



ISO 9001:2008, 14001:2004,
50001:2011 & OHSAS 18000
MAHARATNA COMPANY

MATERIAL MANAGEMENT (PURCHASE)
CENTRAL FOUNDRY FORGE PLANT, BHEL HARDWAR
RANIPUR, HARIDWAR (INDIA) – 249403
Phone No. +91-1334-281277/281299, FAX No. 225892
e-mail : vinaysingh@bhel.in; anuragkk@bhel.in

Sub: Tender Enquiry for supply of High Feed Turning Insert.

Dear Sir,

We are pleased to invite offer in **E-Tender** as per enclosed specifications & terms and conditions for the under mentioned items.

Sl. No	Tender No	Description of Material	Qty	Date & Time Of Opening
01	201903201, Event ID: 39086	FF7158000893 HIGH FEED TURNING INSERT SNMM 250724 AS PER SPEC. SPEC: FF07015 REV: 00 SIZE: AS PER SPEC, DIM.: S	1500 No	20/01/2020 at 2.00 PM

Delivery Schedule: For Indigenous vendors: 60 days from Po date.

For Foreign Vendors: 30 days from BL date.

For New Vendor who are not registered with CFFP:

New Vendor who are not registered with CFFP are required to fill the Supplier Registration Form (SRF). The SRF can be filled online through <https://supplier.bhel.in/>. Please ensure to fill the SRF and it is requested to submit the Acknowledgement No./ Application no. of filled SRF along with the offer. Kindly read terms and conditions, offer not in accordance with the instructions is liable to be disqualified or ignored.

Please send the following along with the Offer:

1. **Company Name and Address Proof.**
2. **GST Number (Scan Copy of Acknowledgement)**
3. **PAN Copy**
4. **MSME Certificate (if Any)**

All the above documents should be signed and stamped.

Please visit <https://bhel.abcpurchase.com/EPROC/>; www.bhel.com or www.bhelhwr.co.in for more details & corrigendum if any for the tender enquiry. **Offers are to be submitted online in E-tender portal at <https://bhel.abcpurchase.com/EPROC/>**

Offer to be submitted only on e-procurement portal. Hard copy of offer is not required to be submitted to CFFP. Any offers received in Hard copy shall not be accepted and straightaway rejected by CFFP. Before proceeding for submitting quotation in e-portal, supplier to ensure that they are having a valid Digital Signature Certificate (DSC). Valid DSC refers to an Active Signing and Encryption Certificate (both), with specification Class III SHA2 2048 bit

Thanking You,

Yours Faithfully,

For & On behalf of CFFP, BHEL, Hardwar

(Vinay K Singh)

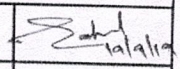
Sr. Engineer (Purchase)

Note: Corrigendum if any shall not be published, kindly refer <https://bhel.abcpurchase.com/EPROC/> for any changes.

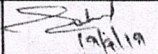
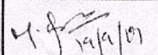
Pre- Qualifying Conditions:-

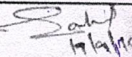
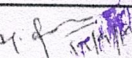
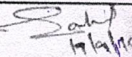
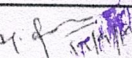
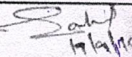
SL.NO.	REQUIREMENT TO BE COMPLIED	
1	Only those vendors to quote who are Original tool manufacturer(OEM) or authorized dealer/distributor of Original Tool manufacturer. Authorization certificate from Original Tool manufacturer to be furnished by the vendor with the offer, in case the vendor is dealer/distributor/channel partner of Original Tool manufacturer.	VENDOR TO CONFIRM AND SUBMIT NECESSARY DOCUMENTS
2	Only those vendors to quote, who or their principal OEM have supplied items similar to tender enquiry item i.e Carbide inserts in past 2 years effective from tender opening date.	Vendor to submit PO Copy/Invoice copy
3	Average annual turnover of the bidder & the party on whom PO is to be placed (in case bidder quotes for PO to be placed on other vendor) should be at least Rs. 4,00,000/- or more and it should be supported by balance sheet and profit & loss account vetted by chartered accountant or income tax return of the bidder for last three financial years & self attested last 3 years profit & loss account transaction in case of small scale industry/vendor those not coming under the boundation of audit as per government/income tax rules. If the bidder and/or the party on whom PO is to be placed; is registered in BHEL, CFFP and/or HEEP haridwar with Permanent vendor code, then vendors can also submit details of last three year POs executed to BHEL CFFP and/or HEEP haridwar with average PO values of cumulative POs of last 3 financial years at least Rs. 4,00,000/- for Qualification.	Vendor to submit supporting documents
4	Vendor should be competent w.r.t. Personnel, Equipment and manufacturing facilities to supply offered items against tender requirement.	VENDOR TO CONFIRM
5	BHEL reserves the right to verify the information provided by vendor. In case the information provided by vendor is found to be false/ incorrect, the offer shall be rejected.	VENDOR TO NOTE

