



# BHARAT HEAVY ELECTRICALS LIMITED

( A Government of India Undertaking )  
HIGH PRESSURE BOILER PLANT  
PURCHASE DEPARTMENT - FOSSIL BOILERS  
THIRUCHIRAPALLI - 620014  
TAMILNADU (INDIA)

Page  
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PHONE :2577331  
GRAMS : BHARATELEC  
FAX NO: 2520719  
E-mail: srchandran@bheltry.co.in  
Web:

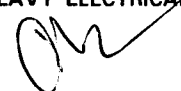
429-002/A

Enquiry No	Enquiry Date	Due Date for Quotation
2661400873 - 55	02.12.2014	27.12.2014

Please quote Enquiry No, Date and due date in all correspondences.  
This is only a request for quotation and not an order

Item	Description	Unit	Quantity	Delivery Quantity	Schedule Date
10	7508F0301000 SCREW ROD (LH) AS PER DRG NO. 3M-08F-03-10562 NOTE: FOR SL.NO. 10 AND 20 ARE MATING COMPONENTS. HENCE THESE ITEMS SHOULD BE PROCURED FROM SINGLE SOURCE ONLY. VENDOR QUALIFYING CRITERIA Only those vendors who satisfy the following conditions will get qualified to participate in the tender: 1.,,Vendor should have minimum 2 years of experience in this field. 2.,,Previous PO details for supplying similar kind of items to BHEL and/or any-other Organisation should be submitted along with offer. Otherwise offer will be rejected. 3.,,Company profile details has to be provided along with offer. 4.,,BHEL reserves the right to visit the vendor's works for verifying the manufacturing facilities and any other credential furnished by the vendor. In case the information furnished with the offers found to be false /incorrect, the offer shall be rejected.	NO	4.000	4.00	26.02.15
20	7508F0301100 JAW (LH) AS PER DRG.NO. 3M-08F-03-11810	NO	4.000	4.00	26.02.15
30	7508F0304000 BRAKE SHOE LINING PLATE AS PER DRG.NO. 3M-08F-03-11332, ONE SET CONSISTS OF 12 PIECES.	SET	1.000	1.00	26.02.15
40	7508F0300600 HELICAL GEAR AS PER DRG NO. 3M-08F-03-11666 NOTE: FOR SL.NO. 40 AND 50 ARE MATING COMPONENTS. HENCE THESE ITEMS SHOULD BE PROCURED FROM SINGLE SOURCE ONLY.	NO	2.000	2.00	26.02.15
50	7508F0300700	NO	2.000	2.00	26.02.15

The offers should reach us 30 minutes before the time of opening of tenders.  
The offers will be opened at 14.30 hrs on the due date of tender in the presence of tenderers who have submitted their offer and who may like to be present for the tender opening.Late and delayed offers are liable to be rejected.

Yours faithfully,  
For **BHARAT HEAVY ELECTRICALS LIMITED**  
  
MANAGER / PURCHASE  
(FOSSIL BOILERS)  
Yours faithfully,



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THIRUCHIRAPALLI - 620014  
TAMILNADU (INDIA)

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Web:

2661400873 / 02.12.2014

HELICAL GEAR AS PER DRG  
NO:4M-08F-03-26205

60	7508F0304100 PINION SHAFT AS PER DRG.NO. 3M-08F-03-11764	NO	2.000	2.00	26.02.15
70	7508F0304200 SHAFT AS PER DRG.NO. 3M-08F-03-11785	NO	1.000	1.00	26.02.15
80	7508F0304300 HUB AS PER DRG.NO. 3M-08F-03-11914	NO	2.000	2.00	26.02.15
90	7508F0304400 SPLIT NUT AS PER DRG NO. 3M-08F-03-12122, ONE SET CONSIST OF 2 PIECES.	SET	2.000	2.00	26.02.15
100	7508F0304500 PINION SHAFT AS PER DRG.NO. 3M-08F-03-12123	NO	2.000	2.00	26.02.15
110	7508F0301700 SPLINE SHAFT AS PER DRG.NO. 3M-08F-03-12252	NO	2.000	2.00	26.02.15
120	7508F0304600 GIB AS PER DRG.NO. 4M-08F-03-15683	NO	2.000	2.00	26.02.15
130	7508F0304700 GIB AS PER DRG.NO. 4M-08F-03-15684	NO	2.000	2.00	26.02.15
140	7508F0304800 BUSH AS PER DRG.NO. 4M-08F-03-17518	NO	6.000	6.00	26.02.15
150	7508F0304900 NUT AS PER DRG.NO. 4M-08F-03-18303	NO	4.000	4.00	26.02.15
160	7508F0305000 NUT AS PER DRG.NO. 4M-08F-03-18304	NO	4.000	4.00	26.02.15
170	7508F0305100 GUIDE BUSH IN ASSEMBLED CONDITION AS PER DRG.NO. 4M-08F-03-18329	NO	2.000	2.00	26.02.15
180	7508F0300400 THRUST COLLAR AS PER DRG NO. 4M-08F-03-18331, ITEM No.1, NOTE: FOR SL.NO. 180 TO 230 ARE SAME DRG NUMBER BUT DIFFERENT SIZE. HENCE THESE ITEMS SHOULD BE PROCURED	NO	2.000	2.00	26.02.15

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The offers will be opened at 14.30 hrs on the due date of tender in the presence of  
tenderers who have submitted their offer and who may like to be present for the tender  
opening.Late and delayed offers are liable to be rejected.

Yours faithfully,  
For **BHARAT HEAVY ELECTRICALS LIMITED**

MANAGER / PURCHASE  
(FOSSIL BOILERS)  
Yours faithfully,



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( A Government of India Undertaking )  
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THIRUCHIRAPALLI - 620014  
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3/3

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E-mail: srchandran@bheltry.co.in  
Web:

2661400873 / 02.12.2014

FROM SINGLE SOURCE ONLY.

190	7508F0300500 THRUST COLLAR AS PER DRG NO:4M-08F-03-18331, ITEM NO. 2	NO	2.000	2.00	26.02.15
200	7508F0305200 THRUST COLLAR AS PER DRG NO:4M-08F-03-18331, ITEM NO. 3	NO	2.000	2.00	26.02.15
210	7508F0305300 THRUST COLLAR AS PER DRG NO:4M-08F-03-18331, ITEM NO. 4	NO	2.000	2.00	26.02.15
220	7508F0305400 THRUST COLLAR AS PER DRG NO:4M-08F-03-18331, ITEM NO. 5	NO	2.000	2.00	26.02.15
230	7508F0305500 THRUST COLLAR AS PER DRG NO:4M-08F-03-18331, ITEM NO. 6	NO	2.000	2.00	26.02.15
240	7508F0305600 FIX RING AS PER DRG NO:4M-08F-03-18332	NO	2.000	2.00	26.02.15
250	7508F0305700 NUT AS PER DRG NO:4M-08F-03-18333	NO	2.000	2.00	26.02.15
260	7508F0305800 NUT AS PER DRG NO:4M-08F-03-18334	NO	2.000	2.00	26.02.15
270	7508F0305900 END COVER AS PER DRG NO:4M-08F-03-19420	NO	2.000	2.00	26.02.15
280	7508F0306000 BOX NUT AS PER DRG NO:4M-08F-03-29521, ONE SET CONSIST OF 2 PIECES.	SET	2.000	2.00	26.02.15

**General Note:**

GENERAL NOTE:PLEASE SUBMIT YOUR OFFER IN "TWO PART BID SYSTEM" AS PER THE ANNEXURES ENCLOSED.


ENCLOSURES:ANNEXURE II,III,IV,V,VI,VII.

**Enclosures:**

"LD clause has to be confirmed without fail."

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Yours faithfully,  
For **BHARAT HEAVY ELECTRICALS LIMITED**

  
MANAGER / PURCHASE  
(FOSSIL BOILERS)  
Yours faithfully,

**CAPITAL PURCHASE**  
**COMMERCIAL TERMS AND CONDITIONS**

**1.0 QUOTATIONS**

The Bidders shall submit the offer in **TWO INNER ENVELOPES** as indicated below which shall be sealed in one outer envelope.

**Envelope I** This sealed envelope should contain all the copies of technical bid together with un-priced commercial bid & annexure III. This envelope should be clearly marked "**Part I - Technical and commercial bid**",

Indicating Enquiry No., Due Date and Address & Reference of the Bidder.

**Envelope II** This sealed envelope should contain **price as per Annexure-IV format**. This envelope should be clearly marked "**Part II - Price bid**", indicating **Enquiry No., Due Date and Address & Reference of the Bidder**.

Both the envelopes (Part I & II) shall be put in one cover (**Envelope III**), duly sealed, superscribing as Part I and Part II of Enquiry No., due date of opening and the address and reference of the Bidder

The above offer should reach this office on or before the due date by 14.00 hours (IST). Late offers will not be considered.

Tender should not be addressed to any individual's name but only by designation to

**SENIOR MANAGER /PURCHASE/ CP & SP/ MM / MFG  
BHARAT HEAVY ELECTRICALS LIMITED  
HIGH PRESSURE BOILER PLANT  
TIRUCHIRAPALLI - 620 014  
TAMIL NADU**

Tenders should be free from **CORRECTION AND ERASURES**, Corrections if any, must be attested. All amounts shall be indicated both in words as well as in figures. Where there is difference between amount quoted in words and figures, amount quoted in words shall prevail.

Offers should be in **ENGLISH** and accompanied by detailed technical literature, catalogue and detailed dimensional drawings in **ENGLISH** or otherwise, the offers will not be considered.

**2.0 OPENING OF TENDERS**

The Part I - Technical & commercial bid alone would be opened on the Tender opening date.

The Part II - Price bid of technically suitable Bidders alone would be opened. The Technically Suitable Bidders would be informed about the tender opening date through e-mail.

