



NOTE

1. CASTING TO BE ROUGH MACHINED ON THE SURFACES MARKED ∇ TO THE DRAWING DIMENSIONS AND SURFACE FINISH 12.5 MICRONS AND TO THE TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE STATED.
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-18102 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18102.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 14190 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 8257 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SFL. 143
Date: 10 NOV 2021

REV	DATE	ALTERED	CHECKED
ZONE			

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORCE PLANT RANPUR HARDWAR	
DEPT.	F.DY. TECH.	SCALE	N.T.S.
TITLE	ROUGH M/C DRG. FOR (4 in 1) LOWER ROTATING LABYRINTH		
PROJECT AND CUSTOMER NAME	PALAMURU RR I BHEL / BHOPAL		
TECHNOLOGY NO	23502D		
DRAWING NO	3-204-07-18102/M4		
SHEET NO.	1		
NO. OF SHEETS	1		

MACHINING OF LABYRINTH RING

INDENT NO: 20210362

PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 3900 mm, and weight 15MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity \geq 15.0MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18102/M4: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: 5 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:- e) Details of the Organization f) 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

Vikalp Bibhuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
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15/12/21

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