

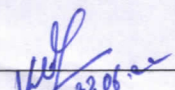
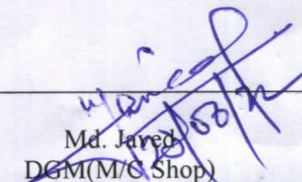
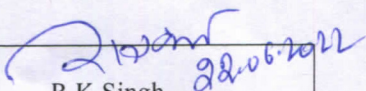
PARTING PLANE MACHINING OF IPI CASING (UH)

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 ≥ 2500 mm and weight ≥ 20 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 to provide specification of the suitable machine on which machining is planned	Vendor to submit detail
3	Vendor should have material handling capacity ≥ 31 MT	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

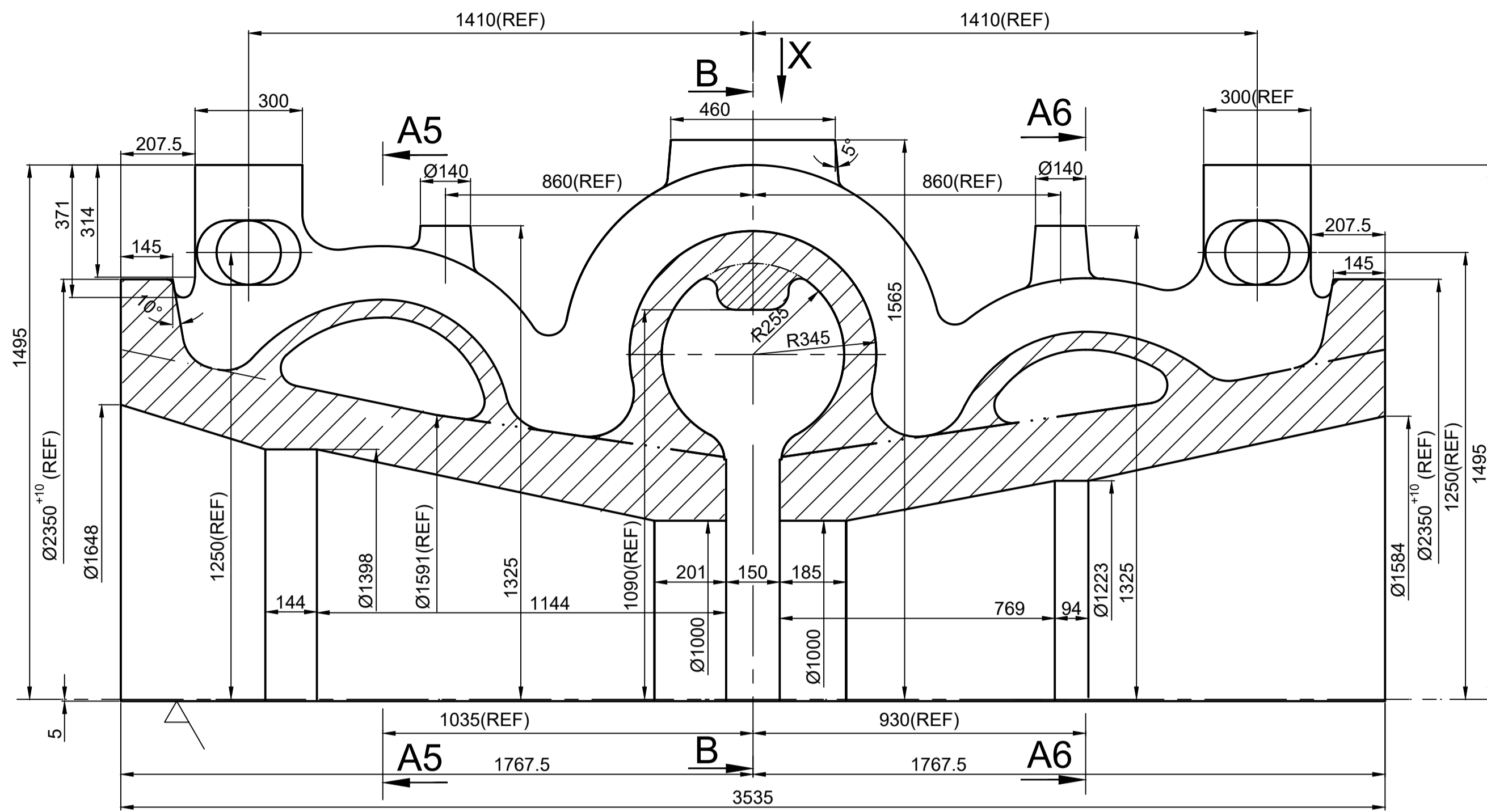
S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-106-02-56901/M4:Rev-A	Vendor to confirm
2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining 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: 4 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 to submit Filled Supplier Registration Form along with Requisite Documents to SDC Cell in MM Deptt. of CFFP, BHEL, Haridwar. If already registered at CFFP or any other unit of BHEL, then Vendor code may be furnished.	Vendor to submit
9	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
10	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept
11	Job shall be offered to vendor with parting plane machined. Therefore, parting plane machining is not required from vendor.	Vendor to Note