Clarifications if any required by BHEL for Technical evaluation **would be** sought from Bidders before opening of Part II - price bid

**For any queries clarifications the bidders may contact us through our FAX NO. +91 431 2520719 or through e-mail <mmcpmf1@bheltry.co.in >&< chells@bheltry.co.in>**

**MM: CP & SP**  
**Annexure For Techno Commercial Bid**

Check List - to be filled and submitted along with Technical Bid

BHEL Commercial Terms and Conditions for Indigenous Supplies	Vendor's Confirmation / Comments
Technical confirmation to BHEL's Specification as called for in BHEL Format shall be furnished. If needed additional sheets shall be used.	
Prices shall be <b>quoted item wise</b> only as per the model format enclosed	
Prices shall be quoted on " <b>FIRM PRICE</b> " basis only The prices should be only on <b>F.O.R / Despatching station</b> basis with <b>Packing &amp; Forwarding</b> charges if any. <b>Applicable % of ED &amp; Sales Tax, Freight &amp; Insurance, Installation &amp; Commissioning Charges should be clearly Indicated</b>	
<b>Validity of offer</b> shall be for a minimum period of 120 days from the date of Tender opening	
Delivery period from the date of Letter of Intent / Purchase order shall be clearly mentioned in the offer	
<b>Liquidated damages @ '0.5% per week</b> subject to a maximum of 10% of the order value shall be applicable for delay in deliveries <b>For Details Refer Annexure- v</b>	
<b>Following Risk Purchase clause</b> shall be applicable The purchaser at his option will be entitled to terminate the contract and to purchase elsewhere at the risk and cost of the seller either the whole of the goods or any part which the supplier has failed to deliver or dispatch within the time stipulated or if the same were not available, the best and the nearest available substitute therefore The supplier shall be liable for any loss which the Purchaser may sustain by reason of such risk purchases	
<b>Payment term for supply portion:</b> Payment term is 100% direct payment after 45 days from the date of receipt and acceptance of materials <b>For details Refer Annexure- v</b>	
Erection / commissioning: (if applicable only) Erection / commissioning charges if any has been mentioned in the offer or else confirmation that Erection /commissioning shall be done at free of cost is available in the offer,	
The equipment shall be guaranteed for a period of 12 months from the date of commissioning	
Final inspection and acceptance of equipment will be after installation at BHEL, Trichy	
The vendor shall provide necessary drawings, Test Certificates and Operating Maintenance Manuals etc., as called for in the Technical Specification, in the required number of copies at no extra cost	
Any warranty replacement during warranty period shall be supplied free of charge on FOR BHEL, Trichy basis.	
Offers should be submitted only in <b>sealed cover super-scribing clearly the Enquiry reference and due date.</b>	
% of Excise Duty with cess	
% of TAX (CST/VAT)-(INGST with FORM-17 or CST with C-FORM)	
Packing & Forwarding Charges ( if any in % only)	
Percentage of Freight& transit insurance charges, if any Freight charges from Dispatching station to BHEL, Tiruchirappalli • Supplier should quote for F.O.R-BHEL Trichy Stores.	
As per Commercial terms and conditions, acceptance for participation in Reverse auction (RA).Yes/No to be indicated	
Name of the person for participating reverse auction	
Land Line Number	
Fax Number	
Mobile Number	
E-mail ID	

## NOTE:-

- a) It is confirmed that all the terms and conditions stipulated In the Enquiry have been fully understood by us and all clarifications & details have been obtained.
- b) Your offer should be indicating applicable If any P&F Charges, % of ED, Sales Tax -CST or VAT, Service Tax), Freight, Insurance and Installation and Commissioning Charges etc., as per our Price Format
- c) Your specific acceptance to our Payment terms, LD & Risk Purchase Clause are essential for consideration of your offer. Other wise your offer is liable for rejection.
- d) No row shall be left blank. Please indicate NA, in case the item is "not applicable"

**Annexure For Price Bid**

**Bharat Heavy Electricals Limited TIRUCHIRAPPALLI CAPITAL PURCHASE  
MODEL PRICE BID FORMAT FOR INDIAN BIDDERS**

Annexure-IV

Enquiry No. & Date:

Bidder's Offer No. & Date:

SI No	Description of item	Unit	Quantity	Rate in Rs.	Value in Rs.
	<b>TOTAL VALUE IN RS.</b>				
	<b>Packing &amp; Forwarding charges in % if any</b>				
	<b>Freight &amp; Insurance Charges In % if freight charges are not mentioned it will be considered as FOR-BHEL TRICHY.</b>				
	<b>Excise Duty (indicate in %)</b>				
	<b>A) TNGST — VAT (%)</b>				
	<b>B) CST with C-FORM — (%)</b>				
	<b>C) CST without C-Form — (%)</b>				
	<b>Approximate Net weight of the total consignment</b>				
	<b>Approximate Gross weight of the total consignment</b>				
	<b>Approximate Dimensions of the Consignment</b>				
	<b>The price indicated shall be inclusive of all accessories, spares etc. as given in the scope of supply. Individual item-wise break-up price shall be attached as an annexure to this price bid format.</b>				

**Signature & Seal of Vendor**

**NOTE:**

1. The price bid should be submitted only as per the above format. No row shall be left blank. Please indicate NA, in case the item is "not applicable".
2. Prices shall be quoted item-wise only as per the above format.
3. If Price quoted is Inclusive of ED, the included ED Value and Base Value shall be indicated item-wise.

<b>Payment Term (Indigenous)</b>	
<b>If materials are receivable at Stores/Trichy <u>without</u> PBG</b>	Payment term is 100% direct payment after 45 days from the date of receipt and acceptance of materials.
<b>If materials are receivable at Stores/Trichy <u>with</u> PBG</b>	Payment term is 100% direct payment after 45 days from the date of receipt and acceptance of materials and against 10% PBG valid for the warranty period.
Any deviation in the above payment term will attract loading as mentioned below. “Base rate of SBI (as applicable on the date of bid opening. Techno-commercial bid opening in case of two part bids) + 6% shall be considered for loading for the period of relaxation sought by bidders.	

Payment through Bank is not preferred. In case of Payment through Bank is opted by Supplier, BHEL prefers documents submission through bank with copy of LR and door delivery of Goods to Site/Stores with Consignee copy attached. In this case Loading will be 3% on the offered value.

Offers of indigenous Suppliers with payment terms as LC/Advance Payment are liable for rejection.

#### **Liquidated Damages / Penalty -**

Liquidated damages shall be 0.5% of the total order value per week or part thereof subject to a maximum of 10% of the total order value.

For staggered delivery schedule, LD shall be 0.5% of the undelivered portion per week of the delay or part thereof subject to a maximum of 10% of the total order value.

Any deviation from the above LD clause, loading will be applied to the extent to which it is not agreed by the bidder (at offered value).

#### **Guarantee / Warranty Period – (if applicable)**

Normally No deviation permitted and the deviated offers are liable for rejection.

#### **Ranking-**

BHEL will consider the ranking after the loading is applied as referred above wherever deviations are observed.

#### **Performance Bank Guarantee – (if applicable)**

Normally No deviation permitted and the deviated offers are liable for rejection.

#### **NOTE:-**

1. If the due date of tender opening happens to be a holiday, the tenders will be opened on the next working day.
2. BHEL reserves the right to go for a reverse auction (RA) instead of opening the submitted sealed bid which will be decided after technical evaluation. Information and general terms and conditions covering RA are given in commercial terms and conditions.
3. Corrigendum if any, with respect to this tender will be hosted only in the website <http://www.bhel.com> or <http://tenders.gov.in>. You are requested to visit the website regularly for updates.

**Special Provisions for Micro and Small Enterprises (MSE)**

1. 20% of the tendered quantity is earmarked for MSE suppliers in this tender.
2. Out of the 20% tendered quantity reserved for MSE suppliers, 4% shall be earmarked for procurement from MSE owned by SC/ST entrepreneurs.
3. In case MSE vendor participating in the tender quotes within the price band of L1+15%, they will be allowed to supply the portion of the requirement subject to acceptance of L1 price by MSE vendor. In case of more than one such MSE, the supply shall be shared proportionately.
4. "MSE suppliers can avail the intended benefits only if they submit along with the offer, attested copies of either EM II certificate having deemed validity (five years from the date of issue of acknowledgement in EM-II) or valid NSIC certificate or EM II certificate along with attested copy of a CA certificate (Format enclosed at Annexure -VII where deemed validity of EM II certificate of five Years has expired) applicable for the relevant financial year (latest audited). Date to be reckoned for determining the deemed validity will be the date of bid opening (Part 1 in case of two part bid). Non submission of such documents will lead to consideration of their bid at par with other bidders. No benefit shall be applicable for this enquiry if any deficiency in the above required documents are not submitted before price bid opening. If the tender is to be submitted through e-procurement portal, then the above required documents are to be uploaded on the portal. Documents should be notarized or attested by a Gazetted officer."

**Certificate by Chartered Accountant on letter head**

This is to Certify that M/S .....  
(hereinafter referred to as 'company') having its registered office at .....  
is registered under MSMED Act 2006, (Entrepreneur  
Memorandum No (Part-II) ..... dtd:.....,  
Category: ..... (Micro/Small)). (Copy enclosed).

Further verified from the Books of Accounts that the investment of the company as on  
date..... as per MSMED Act 2006 is as follows:

1. **For Manufacturing Enterprises:** Investment in plant and machinery (i.e. original cost  
excluding land and building and the items specified by the Ministry of Small Scale Industries vide its  
notification No.S.O.1722(E) dated October 5, 2006 :  
Rs.....Lacs
2. **For Service Enterprises:** Investment in equipment (original cost excluding land and building and  
furniture, fittings and other items not directly related to the service rendered or as may be notified under the MSMED  
Act, 2006:  
Rs.....Lacs

The above investment of Rs.....Lacs is within permissible limit of  
Rs.....Lacs for .....Micro / Small (Strike off which is not applicable)  
Category under MSMED Act 2006.

