

**MACHINING OF IMPELLER CONE**


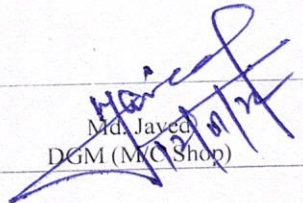
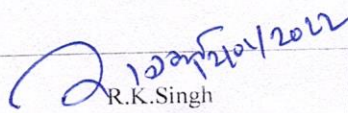
Indent No: 20210449

**iii) 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. 1600 mm, height 1020 mm and weight 4.0MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 4.0MT	Vendor to Confirm and submit detail

**iv) TECHNICAL REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-204-07-18102/M:Rev-B	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:- c) Details of the Organization d) 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. Jayed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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Technical drawing of a tapered cylindrical component with a flange. The drawing shows a side view with dimensions: top flange diameter 352, main body diameter 290, and a smaller diameter section 548. The length of the main body is 965. The top flange has a thickness of 45. The main body has a wall thickness of 40. The bottom flange has a thickness of 270. The drawing also shows a dashed line for the 'AS CAST CONTOUR OF CASTING' and a radius R100 at the top edge.

2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 2-204-07-18102  
REV 00


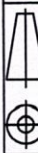
3. WT. OF CASTING BEFORE M/C: 3870 KGS  
WT. OF CASTING AFTER M/C: 1090 KGS

#### 4. MATERIAL OF CASTING: 13Cr 4Ni STAINLESS STEEL

5. CHAIN DOTTED LINE SHOWS AS CAST CONTOUR OF CASTING.

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Foundry Technology  
C.No. LF/.....179  
Date.....29 NOV 2021

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		<b>BHARAT HEAVY ELECTRICALS. LTD.</b>			
<b>CENTRAL FOUNDRY FORGE PLANT</b>		<b>RANIPUR HARDWAR</b>			
DEPTT. - FDY. TECHY		SCALE	WEIGHT	IN KG.	
TITLE	<b>ROUGH M/C DRG FOR IMPELLER CONE</b>				
PROJECT AND CUSTOMER NAME	TECHNOLOGY NO.		DRAWING NO.		
PRANAHITA VIII BHEL BHOPAL	23510		2-204-07-18102/M		
		SHEET NO.	NO. OF SHEETS		
			NAME	SIGN	DATE
		DRN	PRANAHITA VIII/23510M.DWG		
		WKD	T DAVE	SD	
		CHD	R LAKRA	SD	
		APD	T DAVE	SD	14/5/