 Vikalp Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM(M/C Shop)	 R.K.Singh AGM (M/C Shop)
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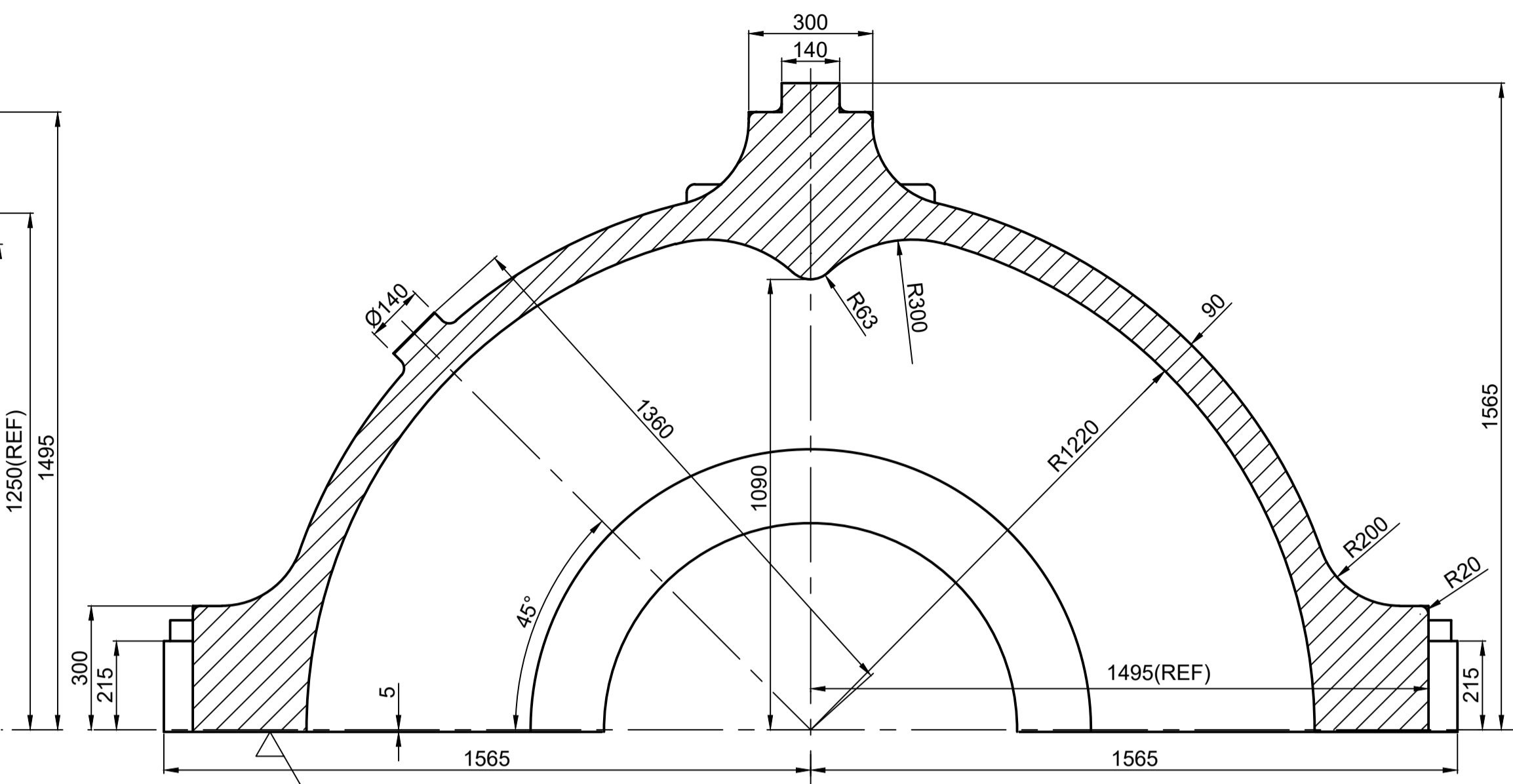
Indent No. : 20220070