संस्था के प्रतिनिधि SIGN & DATE		संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF07015 Rev 00							
				पृष्ठ Page	का 1 of 4						
समीचीन संचयन को अतिरिक्त करें	SUPERSEDES INVENTORY NO	HIGH FEED TURNING INSERT SNMM 250724									
1. GENERAL This specification governs the requirements of High feed turning Inserts SNMM 250724 for rough machining of Super critical grade Castings in Machine Shop, CFFP.											
2. APPLICATION High feed Turning Insert SNMM 250724 shall be used for Rough Machining of castings of Super critical grade having hardened surface, sand inclusion, cracks on Large 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>High feed Turning Insert SNMM 250724 for Rough Machining of castings of Super critical grade having hardened surface, sand inclusion, cracks Code:-</td> <td>Micro Engineering solution: SNMM 250724 VH N50</td> </tr> </tbody> </table>						CI	Description / Material Code	Equivalent models of Different Companies	4.1	High feed Turning Insert SNMM 250724 for Rough Machining of castings of Super critical grade having hardened surface, sand inclusion, cracks Code:-	Micro Engineering solution: SNMM 250724 VH N50
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इस प्रलेख में दी गयी सूचना भारत हेतु इलेक्ट्रिकल कोड की प्रतीति है। इसका प्रयोग एवं अप्रयोग रूप में किसी भी तरह प्रयोग, जो की कंपनी के हित में नहीं है, न किया जाये											
संस्था के प्रतिनिधि SIGN & DATE	RMS PLANNING RMS PROD Chairman PSC	VIKALP BIBHUTI R.R.BAUNTHIYAL GM VARMA	अनुवादक TRANSLATED BY निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY अनुमोदित APPROVED BY	R.K.KHANDELWAL MOHD. ASAD R.K.SINGH	19/09/19						
समीचीन संचयन INVENTORY NO	सहमत विभाग Agreed Deptt	नाम Name	दिनांक एवं हस्ताक्षर Date and Signature	स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE							
			निर्माण PREPARED : RMS TOOLING	जारी: फाउंड्री प्रौद्योगिकी ISSUED : RMS TOOLING	दिनांक DATE 19.09.19						

BHEL भारतीय विद्युत निर्माता संस्थान	संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF07015 Rev 00 पृष्ठ का Page 2 of 4																																																																
	SIGN & DATE																																																																		
SUPPLIERS INVENTORY NO.	5. PERFORMANCE TEST																																																																		
समायोजित संख्या को अभिलेखित करें	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 to submit his offered insert sample for trial purpose for assessment of technical suitability. 5.2.3 Representative of vendor may be present during the trial on intimation by BHEL. 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:- 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 rowspan="3">Wt. (%)</td> <td>0.6-</td> <td>9.2-</td> <td>0.18-</td> <td>0.8-</td> <td>0.9-</td> <td>1.0</td> <td>0.4</td> <td>0.11-</td> <td>0.2-</td> <td>0.05-</td> <td>0.9</td> <td>0.0</td> </tr> <tr> <td>0.8</td> <td>10.2</td> <td>0.25</td> <td>1.2</td> <td>1.05</td> <td>Max</td> <td>Max</td> <td>1.14</td> <td>0.4</td> <td>0.08</td> <td>5-</td> <td>4-</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>1.0</td> <td>0.0</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>5</td> <td>6</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-	9.2-	0.18-	0.8-	0.9-	1.0	0.4	0.11-	0.2-	0.05-	0.9	0.0	0.8	10.2	0.25	1.2	1.05	Max	Max	1.14	0.4	0.08	5-	4-											1.0	0.0												5	6
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दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनीर्देश (सी एफ एफ पी)		FF07015 Rev 00	
SUPERSEDES INVENTORY NO	PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का	Page 3 of 4	
सामग्री सूचित सख्या की अतिरिक्ति कर्ता	5.2.5 Operational Parameters:- Depth of Cut 10-12 mm , Cutting Speed-8-20 Mtr/min, Cutting Feed – 2.1-2.6 mm/min (Note:- Vendor may select cutting speed from the specified range as per their own judgement at the time of trial without compromising from Depth of cut, feed and insert life specified under clause No. 5.2.5 & 5.2.6)				
COPYRIGHT AND CONFIDENTIAL 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	5.2.6 Following operating result needs to be obtained during shop trial for technical suitability:				
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दिनांक एवं हस्ताक्षर SIGN & DATE	6. MISCELLANEOUS				
सामग्री सूचित सख्या (Inventory No)	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 .				
	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.				
	निर्माणकर्ता WORKED BY	R.K.KHANDELWAL			
	जांचकर्ता CHECKED BY	MOHD. ASAD			

दिनांक व समय SIGN & DATE		संस्थान क्रय विनीर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF07015 Rev 00 पृष्ठ का Page 4 of 4							
सामग्री सूची संख्या INVENTORY NO	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. 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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