

NOTE

1. CASTING TO BE ROUGH MACHINED ON 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. -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. 2-203-01-21610 3N1/M/P AND COMPONENT DRG NO. 2-203-01-21610 REV 00.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 10495 KGS. ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 8035 KGS.

REV	DATE	ALTERED	ZONE
		CHECKED	
DEPT. F.DY. TECH.		SCALE	N.T.S.
BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR		WEIGHT IN Kgs	
ROUGH M/C DRG. FOR (3 IN 1) UPPER STATIONARY LABYRINTH		TECHNOLOGY NO	23626
PROJECT AND CUSTOMER NAME		DRAWING NO	2-203-01-21610 / M1
KST 14 P2 BHOPAL BHEL / BHOPAL		SHEET NO.-1	
DRN	32/KALESHWAR	NAME	SION
CHKD	ING	DATE	14/02/2024
APPD	JAN SUDHAKAR	NO. OF SHEETS	1

MACHINING OF LABYRINTH RING

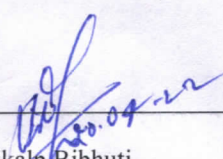
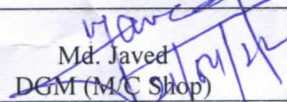
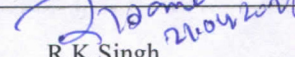
INDENT NO: 20210588

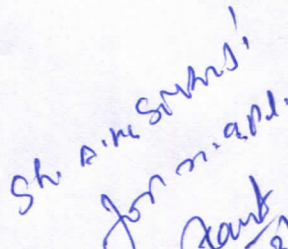
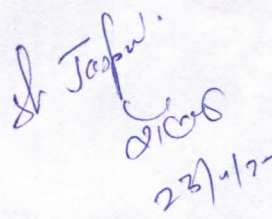
i) PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 3000 mm, and weight 11MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity ≥ 11MT	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-203-01-21610/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 Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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 Sh. A. M. S. V. S. V. S.
 28/04/22

 Sh. Jaspreet
 28/04/22