



BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL VALVES PLANT
433, INDUSTRIAL COMPLEX
GOINDWAL SAHIB
DISTT. TARN TARAN- PUNJAB – 143422

No.BHEL:IVP:
SC: Wall
Blower : AD
2021-22/01
Dated
25.05.2021

NOTICE INVITING APPLICATIONS FOR REGISTRATION OF SUB CONTRACTORS

BHARAT HEAVY ELECTRICALS LIMITED [BHEL] is manufacturing Industrial Valves and other Boiler accessories at its Industrial Valves Plant, Goindwal Sahib unit. Approx annual procurement value for Wall Blower items for the year FY2021-22 – Rs 30 lac.

Expression of interest and applications for registration are invited from sub-contractors (BHEL encourages procurement from Micro and Small Enterprises (MSEs), MSEs are requested to apply for registration) for doing the machining job of various components of Wall Blowers. Major areas for which subcontractors are required are gear/worm machining, press/die. Various work centers involved in the machining job shall be CNC, VMC etc.

Machining of Items for which vendors required immediately are:

Wall Blowers

Machining vendors are required to machine various components of wall blower such as Rack, Spur Gear, Worm, Primary Shaft, Secondary Shaft, Rack Cover etc. Also heat treatment, cadmium plating, wherever required to be arranged by the vendor. List of components, where machining vendors are required, is attached herewith as Annexure-I. Sample drawings of some components are also attached. (S.No of the list - 63 and 69)

BHEL is looking for prospective Sub Contractors for above detailed job work for BHEL.

BHEL shall evaluate the vendors as per its established vendor selection, evaluation and registration procedure. Supplier registration can be done online <https://supplier.bhel.in/>

BHEL invites such vendors to visit its above located plant on any working day from Monday to Saturday between 0900 Hrs to 1730 Hrs and contact undersigned for any clarification regarding:

Items details and requirement		Vendor registration form/procedure
Vineet Kumar Manager (Sub Contracting)	Mukesh Kumar Dy.Manager (Sub Contracting)	Sahil Malhotra Dy.Manager (Sub-Contracting)
Phone: 01859-224625	01859-224644	01859-224669
Mobile: 099150 47504	081465 52387	098142 09180
E-mail: vineet.k@bhel.in	kumarmukesh@bhel.in	sahil@bhel.in

BHARAT HEAVY ELECTRICALS LIMITED INDUSTRIAL VALVES
PLANT, 433, INDUSTRIAL COMPLEX, GOINDWAL SAHIB,
DISTT. TARN TARAN, PUNJAB – 143 422

Wall Blower Items

List of Items

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)
1	G2168	VALVE BODY-10001001	Wall Blower
2	G2168a	3" VALVE BODY	Wall Blower
3	G2195	SWIVEL TUBE D60.3X4.8-30069900 (Chrome plating length - 1088mm Total length - 1218mm)	Wall Blower
4	G2195a	EXT. SWIVEL TUBE D60.3X4.8 (Chrome plating length - 1388 mm to 1575 mm) Total length - 1518 to 1705 mm)	Wall Blower
5	G2195b	EXT. SWIVEL TUBE D60.3X4.8- 30212301 (Chrome plating length - 2088 mm Total length - 2218 mm)	Wall Blower
6	G2503	Swivel tube from SS	Wall Blower
7	G2169	WALL DESLAR.BODY-10016202	Wall Blower
8	G2171	CLEVIS BRACKET-20006200	Wall Blower
9	G2172	LEVER-20006300	Wall Blower
10	G2173	GLAND FOLLOWER-30014502	Wall Blower
11	G2175	VALVE STEM-30141200	Wall Blower
12	G2178	VALVE STEM CAP-40019800	Wall Blower
13	G2183	RAMP CAM-30013700	Wall Blower
14	G2185	CAM SHAFT COLLAR-30014700	Wall Blower
15	G2186	WORM SHAFT-30015100	Wall Blower
16	G2187	SPUR GEAR SHAFT-30015300	Wall Blower
17	G2188	SECONDARY SHAFT-30015400	Wall Blower
18	G2189	WORM GEAR SHAFT-30015500	Wall Blower
19	G2190	ROLLER SHAFT-40025700	Wall Blower
20	G2191	PRIMARY SHAFT-40025800	Wall Blower
21	G2192	CAM SHAFT-40024700	Wall Blower
22	G2193	SPINDLE SLEEVE-30015200	Wall Blower
23	G2196	SWIVEL TUBE SHAFT-40023700	Wall Blower
24	G2209	NOZZLE HEAD-40016200	Wall Blower
25	G2210	NOZZLE-40016300	Wall Blower
26	G2211	LOCK NUT M20X1.5-40016600	Wall Blower
27	G2212	NIPPLE M20X1.5-40016700	Wall Blower
28	G2216	MOTOR SPACER-40018100	Wall Blower
29	G2217	ARM BRACKET-40018200	Wall Blower
30	G2224	GUIDE ROD-40019500	Wall Blower
31	G2225	PACKING GLAND-40019600	Wall Blower
32	G2226	GLAND BUSH D32X45-40019700	Wall Blower
33	G2227	PLUG 3/8INCH NPT-40019900	Wall Blower
34	G2228	AIR VENT (R1/4")	Wall Blower