Date:

(Signature)

Name -

Membership number -

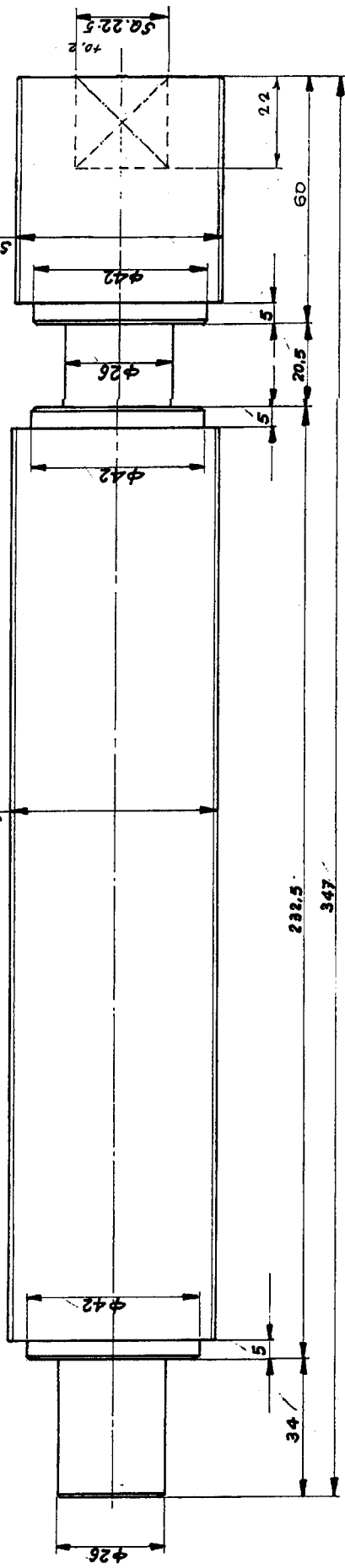
Seal of Chartered Accountant

**CAUTION**

THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LTD., TRICHYRAPALLI - 520 014.

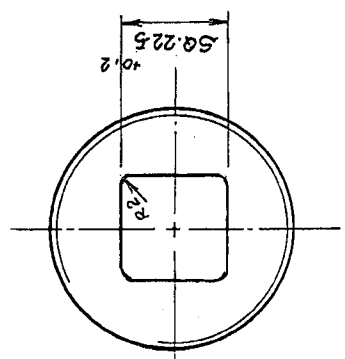
50.7mm  $\phi$  50x6.35(L.H)

50.7mm  $\phi$  50x6.35(L.H)



**NOTE:-** CHAMFER THE EDGES TO 45/45°

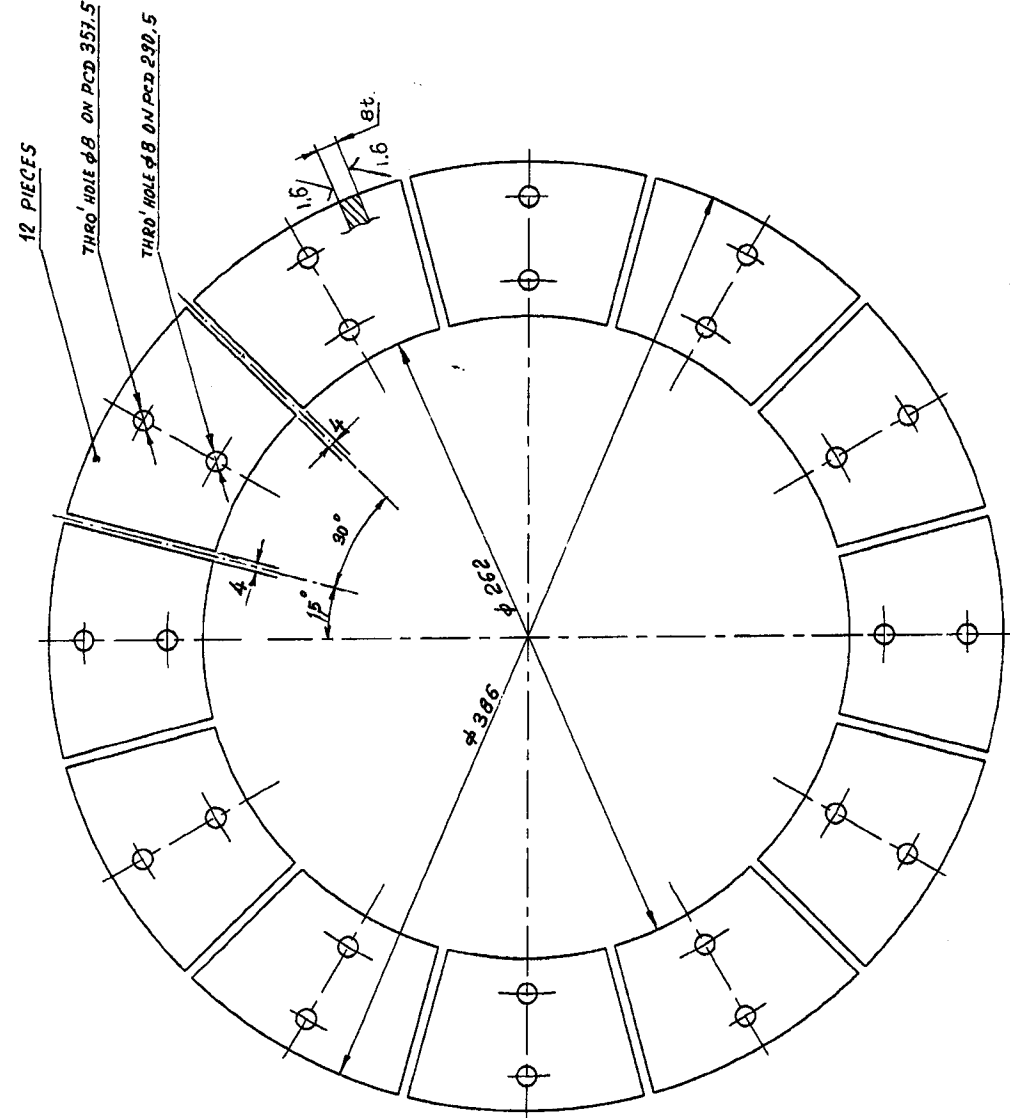
MATING JAW REF. DRG. NO. 3-M-08F-11810



NO. OF PIECES	DESCRIPTION	SEM-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SERIAL NO.	NET WT.	GROSS WT.	DRAWING No.	ITEM No.	REVISIONS	
										DATE	BY
1:1	SCREW ROD										
	CHECKED										
	APPROVED										
	STDS. OFFICER										
	DATE										
	REFERENCE										
	PART No.										
	50 14 133										
	ALTERATIONS										
	DATE										
	SIGNATURE										
	MACHINE DEEP HOLE BORING LATHE										
	TITLE:										
	TYPE: 60-6-FIB (PTC 400)										
	DRAWING No.										
	3-M-08f-10562										
	No. OF SHEETS:										
	SHEET No.										

ALL DIMENSIONS ARE IN MM

CAUTION: THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED. TRICHYRAPPALI - 680 014.

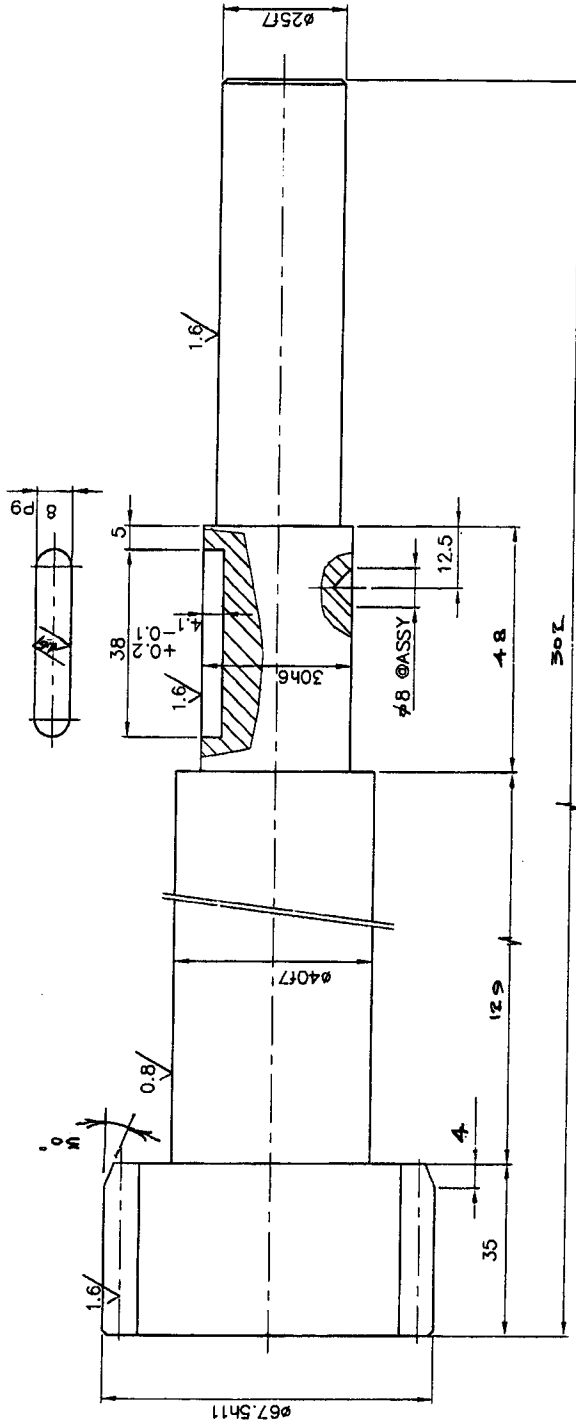


32/1.6/ ✓

No. of Revised	DESCRIPTION	IS: 2062	3.96	ITEM No.	
		MATERIAL	NET WT. IN KGS.	DRAWING No.	
REFERENCE:		COMPONENT CODE: 00	EQUIPMENT CODE: 03	INDEX	
SCALE DRAWN		ALTERATIONS:	DCN REF	DATE	SIGN.
CHECKED	<i>g...</i>				
APPROVED	<i>S. Chandra...</i>				
DATE	15.07.96				
MACHINE: DEEP HOLE BORING LATHE		TYPE	PTC 400	REV.	
TITLE:		DRAWING No.		03	
BRAKE SHOE LINING PLATE		3-M-08F-11332		Sheet No	
MAIN MOTOR BRAKE J		Main Sheets		Sheet No	



