

**NOTE**

1. CASTING TO BE ROUGH MACHINED ON THE SURFACES MARKED  $\nabla$  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. 3-204-07-21601 3N1/M/P AND COMPONENT DRG NO. 3-204-07-21601 REV 00.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 10420 KGS.  
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 7975 KGS.

CONTROLLED COPY  
Foundry Technology  
C.No. LF/2.2  
Date: 22 FEB 2022

|                                       |  |            |                   |
|---------------------------------------|--|------------|-------------------|
| REV                                   | DATE   | ALTERED    | CHECKED           |
| ZONE                                  |  |            |                   |
| <b>BHARAT HEAVY ELECTRICALS. LTD.</b> |  |            |                   |
| <b>CENTRAL FOUNDRY FORGE PLANT</b>    |  |            |                   |
| <b>RANIPUR HARDWAR</b>                |  |            |                   |
| DEPT.                                 | FDY/TECH.  | SCALE      | N.T.S.            |
| TITLE                                 | ROUGH M/C DRG. FOR (3N1)<br>UPPER ROTATING LABYRINTH |            |                   |
| PROJECT AND CUSTOMER NAME             | BHTEL / BHOPAL                                       |            |                   |
| TECHNOLOGY NO                         | 23627  | DRAWING NO | 3-204-07-21601/M1 |
| DRN                                   | 23/04/2021   | NAME       | SRIN              |
| WHO                                   | NRG  | DATE       | 11/11/2021        |
| QCD                                   | AN   | DATE       | 11/11/2021        |
| APPD                                  | AN   | DATE       | 11/11/2021        |
| SHEET NO. - 1                         |  |            |                   |



MACHINING OF LABYRINTH RING

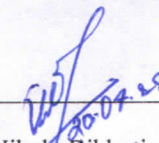
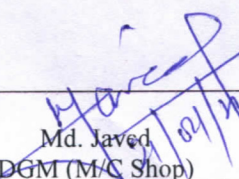
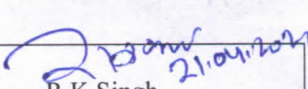
INDENT NO: 20210586

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. 2900 mm, and weight 11MT | Vendor to Confirm and submit detail |
| 2     | Vendor should have material handling capacity $\geq$ 11.0MT   | Vendor to Confirm and submit detail |

TECHNICAL REQUIREMENT

| S.No. | BHEL Requirement   | Vendor's Confirmation |
|-------|--|-----------------------|
| 1     | Machining as per drawing no. 3-204-07-21601/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:-<br>a) Details of the Organization<br>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      |

|   |   |   |
|---|---|---|
| <br>Vikalp Bibhuti<br>Dy. Manager (M/C Shop) | <br>Md. Javed<br>DGM (M/C Shop) | <br>R.K. Singh<br>AGM (M/C Shop) |
|---|---|---|

sh. A.K. Singh  
for m. a. p.  
23/04/22  
sh. Jaspal  
23/4/22  
23/4/22