Wall Blower Items

List of Items

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)
35	G2229	CLEVIS PIN-40023300	Wall Blower
36	G2230	PIN-40023500	Wall Blower
37	G2231	PIN-40162300	Wall Blower
38	G2232	LOCK PIN-40021200	Wall Blower
39	G2239	SPACER-40025403 style 3	Wall Blower
40	G2240	SPACER-40025404 style 4	Wall Blower
41	G2241	SPACER-40025401 style 1	Wall Blower
42	G2242	SPACER-40025402 style 2	Wall Blower
43	G2243	GEAR SPACER-40026000	Wall Blower
44	G2244	WORM SPACER-40025500	Wall Blower
45	G2245	UPPER ROLLER-40025600	Wall Blower
46	G2246	SEAT INSERT-40056500	Wall Blower
47	G2248	SIN BRZ BUSH-40154800	Wall Blower
48	G2249	RACK GEAR HOUSING + GUIDE ROD FIXING	Wall Blower
49	G2334	MOUNTING ADAPTER-20003000	Wall Blower
50	G2335	SUPPORT PLATE-40015000	Wall Blower
51	G2336	GUSSET PLATE-40015100	Wall Blower
52	G2338	SLEEVE TUBE	Wall Blower
53	G2344	BASE PLATE-40159600	Wall Blower
54	G2495	NIPPLE 1 1/2" NPT / NIPPLE G 1 1/2"	Wall Blower
55	G2499	T-PIECE 3/8IN NPT-40065500	Wall Blower
56	G2618	SWIVEL TUBE SUPPORT-40261000	Wall Blower
57	G2336a	GUSSET PLATE-40402200	SLEEVE ASSEMBLY
58	G2498	SLEEVE TUBE W/O NIPPLE	Wall Blower
59	G2179	WORM-30011901	Wall Blower
60	G2180	WORM-30011903	Wall Blower
61	G2181	WORM L.H-30011902	Wall Blower
62	G2182	ELEMENT GEAR-30012200	Wall Blower
63	G2184	RACK-30013800	Wall Blower
64	G2184a	RACK SQ MILL-30013800	Wall Blower
65	G2194	RACK PINION-30015600	Wall Blower
66	G2197	SPUR GEAR 12T-30074000	Wall Blower
67	G2198	MOTOR PINION 30T-40023200	Wall Blower
68	G2199	GEAR 40T-40024600	Wall Blower
69	G2200	SPUR GEAR-40025200	Wall Blower
70	G2201	PINION-40025900	Wall Blower
71	G2202	PRIMARY GEAR-40026200	Wall Blower
72	G2218	WORM GEAR 30T-40018300	Wall Blower
73	G2219	WORM GEAR-40018400	Wall Blower
74	G2220	WORM GEAR LH-40018500	Wall Blower
75	G2204	GLAND PLATE-40011900	Wall Blower
76	G2205	COVER-40012500	Wall Blower