ALL DIMENSIONS ARE IN MM



067.5h11	-0.000	025f7	-0.020
040f7	-0.190	8P9	-0.041
030h6	-0.025		-0.015
	-0.050		-0.051
	-0.000		
	-0.013		

HARDENED TO HRC 40<sup>+0.2</sup>

CHAMFER ALL SHARP CORNERS TO 45°

NO. OF TEETH	13
MODULE	4.5
PRESSURE ANGLE	20°
WIDTH ACROSS 2 TEETH	-0.158 -0.210
CORRECTION FACTOR	NIL
Q.L.T.Y. & TOL. ZONE	9c DIN 3967
MATING GEAR NO. OF TEETH	RACK
MATING GEAR DRAWING NO.	---
CENTRE DISTANCE	---

SCALE	DRAWN	P. A. ROSS / <i>[Signature]</i>	55C8	IS: 5517	3.61	1-M-08F-0983	D3
CHECKED	APPROVED	<i>[Signature]</i>	MATERIAL	STANDARD	NET WT. IN KGS.	DRAWING No.	TEST No.
1:1	DATE	10-02-99		COMPONENT CODE	08	EQUIPMENT CODE	03
				ALTERATIONS		DCN REF	DATE
						SIGN.	INDEX
TITLE: PINION SHAFT OD 67.5/13T*30ZL (P-HEAD DRIVE ASSY.)			MACHINE: DEEP HOLE BORING			TYPE: PTC 400	
DRAWING No: 3-M-08F-11764			DRAWING No: 03			REV.	
Sheet No: 1			Sheet No: 1			Sheet No: 1	

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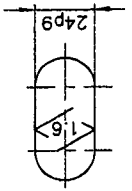


ALL DIMENSIONS ARE IN MM

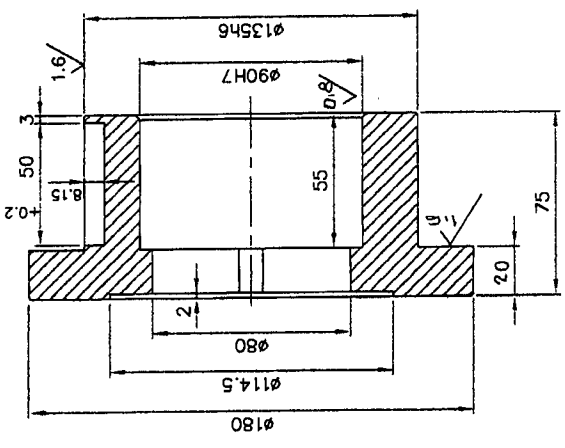
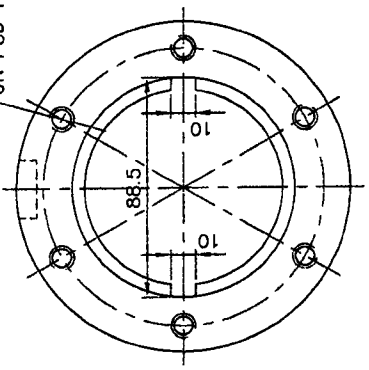
CAUTION: THIS DRAWING IS OUR SOLE PROPERTY AND SHOULD NOT BE USED IN ANY FORM FOR ANY PURPOSE WITHOUT THE WRITTEN PERMISSION OF BHARAT HEAVY ELECTRICALS LIMITED, TRICHYAPALLI - 620 014.

ø1.35h6	-0.000
ø90 H7	+0.035
24 p9	+0.000
	-0.022
	-0.074

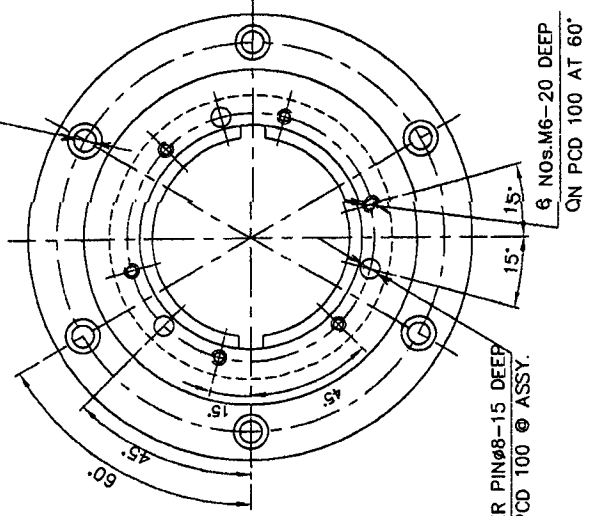
32/16/0.8/1.6



6 HOLES M10-20 DEEP  
ON PCD 113.5



6 HOLES ø9/CBRø14-9 DEEP  
ON PCD 157



TAPER PIN ø8-15 DEEP  
ON PCD 100 @ ASSY.

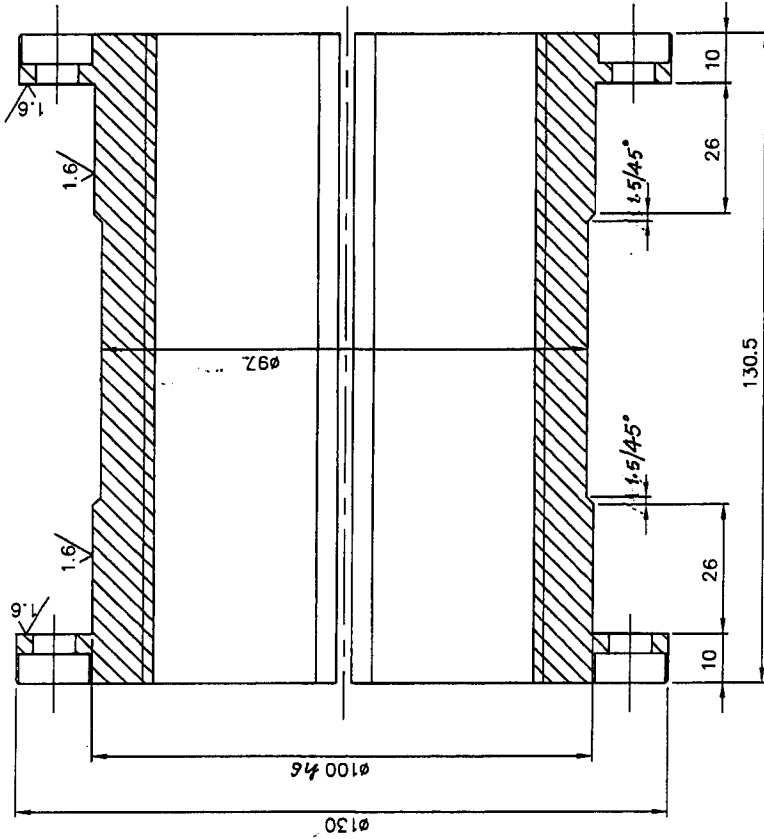
6 NOS. M6-20 DEEP  
ON PCD 100 AT 60°

CHAMFER ALL SHARP CORNERS TO 1/45°

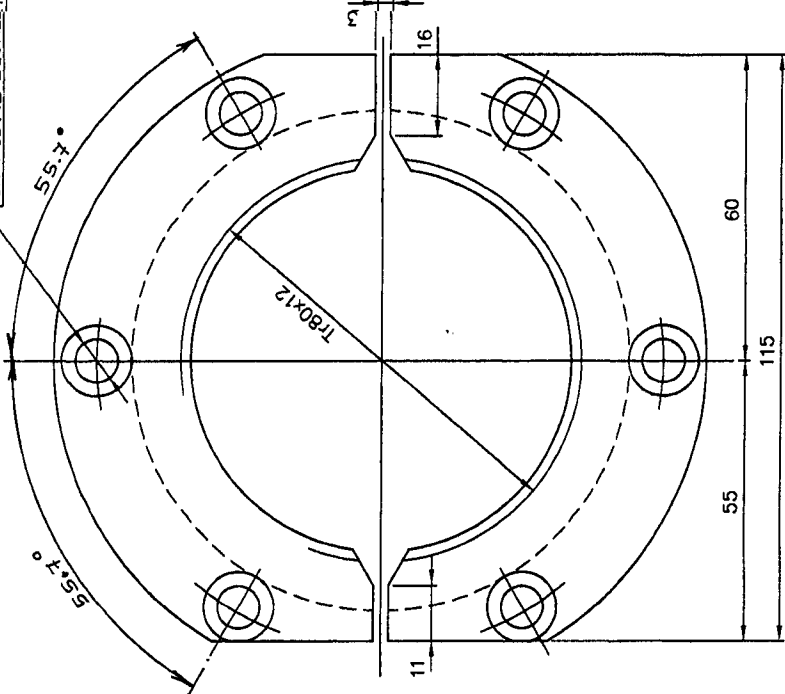
ROD ø180x75L	45 C8	IS: 7283	7.0	1-M-08F-08F7	10
DESCRIPTION	MATERIAL	STANDARD	NET WT. IN KGS.	DRAWING No.	ITER No.
REFERENCE:	ALTERATIONS:	COMPONENT CODE: 00	EQUIPMENT CODE: 03	DCN REF	DATE
SCALE	DRAWN	CHECKED	APPROVED	DATE	INDEX
1:2	P. A. ROSS / <i>lalk</i>	<i>et</i>	<i>et</i>	06-01-2000	
MACHINE: DEEP HOLE BORING LATHE					
TITLE: HUB (ø180x75) (DRIVE ASSY.)					
DRAWING No: 3-M-08F-11914					
REV. 03					
Sheet No					

ALL DIMENSIONS ARE IN MM

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6 HOLES  $\phi 8.5 \times \text{CBR} \phi 14$  - 6 DEEP  
ON POSITIONS EQUALLY SPACED



