

MACHINING OF BOTTOM SHAFT

Indent No- 20220086

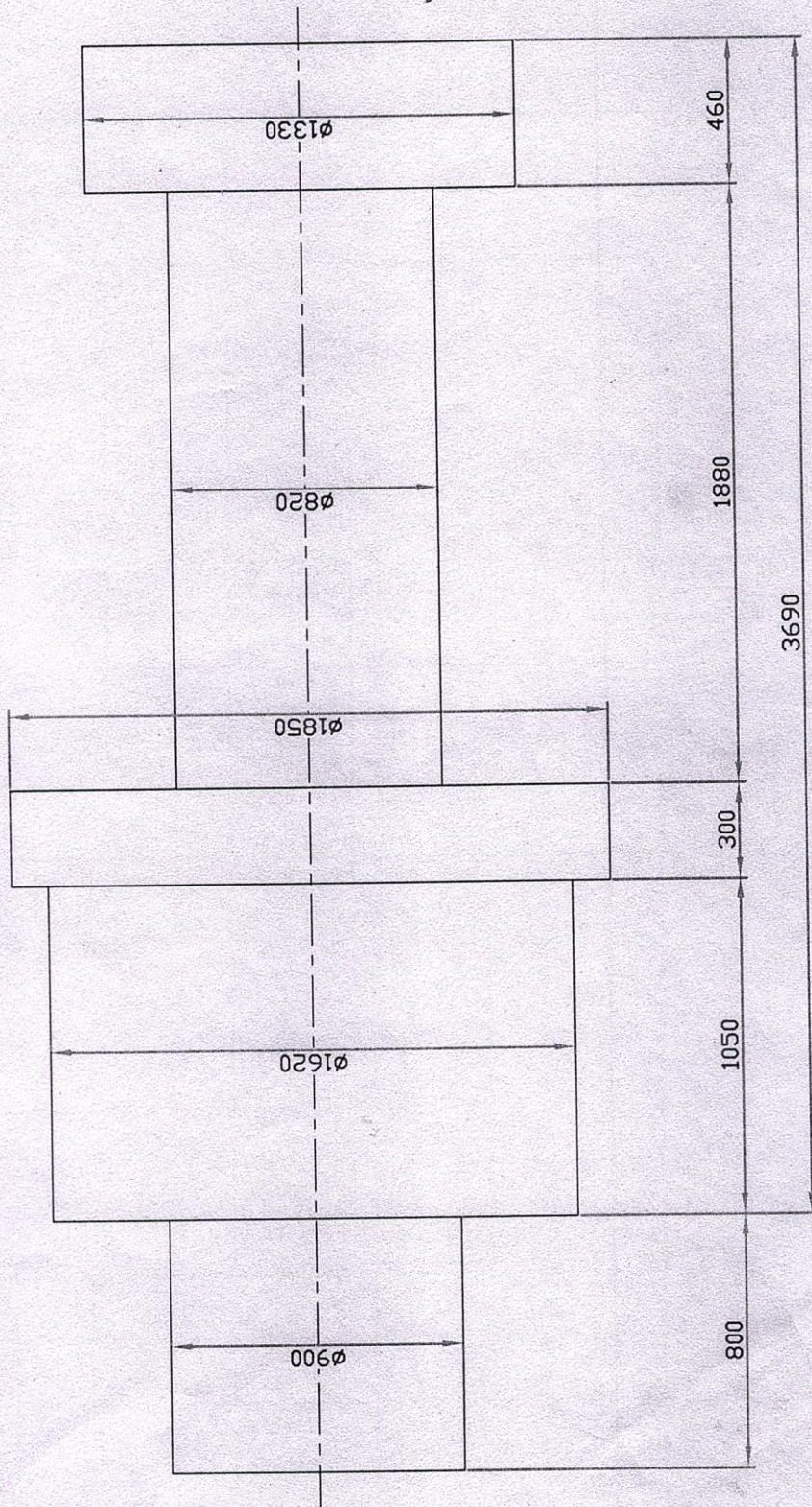
i) PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a LATHE machine having "Swing over bed (SOB)" Dia 1900mm or more and that can accommodate a job of length 4.5metres or more and has loading capacity of 41MT or more	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity \geq 41.0MT	Vendor to Confirm and submit detail
3	Vendor should have previous experience of machining of a shaft type of job having maximum Dia \geq 1150mm, Length \geq 3 metres and weight \geq 25MT.	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 04-D-3657: 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: 8 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 to submit Filled Supplier Registration Form along with Requisite Documents to SDC Cell in MM Deptt. of CFFP, BHEL, Haridwar. If already registered at CFFP or any other unit of BHEL, then Vendor code may be furnished.	Vendor to submit
9	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
10	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bishnuthi Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
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W. O. CFP : MF2-3657-U2		MATERIAL : HG-10035	
SCALE : N.T.S		W.T. : 37390 Kg	
NAME : BHEL, BHOPAL		DRG. NO. : 2-254-01-11702 R00	
CFPP DRG. NO.		REV. NO.	