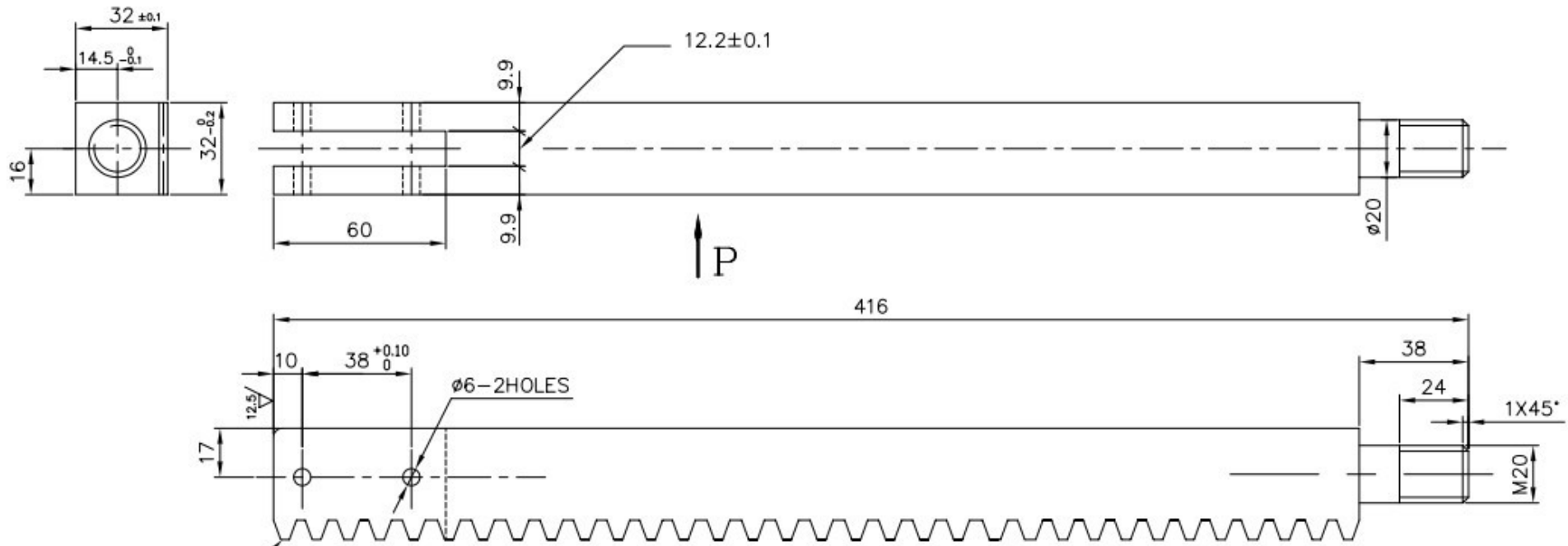
**Wall Blower Items
List of Items**

Annexure - I

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)
77	G2206	COVER PLATE-40012400	Wall Blower
78	G2207	COVER PLATE-40154700	Wall Blower
79	G2208	SHAFT COLLAR-40026100	Wall Blower
80	G2213	CAM ASSY-30013400	Wall Blower
81	G2221	CUPPED PLUG-40019201	Wall Blower
82	G2222	CUPPED PLUG-40019202	Wall Blower
83	G2223	SPRING RETAINER-40019300	Wall Blower
84	G2233	SCRU GRB SOC AP10-40024200	Wall Blower
85	G2234	SWITCH MOUNT BRT-40024500	Wall Blower
86	G2235	THRUST WASHER-40025000	Wall Blower
87	G2236	THRUST WASHER-40025100	Wall Blower
88	G2237	RETAINING WASHER-40023900	Wall Blower
89	G2238	FLAT WASHER-40013000	Wall Blower
90	G2247	CAM-40079700	Wall Blower
91	G2331	RACK COVER W/O PAINT-20024300	Wall Blower
92	G2332	EMERGENCY CRANK-30013600	Wall Blower
93	G2337	ALIGNMENT PLATE-40015200	Wall Blower
94	G2333	COMPANION FLANGE-40028501	Wall Blower
95	G2493	Orifice Plate	Wall Blower
96	G2339	VALVE BODY D40X60-40142200	Air Valve
97	G2340	VALVE BODY COVER-40142300	Air Valve
98	G2341	VALVE DISC & STEM-40022200	Air Valve
99	G2512	CONNECTOR 3/8INC-40051902	Air Valve
100	G2343	PIN-40159700	Wall Blower
101	G2592	MOTOR ADAPTER-30116100	Wall Blower
102	G2443	SPECIAL KEY-40114100	

DRAWING NO. 3-20-201-00138

6.3/ (12.5/)



FULL TOOTH PROFILE
TO BE MAINTAINED
AT THIS END.