$\phi 100 h6$   
-0.000  
-0.022

3.2/1.6  
3.2/1.6

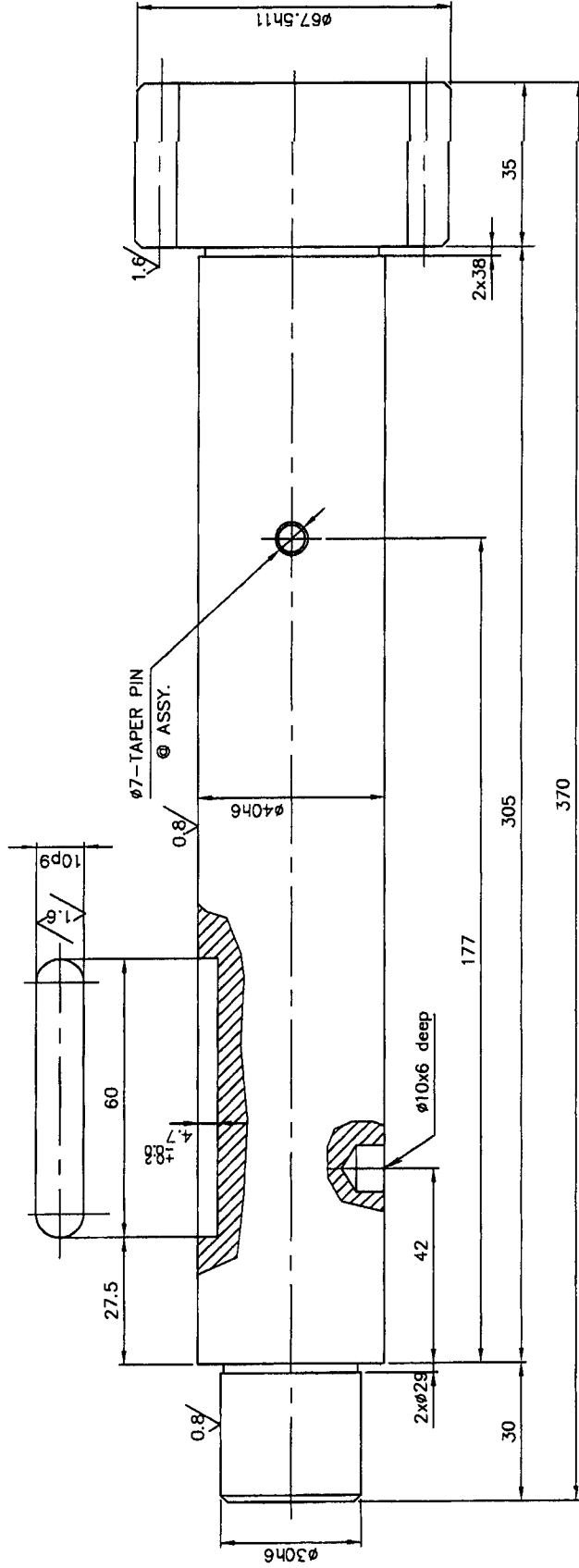
NOTE: -  
CHAMFER SHARP CORNERS TO 1/45°  
FOR MATING SCREW REF. DRG. No. (---)  
SPLIT AFTER MACHINING

No. of Pieces	DESCRIPTION	MATERIAL	STANDARD	NET WT. IN KGS.	DRAWING No.	TIER No.	EQUIPMENT CODE: 03	DCN REF	DATE	SIGN.	INDEX	REV.
1	$\phi 130 \times 130.5 \text{ L}$	PCuSn7	IS: 28	3.20	1-M-08F-00998	127						
SCALE	DRAWN	CHECKED	APPROVED	DATE								
1:1				20-02-2002								
MACHINE: DEEP HOLE BORING LATHE												
TITLE: SPLIT NUT $\text{Tr}80 \times 12 \times 130.5 \text{L}$ (APRON ASSY)												
DRAWING No: 3-M-08F-12122												
TYPE: 60-6-FLB/PTC 400												
No. of Sheets: 03												
Sheet No: 3												

ALL DIMENSIONS ARE IN MM

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10P9	φ30h6	-0.000	φ40h6	-0.000	3.2/√R 0.8
		-0.013		-0.016	
		-0.015		-0.050	
		-0.050		-0.190	



± 0.2

HARDENED TO HRC 40

CHAMFER ALL SHARP CORNERS TO 1.5/45°

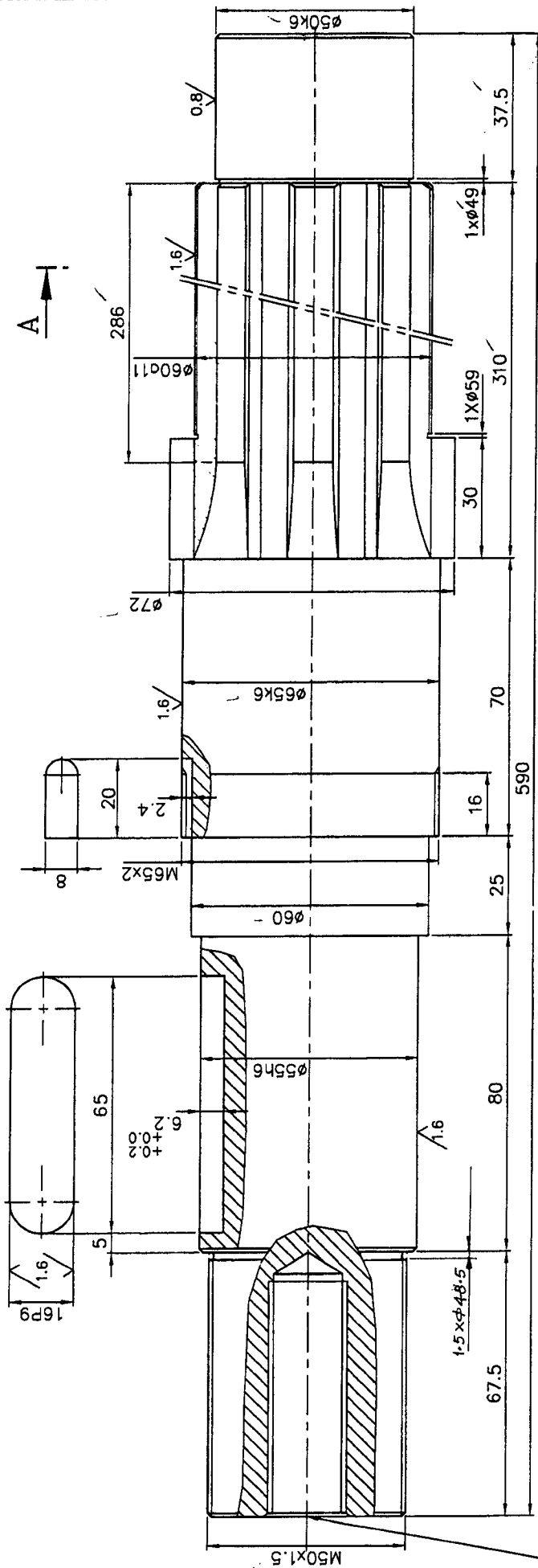
NO. OF TEETH	13
MODULE	4.5
PRESSURE ANGLE	20°
WIDTH ACROSS 2 TEETH	20.7459
CORRECTION FACTOR	NIL
Q.L.T.Y. & TOL. ZONE	9c DIN 3967
MATING GEAR NO. OF TEETH	RACK
MATING GEAR DRAWING NO.	-
CENTRE DISTANCE	-

No. of Pieces	φ68x370L	55C8	IS: 5517	3.61	
	DESCRIPTION	MATERIAL	STANDARD	NET.WT IN KGS.	DRAWING No.
REFERENCE:			COMPONENT CODE: 08	EQUIPMENT CODE: 03	TOP INDEX
SCALE	1:1		ALTERATIONS:	DCN REF	DATE
CHECKED	P.A. ROSS				
APPROVED	R. Ramanamirthy				
DATE	18-02-02				
MACHINE DEEP HOLE BORING					
TITLE: PINION SHAFT-13T (φ67.5x370L)					
TYPE: PTC 400					
DRAWING No. 3-M-08F-12123					
REV. 03					
No. of Sheets					

ALL DIMENSIONS ARE IN MM

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10h6	-0.000 -0.009	ø55h6	-0.000 -0.019 +0.012 -0.007 -0.018 -0.061	ø65k6	+0.021 +0.002 +0.018 +0.002 -0.340 -0.530	$3.2/\sqrt{1.6/0.8}$
		ø52j6		ø50k6		
		16P9		ø60t11		



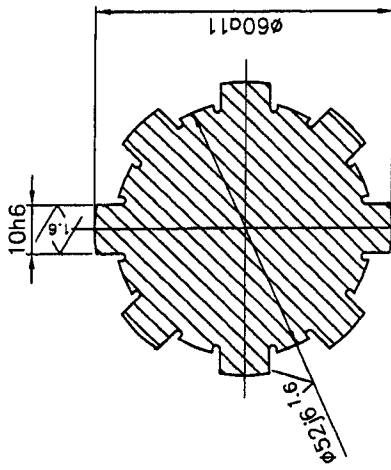
M20-50DEEP

NOTE:-

CHAMFER THE EDGES TO 1/45°  
HARDEN TO HRC40 #2

A

A



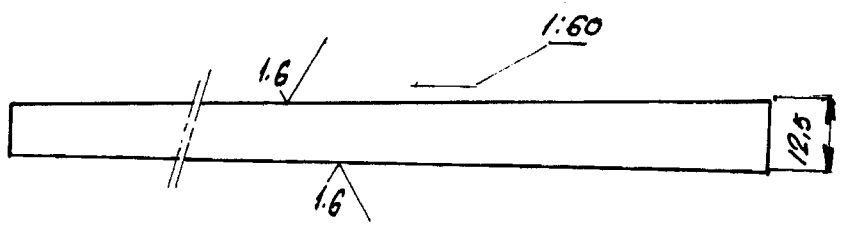
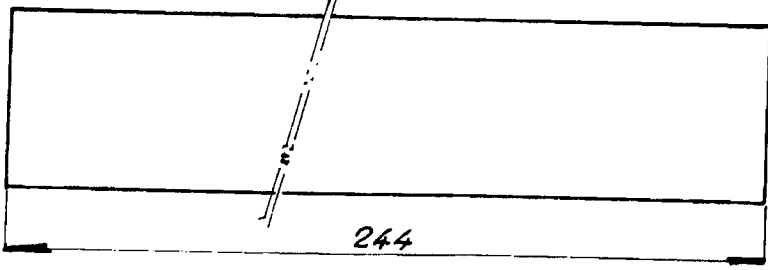
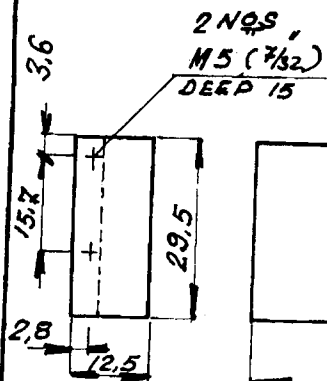
SECTION-AA

