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MPR:20140518 Dated 16/09/2014

PRE QUALIFYING CONDITIONS		REQUIRED	OFFERED	DEVIATION	REMARKS
01.00	PRE QUALIFYING CONDITIONS				
01.01	a) Only OEM vendors who are manufacturing and supplying Indexable Shell Type Milling Cutter bodies of 90 degree approach angle with carbide inserts for finish machining and such items are presently working satisfactorily should quote. b) The following information should be submitted by the vendor about the companies where such carbide inserts & cutter bodies have been supplied during past three years (from Enquiry issue date). This is required from all the vendors for qualification of their offer.	Vendor to accept/agree			
01.02	Name of the customer / company where referred item was supplied.	Vendor to submit details			
01.03	Complete postal address of the customer.	Vendor to submit details			
01.04	Month & Year of previous supply of referred item.	Vendor to submit details			
01.05	Name, designation and contact details (phone number, fax number and email address) of contact person of the customer to whom referred item was supplied.	Vendor to submit details			
01.06	BHEL reserves the right to verify the information provided by vendor. In case the information provided by vendor is found to be false/ incorrect, their offers are liable to be rejected.	Vendor to accept/agree			
02.00	TECHNICAL ACCEPTANCE CRITERIA				
02.01	All qualified vendors shall bring 20 nos of carbide inserts & Two suitable cutter body (Dia 80 mm, coupling bore dia 27mm) same as offered in quotation as sample on free of cost on returnable basis within a month from confirmation for submission of sample tools from BHEL.	Vendor to agree/submit			
2.01.01	Indexable Cutter quoted by vendor should have (a) outer dia 80 mm with 90 degree approach angle (b) coupling bore size 27 mm (c) Screw type clamping of inserts on cutter body.	Vendor to accept/agree			
2.01.02	Inserts & cutters submitted by all qualified vendors shall be tried on existing CNC Kopp machine as per Input Material, Cutting parameter (criteria 02.03) & Successful performance (criteria 02.04) mentioned below in presence of vendor's representative.	Vendor to accept/agree			
02.02	Offers of only those vendors shall be considered as technically acceptable whose tools submitted as sample run successfully as per performance criteria mentioned in clause 02.04 during trial as per 2.01.02	Vendor to accept/agree			
02.02.01	There shall not be any liability on BHEL for failed trial. Price bid shall be opened only for vendors whose samples have been successfully tried as per specified criteria. Subsequently, ordering shall be done on L-1 vendor as per BHEL purchase policy & practice.	Vendor to accept/agree			
02.02.02	After trial sample of tools submitted in technical bid can be taken back by vendor. Sample of tools after its use during trial may or may not be in good condition. Vendor must be ready to take the sample in damage consumed condition. For this, vendor must express his intention explicitly to take sample tool back in technical bid itself.	Vendor to confirm			

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02.03	Input Material & Cutting Parameter: (a) Feed- 300 to 400 mm/min (b) RPM- 600(Maximum Avl RPM =600) (c) DOC- 0.08 mm -0.1 mm (d) Material Grade (X20Cr13) Hot rolled material (material property details as per Annexure III) (e) Blade Type- TX Blade (TX 45-51)-LM11L/IR-36K design. (f) Input Job Shape - Fig-B Annexure -II which was obtained by machining of rectangular cross section of 82X46X448 (mm)-(width x height x length) Refer the Annexure -I	Vendor to accept/agree				
02.04	Performance Criteria: (a) Operation : Finishing operation on arrow headed four faces of rhomboidal cross sectional straight bar as shown in Annexure-I (Fig-C) by duplex horizontal milling throughout the length of the bar using BHEL, provided Programme on EMAG KOPP make machine. For Drawing No: 21030636001 or 21030636003 b) Surface Finish- Machined job obtained after trial should be 1.6 micron or less than 1.6 micron. c) Life of Inserts - Finishing of atleast 140 to 150 nos of blade with one set of inserts applicable in a cutter body using all available cutting edges of inserts. d) There should not be any chattering marks or line marks on the surface after machining. e) Rhomboid & Thickness sizes throughout the length of bar should be within tolerance.	Vendor to accept/agree				
03.00	OEM (M/s Seco) vendor shall be exempted from Technical acceptance criteria (02.00) because Tools of M/s Seco are tested, proven & successfully running on machine since last 12 years at cutting parameter specified at 2.03 & performance specified at 2.04.					
04.00	All the technically accepted vendors as per sl no 2.0 if not already registered with HEEP, BHEL, Hardwar shall be required to submit Supplier Registration Form (SRF) for their registration.	Vendor to agree/submit				

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