



**NOTE**

1. CASTING TO BE ROUGH MACHINED ON THE SURFACE  $\nabla$  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.  
-0  
+0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-20201-4N1/M/P AND COMPONENT DRG NO. 3-204-07-20201.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 18741 KGS.  
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 14341 KGS.

CONTROLLED COPY  
Foundry Technology  
C.No. SF/.....165  
Date.....12 NOV 2021

REV	DATE	ALTERED	CHECKED
1			
2			
3			
4			
5			
6			
7			
8			

ZONE	REV	DATE	ALTERED	CHECKED
	1			
	2			
	3			
	4			
	5			
	6			
	7			
	8			

<b>BHARAT HEAVY ELECTRICALS. LTD.</b>	
<b>CENTRAL FOUNDRY FORGE PLANT</b>	
<b>RAIPUR HARDWARE</b>	
DEPT. FOUNDRY	SCALE N.T.S.
TITLE	WEIGHT IN KGS
ROUGH M/C DRG. FOR (4 in 1)	
UPPER ROTATING LABYRINTH	
PROJECT AND CUSTOMER NAME	TECHNOLOGY NO
BANGARODY RR-4 & TUS LBP1	3-204-07-20201/M1
BHEL / BHOPAL	23603A
SHEET NO.-1	NO. OF SHEETS-1



**MACHINING OF LABYRINTH RING**

INDENT NO: 20210376

**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. 3700 mm, and weight 19MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 19MT	Vendor to Confirm and submit detail

**TECHNICAL REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-20201/M1: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:- a) Details of the Organization b) 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 Bishuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K. Singh AGM (M/C Shop)
--	-----------------------------	------------------------------

उप संविदा विभाग  
दिनांक 15/12/21.....  
सं.एफ.एफ.पी/बी.एच.ई.एल, हरिद्वार