ø72x590L	55C8	IS: 5517	11.50	1-M-08F-00963	33
DESCRIPTION	MATERIAL	STANDARD	NET.WT IN KGS.	DRAWING No.	TEN No.
REFERENCE:		COMPONENT CODE: 02		EQUIPMENT CODE: 03	
SCALE	DRAWN	CHECKED	APPROVED	DATE	INDEX
1:1				04-03-2003	
MACHINE: DEEP HOLE BORING LATHE					
TITLE: SPLINE SHAFT (HEAD STOCK ASSY)					
DRAWING No: 3-M-08F-12252					
REV. 03					
Sheet No: 03					


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 TIRUCHIRAPALLI-14

3.2 / 1.6



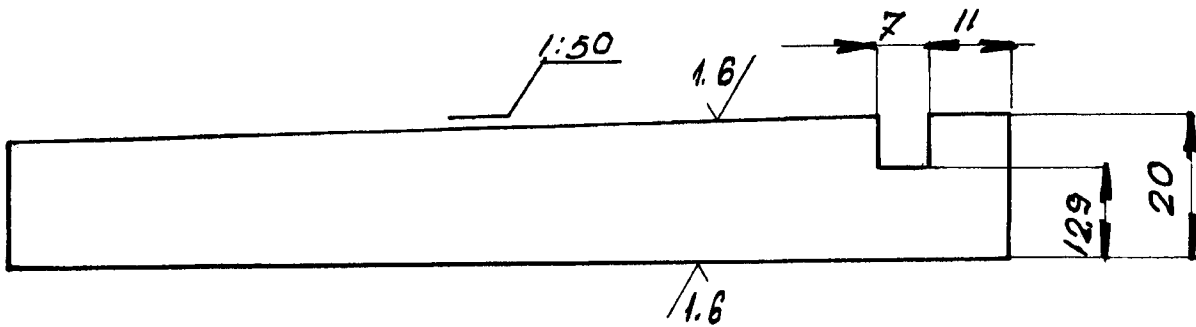
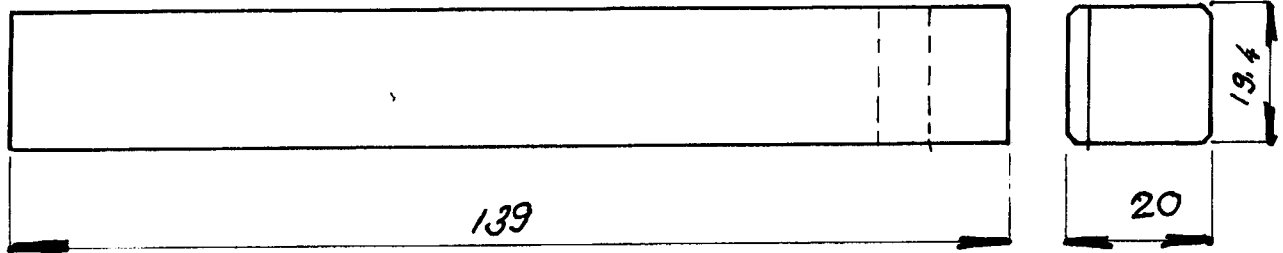
REFERENCE ONLY  
 NOT FOR MANUFACTURE

		BN-CAR							
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
REMARKS			TOTAL NET Wt (kg)						
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
1:1	<i>V. Radhakrishnan</i>								
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	15.7.1976							
MACHINE		DEEP HOLE BORING LATHE		TYPE: 60-BFLB		INV. NO.			
TITLE:		GIB		DRAWING NO. 03		4-M-082-15683			
		(PRESSURE HEAD SLIDE)		NO. OF SHEETS		SHEET NO.			

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 TIRUCHIRAPALLI-14

3.2 / 1.6



		BN-CA 2							
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.

REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	REFERENCE	ALTERATIONS	DATE	SIGNATURE	INDEX			
1:1	<i>P. R. Adlakshman</i>								
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	15. 7. 1976							

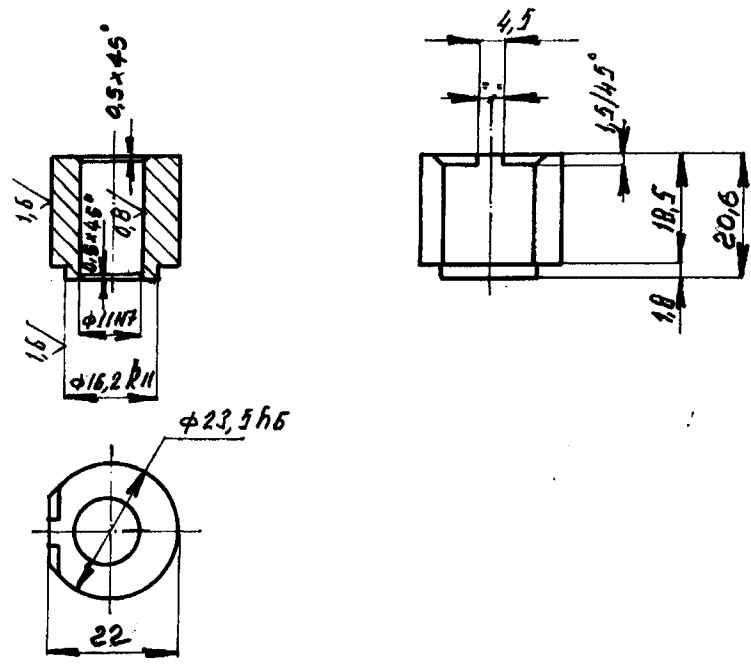
	MACHINE DEEP HOLE BORING LATHE	TYPE: 60-6FLB	INV. NO.
	TITLE: <b>GIB</b> (COMPOUND REST SLIDE)	DRAWING NO. <b>4-M-082-15684</b> <sup>03</sup>	
	NO. OF SHEETS	SHEET NO.	

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**TIRUCHIRAPALLI-14**

32/16/08

$\phi 23,5 h6$	-0,000
	-0,043
$\phi 16,2 R11$	+0,110
	+0,000
$\phi 11 H7$	+0,018
	+0,000



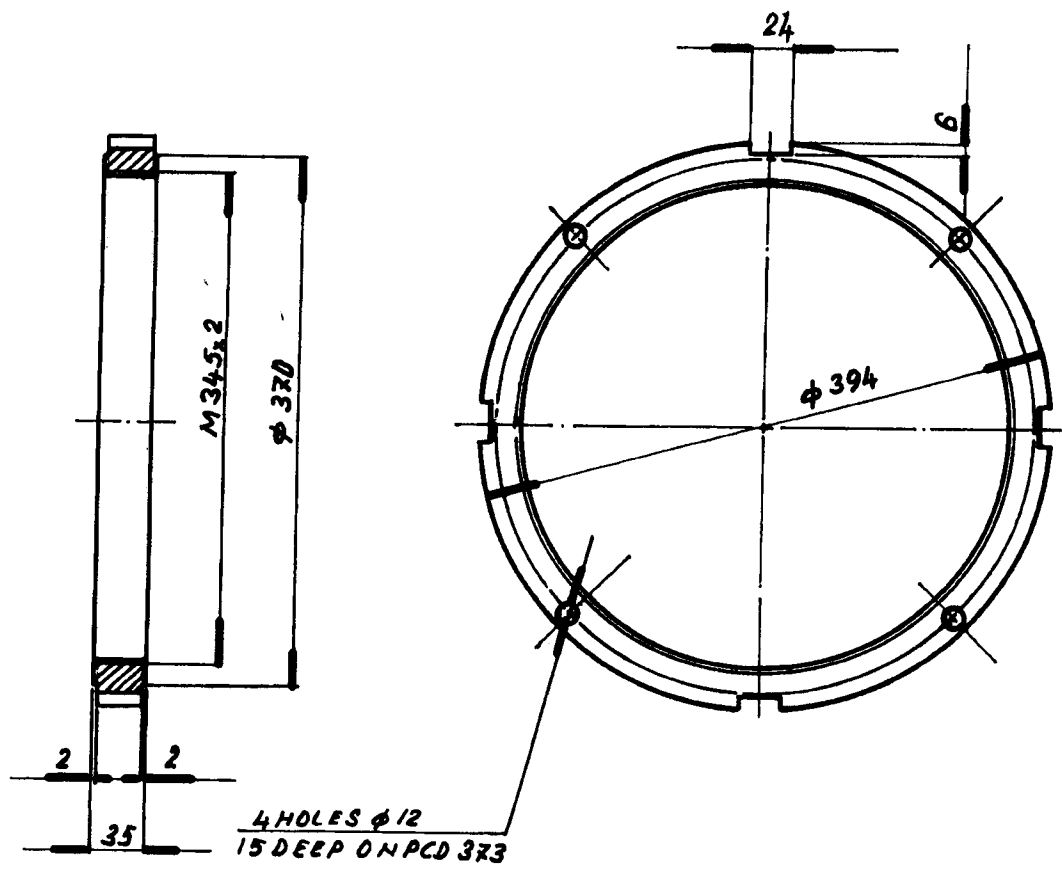
		AL. ALLOY							
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GRDSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg)					
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
1:1	G. Subramanian								
	CHECKED								
	APPROVED								
	SYDS. OFFICER								
	DATE	18-5-78							
MACHINE JEEP HOLE BORING LATHE				TYPE: 606FLB		INV. NO.			
TITLE: BUSH				DRAWING NO.		4-M-08 <sup>03</sup> -17518			
NO. OF SHEETS				SHEET NO.					