VIEW-P

PART NUMBER : 842020116100

NOTES: -

- FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

MODULE	3
PRESSURE ANGLE	20°
WHOLE DEPTH	6.75

REV	DATE	ALTERED	K.S.
11	26.06.06	CHD & APPD	S.N.
DRG. UPDATED AND REDRAWN.			
DCN: 800547 Dt.02.01.06			

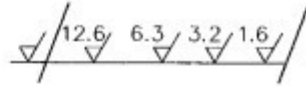
01		ROUND Ø50MM	15 339 142	SA 105			3.680		01	
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No	
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										
365-121		BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.			DRN	S.NAPPI	SIGN	S.N.	DATE	NO.OF VAR.
330		SCALE NTS			DEPT	VL	WEIGHT (KG).	3.680	REFERENCE INFORMATION	NO. OF TIME
U 01		TITLE RACK			APPD	S.NATARAJAN	S.N.	26.06.06	DRAWING NO.	REV
					CHD	K.SRIDHARAN	K.S.	26.06.06	3-20-201-00138	11

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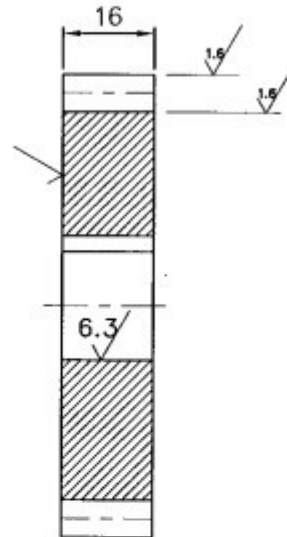
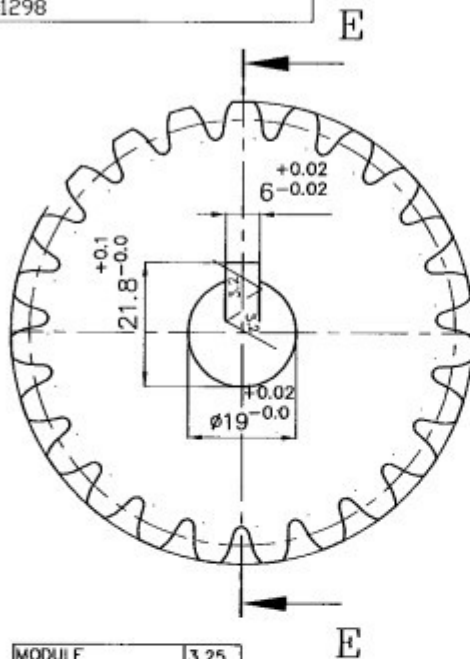
ALL DIMENSIONS ARE IN MILLIMETRES.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP/QP

REV	DATE	ALTERED
04	11.06.01	CHD & APPD
DRG. UPDATED AND REDRAWN.		
DCN:SB:1298		



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SECTION EE

MODULE	3.25
NO OF TEETH	23
PITCH DIAMETER	74.75
PRESSURE ANGLE	20°
WHOLE DEPTH OF TEETH	7.31
OUTSIDE DIMETER	81.25
TOOTH CLEARANCE	0.813
CETRE DISTACE	102.38

TOLERANCE ON GEAR BLANK
TIP DIAMETER 81.25 -0.00
RADIAL AND AXIAL RUN OUT OF REFERENCE SURFACES = 0.0170
TOLERANCE OF GEAR:
TEETH RUN OUT = 0.063
TIR W.R.T.BORG
WIDTH ACROSS THREE TEETH = 25.03 -0.08
ALL OTHER TOLERANCE ARE TO BE AS PER APPLICABLE QP/QCP

NOTES:-

- FOR QUALITY REQUIREMENTS REFER APPLICABLE LATEST QUALITY PROCEDURE.

PART CODE : 842020114500

01	FORGING D 100X20	920377780000	IS 1875 CL IV			1.250			01
NO OFF	DESCRIPTION	MATL CODE	MATL SPECM	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
 365-122	BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI 620014.	DRN	V.ARUMUGAM	SIGN	DATE	NO. OF VAR			
		CHD	K.SRIDHARAN						
		APPD	S.NATARAJAN						
DEPT SB		SCALE	NTS	WEIGHT (KG).	1.250	REFERENCE INFORMATION		NO. OF ITEMS	
CODE						T-13566			
TITLE	SPUR GEAR			CARD CODE	U 01	DRAWING NO.	4-20-201-00252	REV	04