PAYMENT TO CONTRACTOR

Payment by BHEL will be made on the basis of total executed Quantity by the firm. The payment shall be made on **Quarterly Basis.**

7.0

JOB ASSESSMENT

As per our assessment and estimate, minimum 65 Nos. of contract workers are required for moulding of 3188 MT of casting. Before quoting, the party should contact the concerned foundry executive for any clarification and actual work assessment.

8.0

SPLITTING OF CONTRACT

Works contract for moulding (mould & core making) for casting in steel, cast iron and non ferrous area will be split in to two parties for operational convenience. Works contract will be split in the ratio 60:40. The party with L1 rates will be awarded 60% of contract and the second party will be awarded 40% of contract. The second party has to work on the L1 rate. The first party with L1 rate has to do the moulding work of ferrous and non ferrous area where as the second party has to do the moulding work of steel area.

Signature of Contractor

Date : _____

BHARAT HEAVY ELECTRICALS LIMITED

FOUNDRY DIVISION

PRICE BID

TENDER DOCUMENT NO. : **FYM / CONT / 2009 – 10 / 05**

NAME OF WORK : **MOULDING (MOULD & CORE MAKING) FOR CASTINGS IN STEEL, CAST IRON AND NON FERROUS AREA .**

ITEM	DESCRIPTION / NATURE OF WORK	ESTIMATED QTY.	RATE QUOTED PER MT (inclusive of all taxes, duties, incidentals etc expect service tax)		REMARKS
			In Fig.	In Words	
1	Moulding (mould & core making) for castings in steel, cast iron and non ferrous	3188 MT (Finished / casting weight as per Drawing / Shipped weight without runner / riser)			

Signature of Contractor

Date : _____