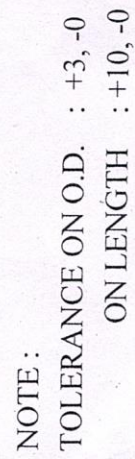

ITEM		COND.	
BOTTOM SHAFT			

DRN.	APPD.	DATE	DATE	DATE	DATE	DATE	DATE

REV.	DATE	ALTERED BY	DATE	REV.	DATE	ALTERED BY	DATE



Handwritten signatures and dates in the bottom right corner of the drawing area.




TOLERANCE ON O.D. : +3, -0

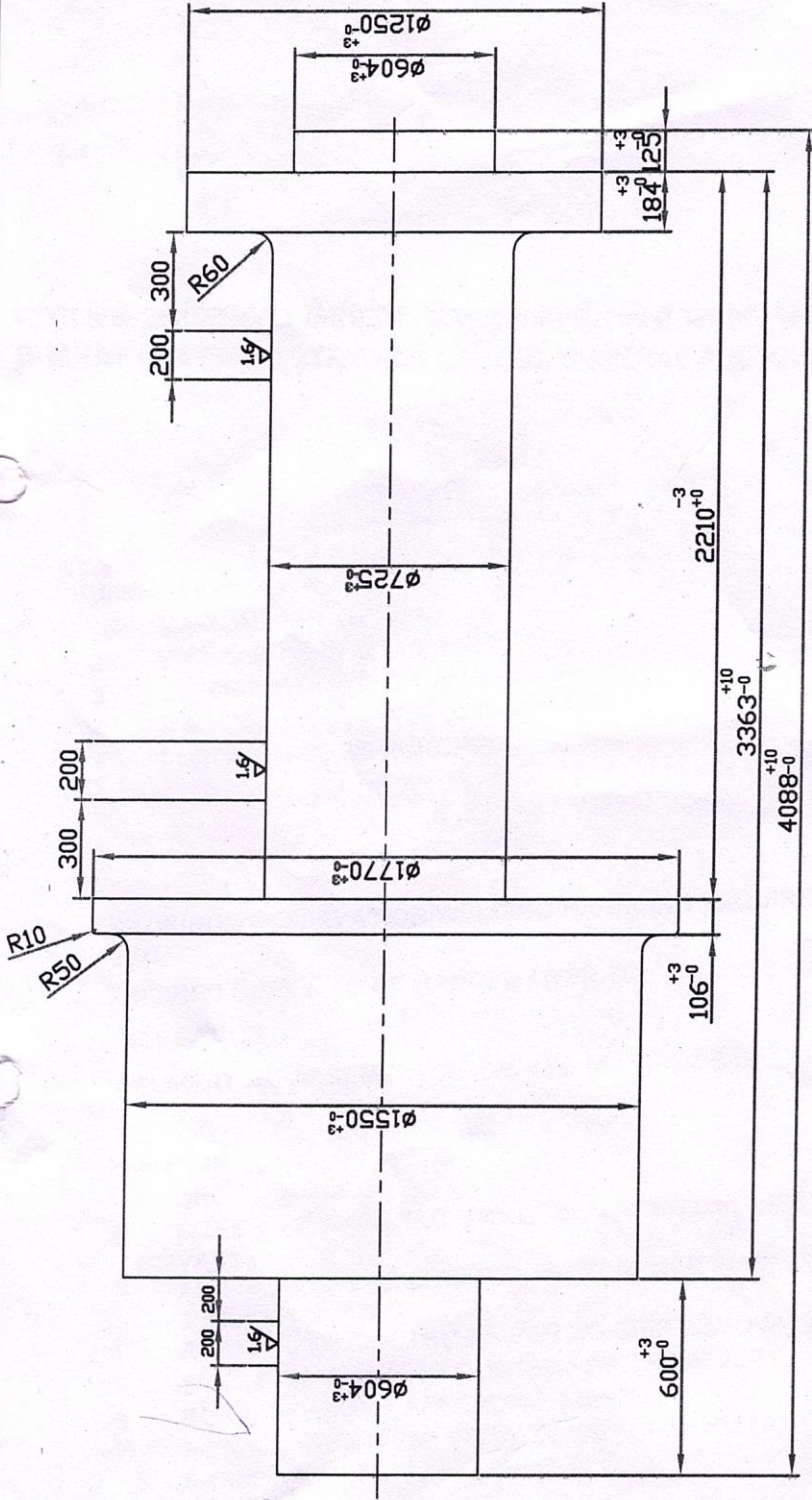
ON LENGTH : +10, -0

REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY
		CHECKED BY			CHECKED BY			CHECKED BY

REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY
		CHECKED BY			CHECKED BY			CHECKED BY

<div></div>	<div>भारत भारती</div> <div>C.F.F.P</div> <div>FORCE SHOP</div>	<div>DRN. <i>OK 25/02/21</i></div> <div>APPD. <i>GR 28/03/21</i></div>	<div>CONO.</div> <div>PRE U.T.</div>	<div>ITEM</div> <div>BOTTOM</div> <div>SHAFT</div>				<div>W. O. CFPP : MF2-3657-U2</div> <div>MATERIAL : HG- 10035</div> <div>SCALE : N.T.S. W.T. : 38065 Kg</div> <div>CUSTOMER</div> <div><div>NAME : BHEL,BHOPAL</div><div>DRG. NO. : 2-254-01-11702 R00</div></div>				<div>CFPP DRG. NO.</div> <div>U - 3657</div>		<div>REV. NO.</div> <div>00</div>	

6.3

UNLESS STATED
OTHER WISE.

NOTE:

1. TOLERANCE

OUTSIDE DIMENSION: $+3/-0$, ON INSIDE GAP: $-3/+0$, TOTAL LENGTH: $+10/-0$