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**TIRUCHIRAPALLI-14**

32/



		CL# 15:1825				2-M-08F-1872		26	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
1:5	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	21.12.1978							
MACHINE DEEP HOLE BORING LATHE		TYPE: 60-6 FLB		INV. NO.					
TITLE:		NUT M345x2		DRAWING NO.		03		166	
NO. OF SHEETS		SHEET NO.							

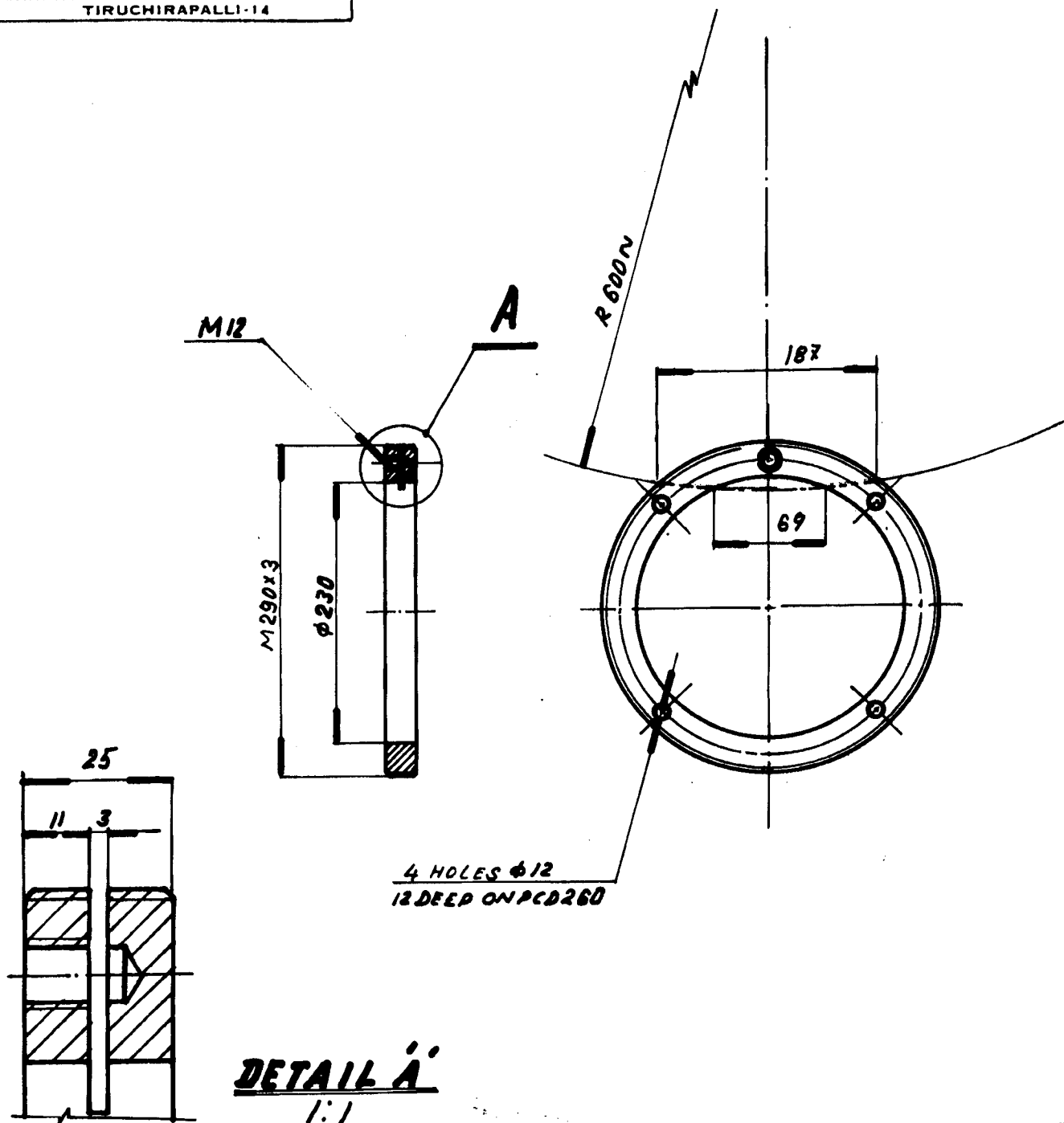


IRUCLA NO. 32 \* 807

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**TIRUCHIRAPALLI-14**

3.2



**DETAIL A**  
1:1

		CR 15/1075				2-M.08J-1832		27	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE <b>1:5</b>	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED								
	APPROVED								
	STDS. OFFICER								
DATE		21.12.1978							
MACHINE DEEP HOLE BORING LATHE				TYPE: 60-6FLB		INV. NO.			
TITLE:		<b>NUT M290x3</b>		DRAWING NO.		<b>4-M-08J-18304<sup>03</sup></b>		107	
NO. OF SHEETS				SHEET NO.					

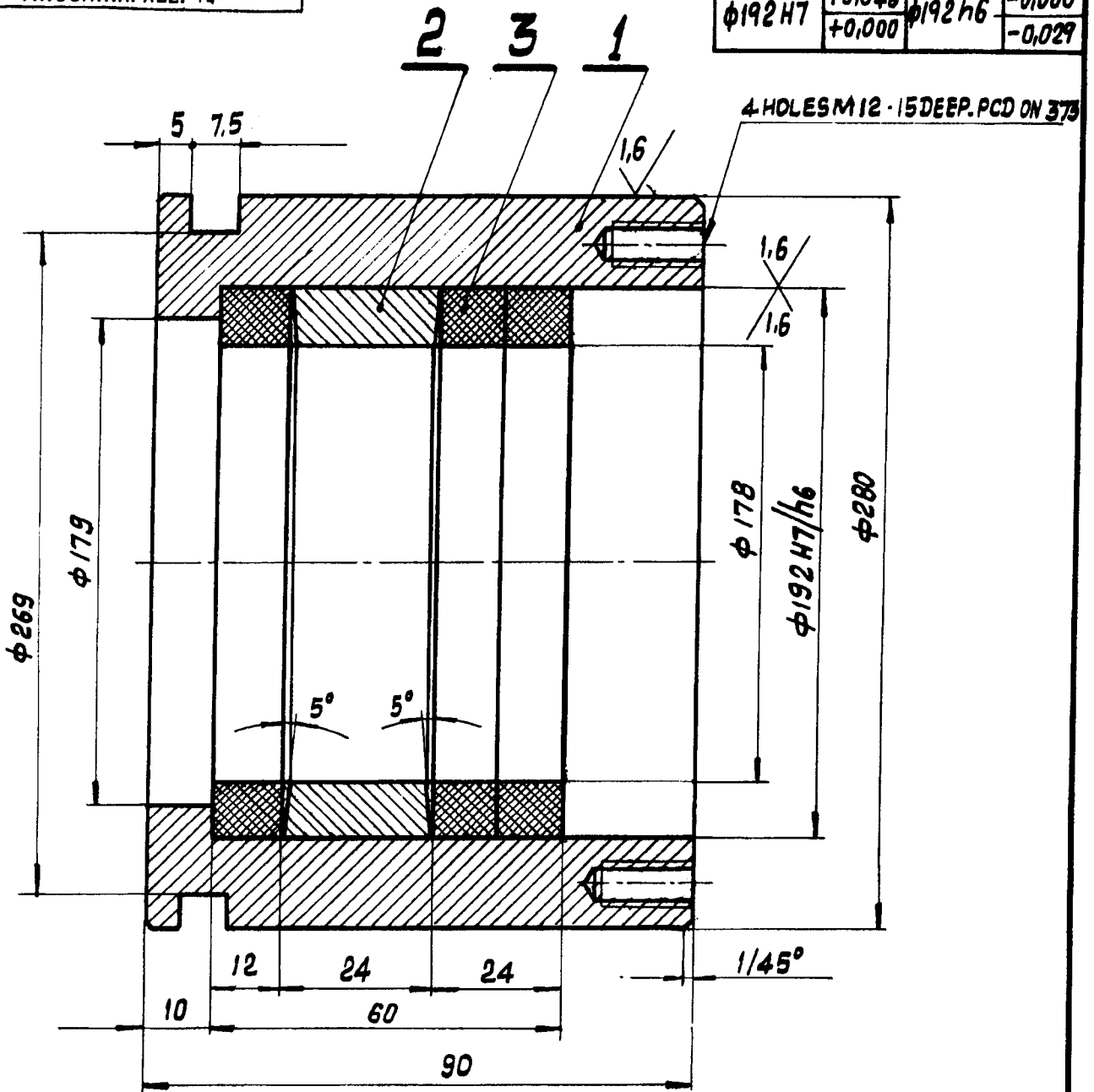


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**TIRUCHIRAPALLI-14**

3.2 / 1.6

φ192 H7	+0,046	φ192 h6	-0,000
	+0,000		-0,029



NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
3	PACKING		ASBESTOS						3
1	BUSH		PCu Sn 7 15:2B						2
1	GUIDE BUSH		C40 15:20F3						1
								2-M-08f-1832	3

REMARKS				TOTAL NET Wt (kg)			
SCALE	DRAWN	REFERENCE		ALTERATIONS	DATE	SIGNATURE	INDEX
	CHECKED						
	APPROVED						
	STDS. OFFICER						
	DATE						



MACHINE DEEP HOLE BORING LATHE

TITLE:

**GUIDE BUSH**

TYPE: 60-6 FLB

DRAWING NO.

**4-M-08f-18329**

INV. NO.

NO. OF SHEETS

SHEET NO.