DRAWING NUMBER
0-106-02-56901/M4

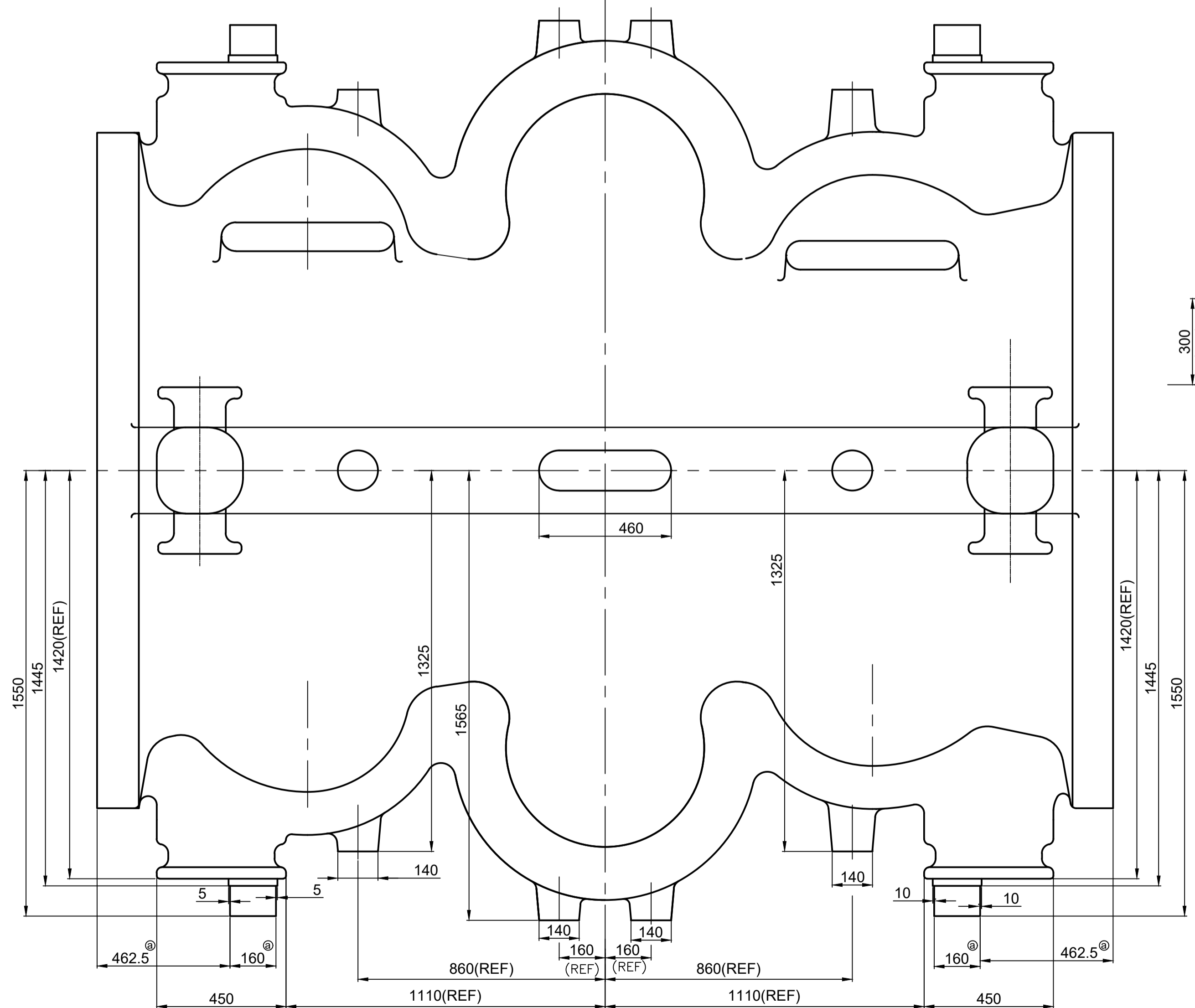
SECTION A-A



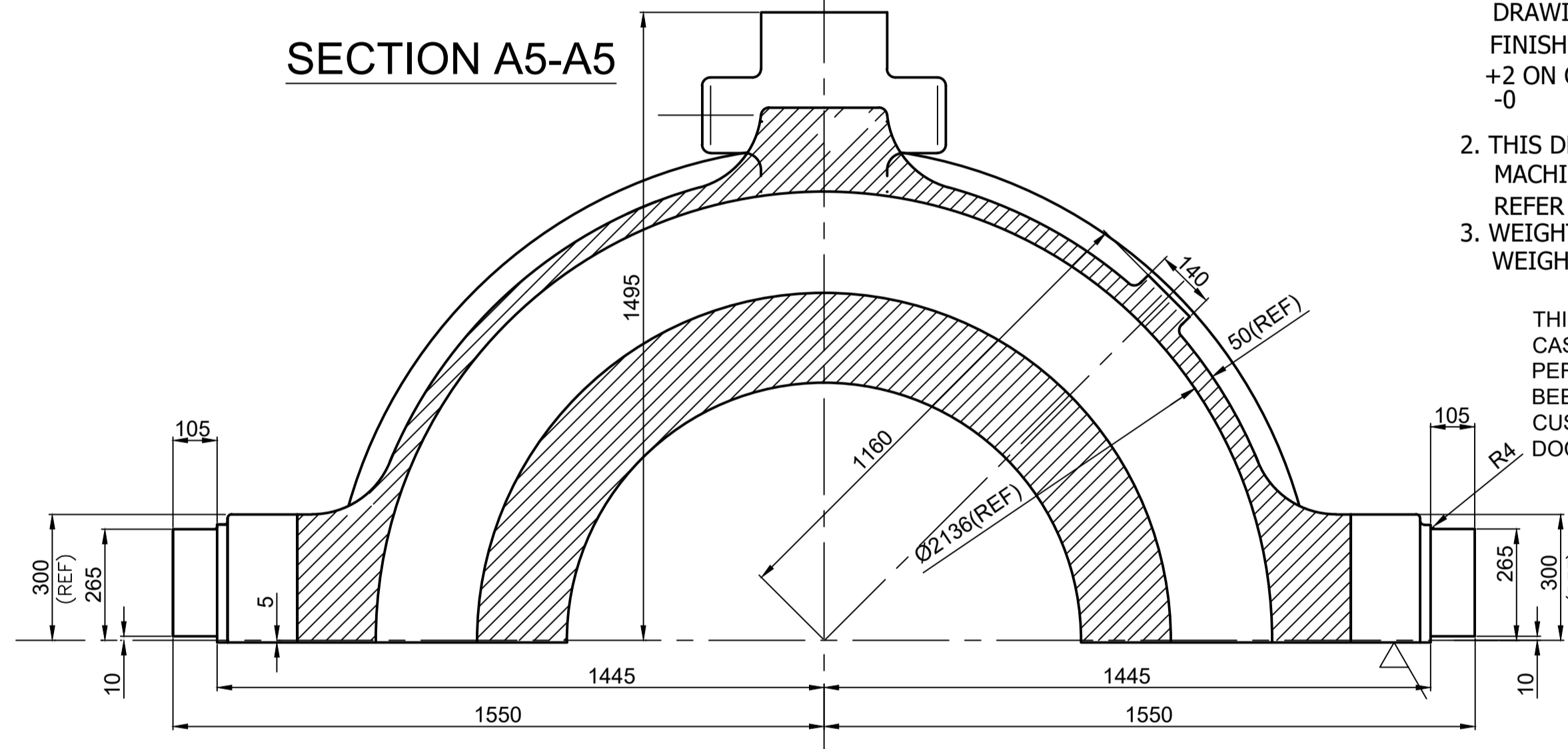
SECTION B-B



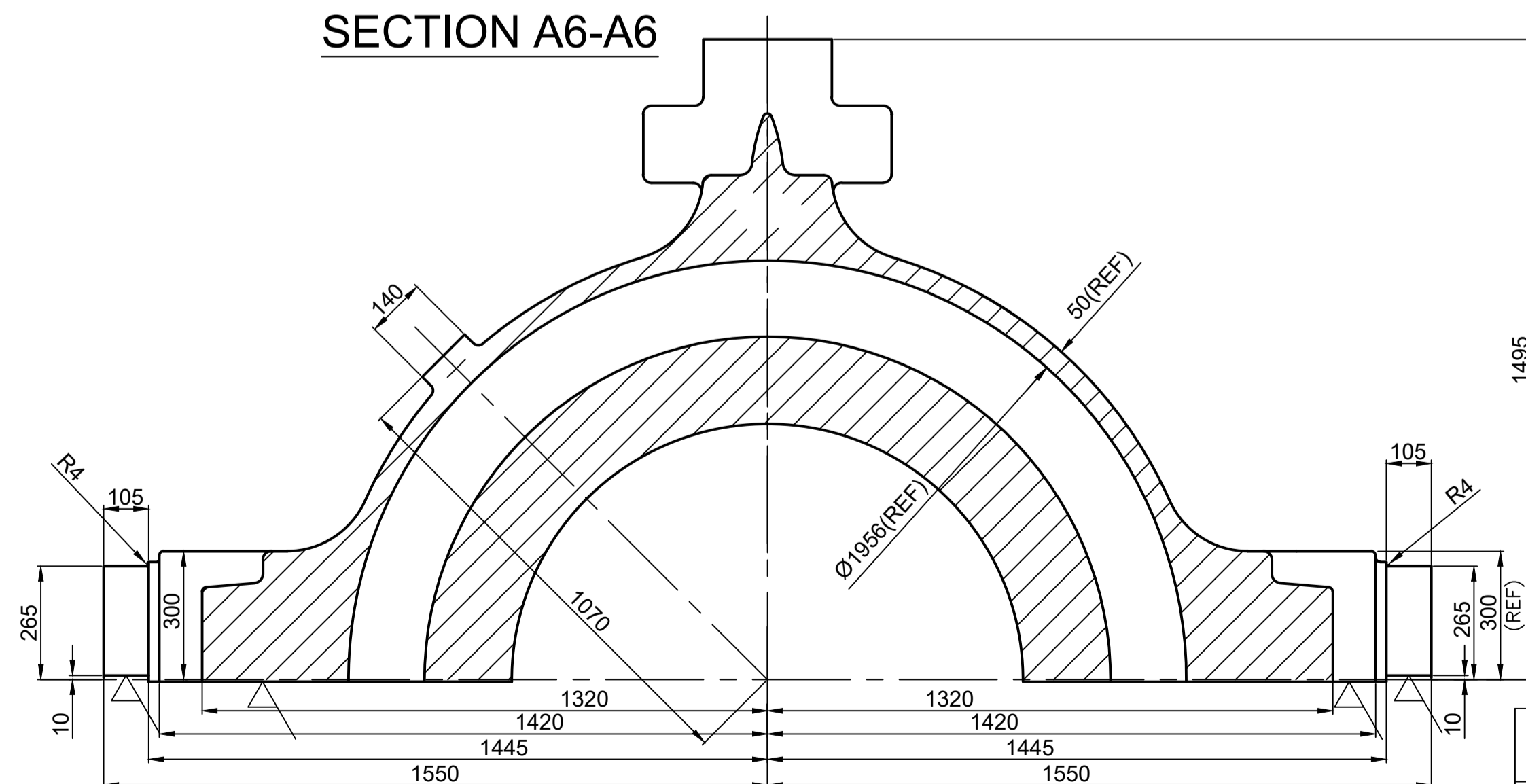
VIEW-X



SECTION A5-A5



SECTION A6-A6



NOTE:

1. CASTING TO BE ROUGH MACHINED ALL OVER TO DRAWING DIMENSIONS TO THE SURFACE FINISH OF 12.5 MICRONS AND TO THE TOLERANCE OF +2 ON OD AND HT, -2 ON ID, UNLESS OTHERWISE STATED
