

BHARAT HEAVY ELECTRICALS LIMITED  
RAMACHANDRAPURAM:: HYDERABAD-502032

PUMPS ENGINEERING DEPT.

TECHINCAL PRE-QUALIFICATION REQUIREMENTS

ACCEPTANCE CRITERIA

Item: Procurement of CWP Suction bell mouth patterns

- a) Vendor has to send his methodology and the machining allowance added on the casting surface for approval by Technology/F&P before starting the layout.
- b) In process inspection at layout finalization: on intimation by the supplier.
- c) BHEL has the right to short close the PO (without any financial obligation by BHEL), in case the BHEL inspectors during in process inspection find that the vendor is in capable of making the pattern as per requirement.
- d) Final Inspection: Once the pattern is ready in all aspects, then BHEL will do the final inspection at vendor works on intimation by supplier.
- e) All the patterns to be manufactured to suit the dimensional requirement of the casting drawing given by BHEL.
- f) Pattern equipment shall be offered for inspection with wood primer coat and only after the final approval by BHEL quality control, painting shall be done with Nitro Cellulose (NC). Color coding will be as per OMI-13.
- g) Manufacturer shall provide all the necessary facilities to carry out inspection and vendor shall cooperate with BHEL inspector to complete the inspection activity with all concern man power/employee.
- h) TIF- 714/Rev 03 and TIF-715/Rev 01 shall be followed for other details of pattern manufacturing.
- i) Necessary templates, inspection instruments and profile gauges are to be made available for inspection.
- j) All templates gauges and layout shall be preserved by vendor and shall be supplied along with the pattern.
- k) For drawing clarification (if any), contact BHEL, Foundry Technology department.

  
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