



भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
Bharat Heavy Electricals Limited, Bhopal

FEEDERS MAINTENANCE DIVISION

TGM MAINT. DEPARTMENT

Phone -: 0755-2505237, 3743, 2621

Email -: vedprakash@bhel.in



Scope of Work

Tender Enquiry No. FDX/TGM/19-20/PM/06

Dtd. : 18.02.2020

Due Date: 09.03.2020 Time: 2:00 PM

Sub:- Preventive maintenance & servicing under annual maintenance contract for AGIE EDM wire cut CNC machine model 220CE serial no. 174, BHEL item no. 14/A/2067 in TGM Division.

Basis check.

- Check ambient conditions.
- Temperature
- Vibrations
- Compressor air piping.
- Power supply.

Machine.

- Check the belt guide rollers.
- Check the U / V coordinate head and the cooling/ Lubrication.
- Cleaning the brake of the upper head and the status check.
- Check the wire chopper.
- Status checks the remote control.
- Check the rinsing performance. (Replacement of worn pipes and connections.)
- Check the lubrication of the sliding surfaces as well as the spindles and stops of axes X / Y / Z.
- Check the table seal.
- Function checks the main switch.
- General maintenance.
- Check the upper and lower are alignment.
- Check the electrode cables.

CNC Control Cabinet

- Inspection of the ventilators.
- Removal of dust.

- Check the indicator / led status.
- Cleaning the cooling ribs of the control unit.
- Checking / replacement of battery BT1 and BT2.
- Checking the memory battery / replacement.

Generators cabinet.

- Inspection of the ventilators.
- Removal of dust.
- Check the indicator / led status.
- Cleaning electronic pcbs if essential.

Dielectric unit

- Change the water and cleaning of the dielectric unit. (Waste water drainage connection required).
- Check the performance of all pumps.
- Replacement of sound absorbers of the Pneumatic slide valves.
- Replacement of the filter.
- Cleaning of the conductivity probe.
- Cleaning of the compressed air filter and check of the compressor air treatment.
- Level probe / sensors check.
- Cleaning / checking of the heat exchanger.

Final check

Accuracy checks for all axes.

Corrections in Telescopic arm.

Function checks – job sensing, Wire alignment, Dry run and Test cut erosion with full cut and follow up cuts. Conic cut.

Ved Prakash Meena
Dy. Mgr. (FDX)