-0 +0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-106-02-56901 REV.- 01
3. WEIGHT OF CASTING BEFORE MACHINING: 31000 Kgs.
WEIGHT OF CASTING AFTER MACHINING: 30350 Kgs.

THIS DRAWING IS ISSUED FOR MACHINING OF IP INNER CASING FOR MAITREE, KURJA & SAGARDIGI PROJECT AS PER RESPECTIVE PO. THE INTERNAL DIAMETERS HAVE BEEN MODIFIED IN LINE WITH REQUIREMENT OF CUSTOMER VIDE THEIR EMAIL DT. 2/4/2018 AND ANNEXURE DOCUMENT PROVIDED BY MTE.

REV	DATE	ALTERED	ZONE	REV	DATE	ALTERED	ZONE	REV	DATE	ALTERED	ZONE
		CHECKED				CHECKED				CHECKED	

DEPT: FDY.TECH.		SCALE: N.T.S.	WEIGHT IN Kgs	NAME	SIGN	DATE
BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR						
TITLE	DRN	CHK	APPD	DATE	DATE	DATE
ROUGH M/C DRG. FOR IP INNER CASING (UH)	156115611CM	NAVEEN	SG	15.06.22	15.06.22	15.06.22
PROJECT AND CUSTOMER NAME	TECHNOLOGY NO.	DRAWING NO.	SHEET NO. / NO. OF SHEETS			
660 MW MAITREE	16601C	0-106-02-56901/M4				

Item Description

Tender Enquiry No	FF/SC/22022/202200701
Item	IP Inner Casing UH (R/M)
Drg No	0-106-02-56901/M4: Rev-A
Quantity	2 No
Delivery Terms	4 Weeks / Pc
Before M/c weight	31000 KG
AFter M/c weight	30350 KG

Remarks:

MARK & MACHINE AS PER DLY DRG.

IDENTIFICATION NO. TO BE PUNCHED.

NTPC SEAL TO BE RETAINED

SCOPE OF MACHINING- AFTER PARTING PLANE MA