

TECHNICAL SPECIFICATIONS OF PORTABLE CHAMFERING MACHINE

NOTE :-

1. The vendor should fill the "Offered" Column in compliance to specified requirements and also "Deviations" Column
2. The offer and all documents enclosed with offer should be in English language only.

ADDRESS OF THE SUPPLIER :**ADDRESS OF THE INDIAN AGENTS :****TELEPHONE NOS.:****TELEPHONE NOS.:****FAX NOS.:****FAX NOS.:****E-MAIL ADDRESS :****E-MAIL ADDRESS :****SCOPE: SUPPLY & COMMISSIONING OF PORTABLE EDGE PLANER MACHINE, Qty- 3 nos**

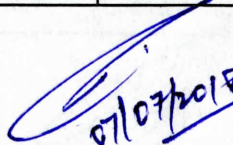
SL. NO.	DESCRIPTION OF BHEL REQUIREMENT	REQUIRED	OFFERED	DEVIATION	REMARKS
1.0	APPLICATION				
1.1	The Portable Chamfering machine is required for making edge/ bevel & for de-cladding pupose on Titatium claddd mild steel plates of different thickness using carbide tools. The machine will be used for- a.) Making edge/ bevel on all the four edges along the periphery of plate. b.) Declading titanium of 2mm from the top side of plate for the width of 10mm along the periphery of plate.	Vendor to offer			
2	Job Description				
2.1	Type of job- Titanium claddd mild steel plate	Vendor to note			
2.2	Thickness of Plate- 18mm(16mm+2mm cladding) , 12mm(10mm+2mm cladding). Thickness of Titanium cladding- 2mm on each thickness of plate.	Vendor to note			
2.3	Size of plates- 2.5M x 7.0M (May vary according to requirement).	Vendor to note			

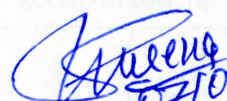
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07.07.18J. K. Singh
07/07/18

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SL. NO.	DESCRIPTION OF BHEL REQUIREMENT	REQUIRED	OFFERED	DEVIATION	REMARKS
2.4	Details of Titanium Cladding - 1. Grade - ASTM, B265 , Gr2 2. UTS - 345 Mpa 3. Shear strength- 175-200 MPa. Details of Carbon Steel- 1. Grade - ASTM, A516, Gr 70 2. UTS- 485-620 MPa 3. Shear Strength - 250 MPa -310 MPa	Vendor to note			
2.5	Details of edge/ Bevel- Edge/ bevel is required to be made on all the four edges of plates along the periphery on mild steel portion. Please refer sketch (Annexure-1) for details.	Vendor to note			
2.6	Details of De-cladding: De-cladding of titanium of 2mm thickness is required from the top side of plate for the width of 10mm along the periphery of plate. Please refer sketch (Annexure-1) for details.	Vendor to note			
3.0	TECHNICAL SPECIFICATION				
3.1	Description: Portable Chamfering Machine with decladding attachment	Vendor to offer			
3.2	Input Supply- 220V $\pm$ 10% variation	Vendor to note			
3.3	Power	Vendor to specify			
3.4	Spindle speed at no load	Vendor to specify			
3.5	The machine should have provision of decladding as mentioned at clause 2.6	Vendor to offer			
3.6	Bevel angle- -60 to + 60 deg	Vendor to Confirm			
3.7	Plate thickness which can be accommodated by machine	Vendor to specify			
3.8	The machine should be track/ rail mounted with the provision of extended track/ rail.	Vendor to offer			
3.9	Feed Speed	Vendor to specify			
3.10	Input Power Cable- 20 M.	Vendor to Confirm			
3.11	Weight of the machine	Vendor to specify			

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3.12	The machine should be complete in read-to-use condition with all necessary accessories like milling unit, guide track, track clamp, chip container etc.	Vendor to Confirm			
4.0	TECHNICAL FEATURES				
4.1	Construction- Portable, light weight, handy and sturdy to work at shop floor working condition	Vendor to confirm			
4.2	It should have following in-built features:				
4.2.1	Auto-feed portable bevelling	Vendor to confirm			
4.2.2	Continuously adjustable bevel angle between 60 and minus 60 degree so that there is no need to turn the plate for bevelling from other side	Vendor to confirm			
4.2.3	Provision of bevelling in both travel directions	Vendor to confirm			
4.2.4	Should have provision of motor overload protection	Vendor to confirm			
4.2.5	Should have suitable provision for quick set-up	Vendor to confirm			
4.2.6	Should have provision of extendable rails	Vendor to confirm			
5.0	SPARES (For 3 nos of Portable Chamfering Machine)				
5.1	Vendor to quote recommended spares for 2 year trouble free operation	Vendor to offer			
6.0	DOCUMENTATION:				
6.1	Three sets of operation & maintenance manuals consisting following along with the supply-	Vendor to confirm			
6.2	Operating & maintenance instructions with Do's & Don'ts	Vendor to confirm			
6.3	Mechanical assembly diagrams	Vendor to confirm			
6.4	Electrical & Electronic circuit diagrams	Vendor to confirm			
6.5	Split diagrams with part identification	Vendor to confirm			
6.6	Trouble shooting chart and diagnostic system	Vendor to confirm			
6.7	List of complete spares with identification nos.	Vendor to confirm			