ON OUTSIDE GAP: $+3/-0$

2. UNSPECIFIED RADIUS SHALL BE TAKEN AS R10.

3. BAND RUNOUT SHALL BE WITHIN 0.2 MM

4. ALL FACES SHALL BE PARALLEL AND SQUARE TO THE AXIS

C.F.F.P.
FORCE SHOP

DRN.

CHKD.

APPD.

18/06/18

18/06/18

18/06/18

ITEM

BOTTOM
SHAFT

COND.

AS DELIVERED

W. O. CFP : MF2-3657-U2

MATERIAL : HG- 10035

SCALE : N.T.S

W.T. : 27525 Kg

NAME BHEL, BHOPAL

DRG. NO. 2-254-01-11702 R00

CFPP DRG. NO.

REV. NO. 00

04 - D - 3657

Item Description

Tender Enquiry No. & Due Date	FF/SC/P22019/202200861
Item	Bottom Shaft Forging
Issue Material details	Drg No: F-3657:Rev-00
	Quantity: 03 No
	Weight: 37390 kg/Piece
Return Material details	Drg No: 04-D-3657:Rev-00
	Quantity: 03 No
	Weight: 27525 kg/Piece
Unit	Per KG of chip removal
Delivery Terms	8 Weeks / Pc

Remarks.

MARK AS PER DLY DRG
MACHINE TO DRG U-3657R00
OFFER FOR UT, IF OK IN UT
MACHINE TO DLY DRG 04-D-3657R00
FORGE NO TO BE PUNCHED
SIZES & WTS ARE TECHNOLOGICAL & INDICATIVE & ACTUAL MAY VARY
ACTUAL CHIPS GENERATED= DIFFERENCE IN WT OF OUTGOING
& INCOMING JOB.
RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS
PQR & TR AS PER ANNEXURE: 23657/A1
ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING &
INCOMING JOB.