

MACHINING OF IPI CASING (LH)

i) PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Only those vendors should quote who have past experience of machining of similar jobs having max. height ≥ 1600 mm and weight ≥ 8 MT to the full satisfaction of the customer. (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. ≥ 2300 mm, height ≥ 2570 mm and weight ≥ 12.5 MT	Vendor to Confirm and submit detail
3	Vendor should have a Horizontal boring machine of Spindle Dia ≥ 100 mm	Vendor to Confirm and submit detail
4	Vendor should have material handling capacity ≥ 12.5 MT	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-106-02-01901/M:Rev-00	Vendor to confirm
2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining to assess the progress and technical aspects and further processing shall be done accordingly.	Vendor to confirm
4	Final Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
5	Delivery requirement: 7 weeks/pc from the date of lifting	Vendor to confirm
6	Identification details on the casting to be maintained	Vendor to confirm
7	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
8	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
9	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept
10	Job shall be offered to vendor with parting plane machined. Therefore, parting plane machining is not required from vendor.	Vendor to Note

 Vikalp Bihuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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MACHINING OF IPL CASING (UH)iii) **PRE QUALIFICATION REQUIREMENT**

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1	Only those vendors should quote who have past experience of machining of similar jobs having max. height ≥ 1600 mm and weight ≥ 8 MT to the full satisfaction of the customer. (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. ≥ 2300 mm, height ≥ 2570 mm and weight ≥ 12.5 MT	Vendor to Confirm and submit detail
3	Vendor should have a Horizontal boring machine of Spindle Dia ≥ 100 mm	Vendor to Confirm and submit detail
4	Vendor should have material handling capacity ≥ 12.5 MT	Vendor to Confirm and submit detail

iv) **TECHNICAL REQUIREMENT**

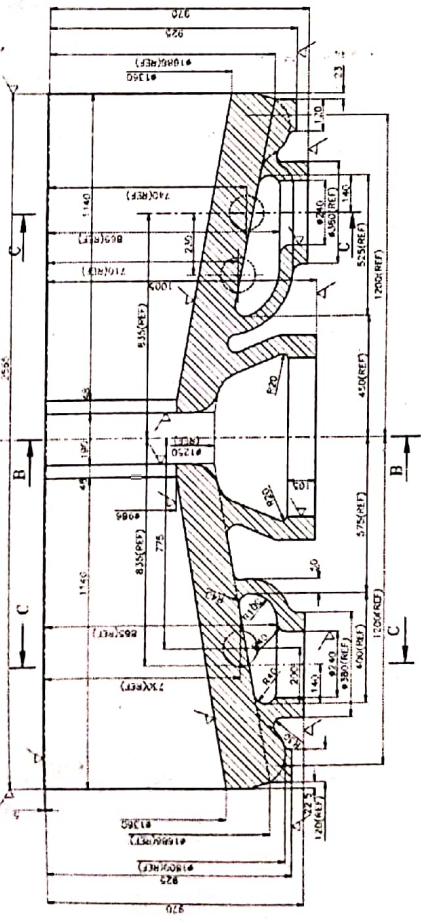
S.No.	BHEL Requirement	Vendor's Confirmation
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2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining to assess the progress and technical aspects and further processing shall be done accordingly.	Vendor to confirm
4	Final Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
5	Delivery requirement: 7 weeks/pc from the date of lifting	Vendor to confirm
6	Identification details on the casting to be maintained	Vendor to confirm
7	Vendor to submit following with the offer:- c) Details of the Organization d) Details of the machine tools and other facilities installed in the company	Vendor to submit
8	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
9	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept
10	Job shall be offered to vendor with parting plane machined. Therefore, parting plane machining is not required from vendor.	Vendor to Note

Vikalp Bishuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
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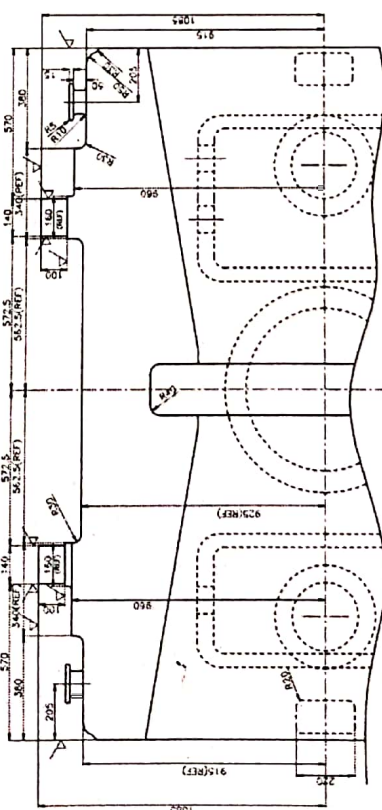
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