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7.0	COMMISSIONING				
7.1	Commissioning & trials of all the features of the machine will be done by the vendor at BHEL work.	Vendor to confirm			
7.2	During commissioning vendor has to carry out following operation on 1 no of Titanium clad plate with each machine (Total 3 nos of plates)- (Refer details in the sketch mentioned at Clause 2.5 & 2.6) 1. Beveling on all 4 edges of plate 2. Decladding of Titanium from top edge of Plate	Vendor to confirm			
7.3	Vendor will impart training to BHEL personnel during commissioning.	Vendor to confirm			
8.0	FINAL ACCEPTANCE				
8.1	Final acceptance shall be given after commissioning of the Portable Chamfering Machine at BHEL by the vendor to the full satisfaction of BHEL as per specification. Final commissioning will be given after 10 days of successful trial of the machine mentioned at clause 7.2.	Vendor to confirm			
9.0	WARANTTEE				
9.1	Warrantee for 2 years for smooth & trouble free working from date of commissioning	Vendor to confirm			
10.0	Special Instructions				
10.1	Vendor should provide pointwise confirmations and clarifications of all above mentioned specification clauses with technical back-up documents/ technical literature	Vendor to confirm			
10.2	Vendor should mention clearly the scope of supply i.e. Main machine, de-cladding arrangement, guide track, chip container etc.	Vendor to confirm			

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10.3	BHEL reserves the right to verify information submitted by vendor. In case the information is found to be false/incorrect, the offer shall be rejected.	Vendor to note			
11.0	PRE QUALIFICATION REQUIREMENT (PQR) :				
11.1	Only those vendors should quote who have supplied and commissioned at least one number of Portable Chamfering machine for the following application- 1. Operation of bevelling from the edge of plate 2. Declading from the top side of plate in last five years and such machine(s) is (are) presently working satisfactory for more than one year after commissioning. The following information should be submitted by the vendor about the companies where such machine has been supplied. This is required from all the vendors for qualification of their offer.	Vendor to comply			
11.1.1	Name of the customer/Company where such machine(s) is(are) installed.	Vendor to submit			
11.1.2	Complete postal address of the customer.	Vendor to submit			
11.1.3	Year of commissioning.	Vendor to submit			
11.1.4	Application for which the machine is supplied	Vendor to submit			
11.1.5	Name and designation of the contact person of the customer.	Vendor to submit			
11.1.6	Phone ,FAX No. and email address of the contact person of the customer.	Vendor to submit			
11.1.7	Performance Certificate from the customer regarding satisfactory performance of the machine supplied to them	Vendor to submit			

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11.2	Alternatively, in case, the vendor is not able to submit performance certificate from their customer as per clause no 11.1, the vendor should demonstrate working of portable edge planer for application mentioned at clause no 11.1 at vendor works (In India only)/ BHEL works.	Vendor to comply			
11.3	Vendor to accept & submit details for either 11.1 or 11.2 or both. In case the mentioned details are not furnished, the offer will not be considered.	Vendor to comply			

07/07/2018
Ravi Deshpande
SE (WT)

R Chaudhary
07/07/18
(Rohit Chaudhary)
E2, WEX BL2 & 11

V.K. Verma
07.07.18
Dy. Manager
BL-2, Bay-4

07/07/2018
BLM
AUM (WT)

B.S.
7.7.18
(BS Arms)
AGN/WT

Annexure-1

2

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM: DG 44(B)

50 THE REST.

A-A

TI SIDE
CLADDED SURFACE

MS SIDE

TECH. REQUIREMENTS :-

1. TI CLADDING TO BE REMOVED ON ALL SIDES COMPLETELY AS PER VIEW A-A.
2. PAINTING & PRESERVATION IS TO BE DONE AS PER HXE PRODUCT STD. NO. HE 77001.

GRADE OF UNTOL. DIM:-

M/CG- V/2/M/F AA 0230208

WELDING-A/B/C/D-AA621104

GAS CUTTING-T3'AA0621101

REV DATE ALTERED
CHECKEDCBOM NO.
81740070001STATUS
OF DRGAGREED
DEPT NAME SIGN DATE

WT. BL MEENA Sd. -

TYPE OF PRODUCT
OR
NAME OF CUSTOMER/ PROJECTBHARAT HEAVY ELECTRICALS LTD.
HARDWARDEPT. HXE
CODE 4222SCALE
NTSWEIGHT(Kg.)
2319

REF. TO ASSY DRG.

-

DRAWING NO.

21740070003

SHEET NO. 01

NO. OF SHEETS 01

SIZE A2

6963±1

2498±1

8

7

6

5

4

3

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FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM: DG 44(B)

DRAWING NO. 2174007000

CLADDED SURFACE

TI SIDE
CLADDED SURFACE

MS SIDE

A-A

50° THE REST.

TECH. REQUIREMENTS :-

1. TI CLADDING TO BE REMOVED ON ALL SIDES COMPLETELY AS PER VIEW A-A.
2. PAINTING & PRESERVATION IS TO BE DONE AS PER HXE PRODUCT STD. NO. HE 77001.

GRADE OF UNTOL DIM:-

M/CG- V/Q/M/Y AA 0230208

WELDING-A/B/C/D-AA621104

GAS CUTTING-T3'AA0621101

REV DATE ALTERED
CHECKEDCBOM NO.
81740070001
STATUS
OF DRGTYPE OF PRODUCT
OR
NAME OF CUSTOMER/ PROJECTBHARAT HEAVY ELECTRICALS LTD.
HARDWAR

NAME	SIGN	DATE	NO OF VAR.
DRN T.BANSAL	Sd.	31.5.18	
CHD AXAY	Sd.	31.5.18	
APD N.P.	Sd.	-	

DEPT. HXE
CODE 4222SCALE
NTSWEIGHT(Kg.)
1516REF. TO ASSY. DRG.
-ITEM NO. OF
NO. OF
ITEMSTITLE
TI CLAD PLATE (10+2 THK, 2500)

DRAWING NO.	ITEM NO. OF NO. OF ITEMS
21740070001	00
SHEET NO. 01	NO. OF SHEETS 01

SIZE A2

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