REV. 02/10 2010-01-01
ISSUING OFFICER

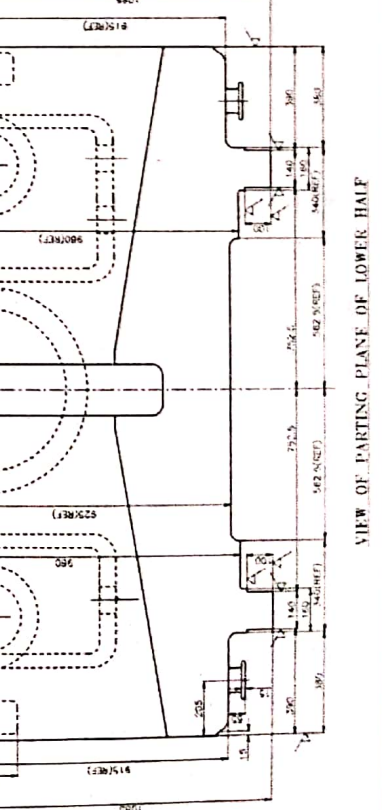
SECTION A-A



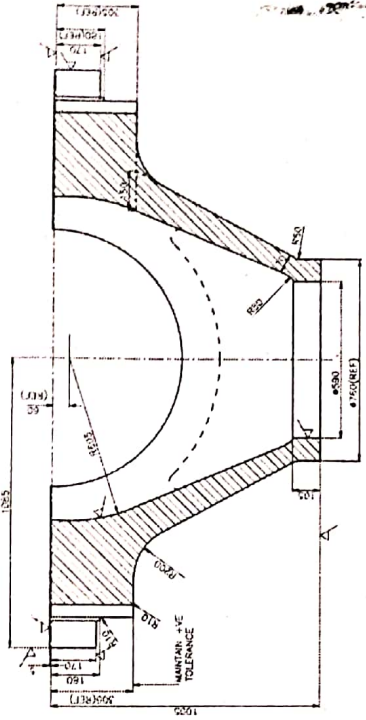
VIEW OF PARTING PLANE OF UPPER HALF



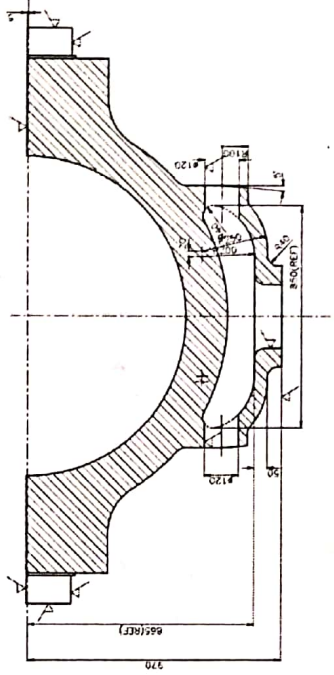
VIEW OF PARTING PLANE OF LOWER HALF



SECTION B-B



SECTION C-C



NOTE

1. CASTING TO BE BRUSH MACHINED TO FINISH DIMENSIONS ON ALL THE SURFACES MARKED ✓ TO THE SURFACE.
2. ALL DIMENSIONS ARE TO THE UNLESS OTHERWISE STATED.
3. DIMENSIONS IN PARENTHESIS ARE TO BE MAINTAINED.
4. DIMENSIONS IN SQUARE BRACKETS ARE TO BE MAINTAINED.
5. DIMENSIONS IN CIRCLES ARE TO BE MAINTAINED.
6. DIMENSIONS IN TRIANGLES ARE TO BE MAINTAINED.
7. DIMENSIONS IN DIAMOND SHAPES ARE TO BE MAINTAINED.
8. DIMENSIONS IN OVALS ARE TO BE MAINTAINED.
9. DIMENSIONS IN HEXAGONS ARE TO BE MAINTAINED.
10. DIMENSIONS IN OCTAGONS ARE TO BE MAINTAINED.
11. DIMENSIONS IN STAR SHAPES ARE TO BE MAINTAINED.
12. DIMENSIONS IN OTHER SHAPES ARE TO BE MAINTAINED.

BHARAT HEAVY ELECTRICALS, LTD.
CENTRAL FOUNDRY FORGE PLANT
RAIPUR, BIHAR

ROUGH MACHINING DRG.
OF INNER CASING (U/H/LH)

DATE: 09/06/02
SCALE: 1:1
JOB NO: 100004
REV: 01
REV: 02
REV: 03
REV: 04
REV: 05
REV: 06
REV: 07
REV: 08
REV: 09
REV: 10

DESIGNED BY: [Signature]
CHECKED BY: [Signature]
APPROVED BY: [Signature]