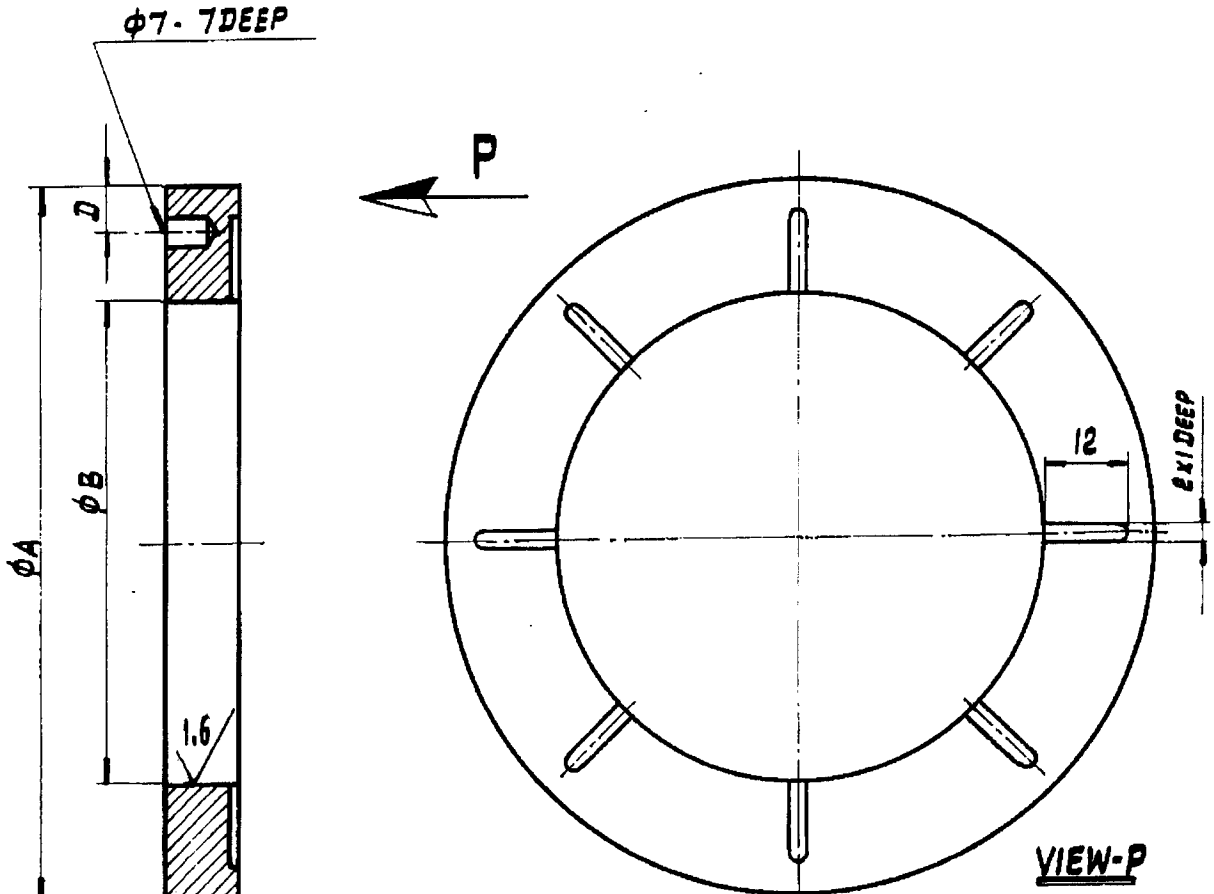
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 TIRUCHIRAPALLI-14

3.2 / 1.6

$\phi 280 H7$   $+0.052$   
 $+0.000$



THRUST COLLAR NO	A	B	C	D	PART NR
1	316	280 H7	10	6.5	
5	444	406 H7	12	10	
6	443	404 H7	12.2	10	
2	405	365.5 H7	11.5	10	48-11665-00
3	365	325.5 H7	12	10	48-11660-00
4	286	250 H7	9.7	9	48-11650-00

NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
			15:28 Gr. PCuSn7					2-M-08f-1832	12

REMARKS				TOTAL NET Wt (kg)			
SCALE	DRAWN	REFERENCE		ALTERATIONS	DATE	SIGNATURE	INDEX
	CHECKED						
	APPROVED						
	BTDS. OFFICER						
	DATE						

	MACHINE DEEP HOLE BORING LATHE	TYPE: 60-6FLB	INV. NO.
	TITLE: <b>THRUST COLLAR</b>	DRAWING NO. <b>4-M-08f-18331</b> <sup>03</sup>	
	NO. OF SHEETS	SHEET NO.	

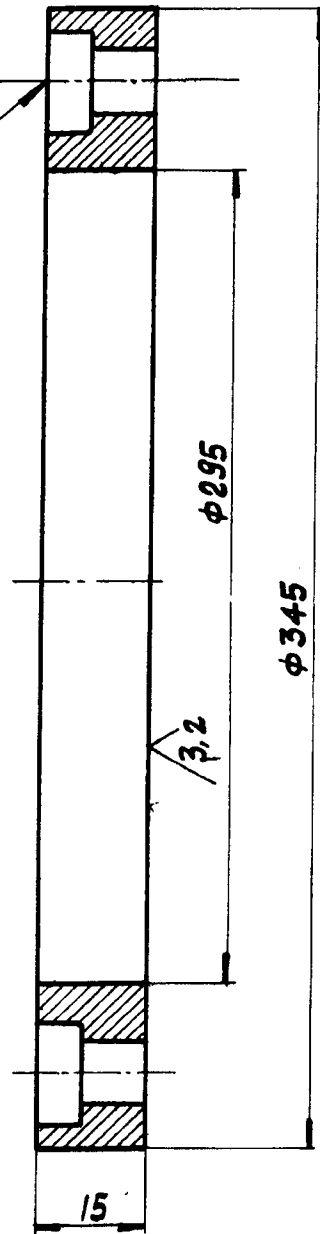
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 TIRUCHIRAPALLI-14

6.3 / 3.2

6 HOLES  $\phi 9$  - CBR  $\phi 14.5$  - 9 DEEP  
 ON PCD 325



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		IS: 1875 Cl III				2-M-08f-1832		14	
ND. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SDRT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
/	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	28-12-1978.							
MACHINE DEEP HOLE BORING LATHE				TYPE: 60-6 FLB		INV. NO.			
TITLE: <b>FIX RING</b>				DRAWING NO. <b>4-M-08f-18332</b> <sup>03</sup>					
NO. OF SHEETS				SHEET NO.					

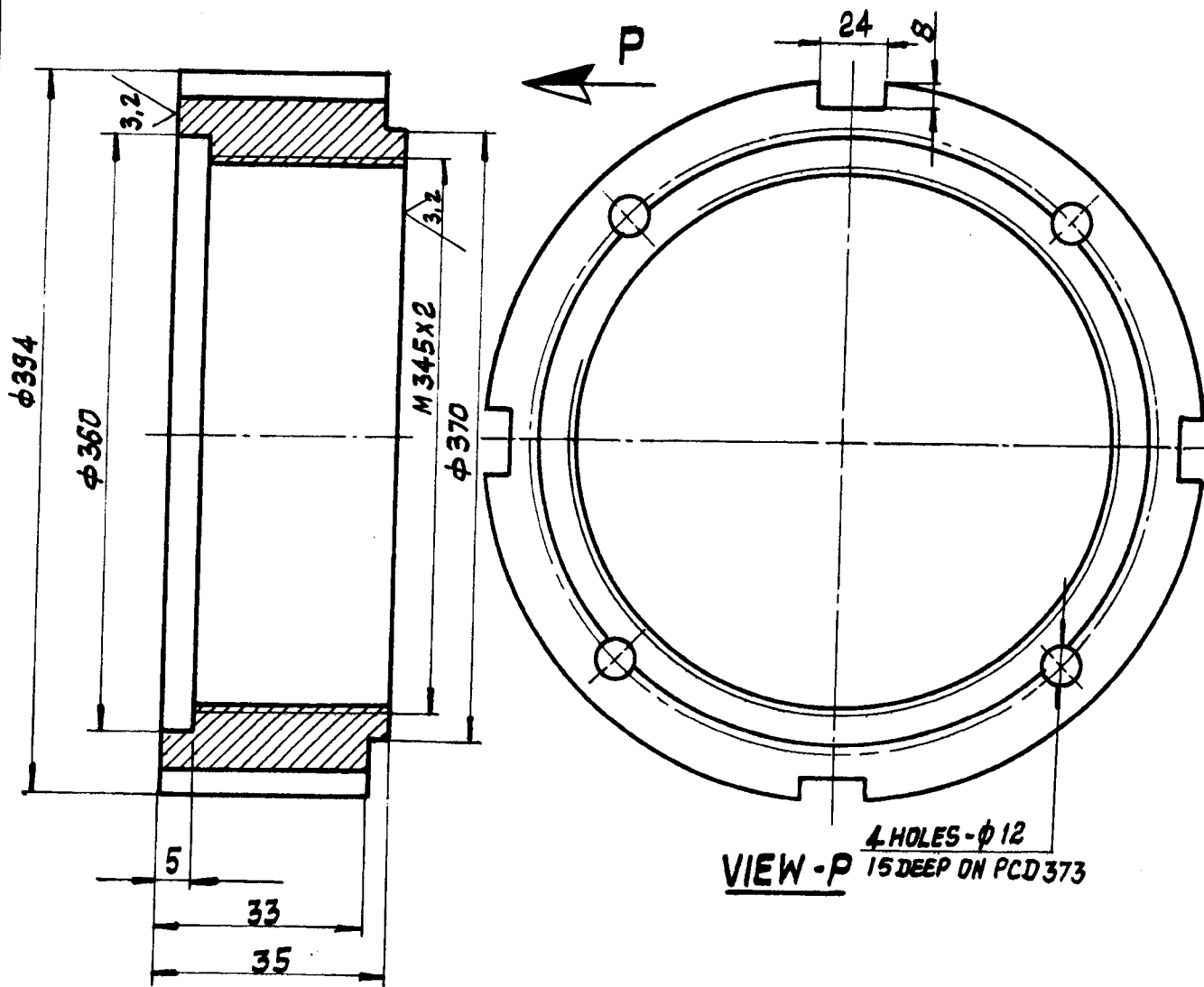


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**TIRUCHIRAPALLI-14**

6.3 / 3.2

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		IS: 1875 cl III				2-M-08f-1832		25	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET wt (kg)					
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	29-12-1978.							
MACHINE DEEP HOLE BORING LATHE		TYPE: 60-6 FLB		INV. NO.					
TITLE: <b>NUT M345x2</b>		DRAWING NO. <b>4-M-08f-18333</b> <sup>03</sup>							
NO. OF SHEETS		SHEET NO.							



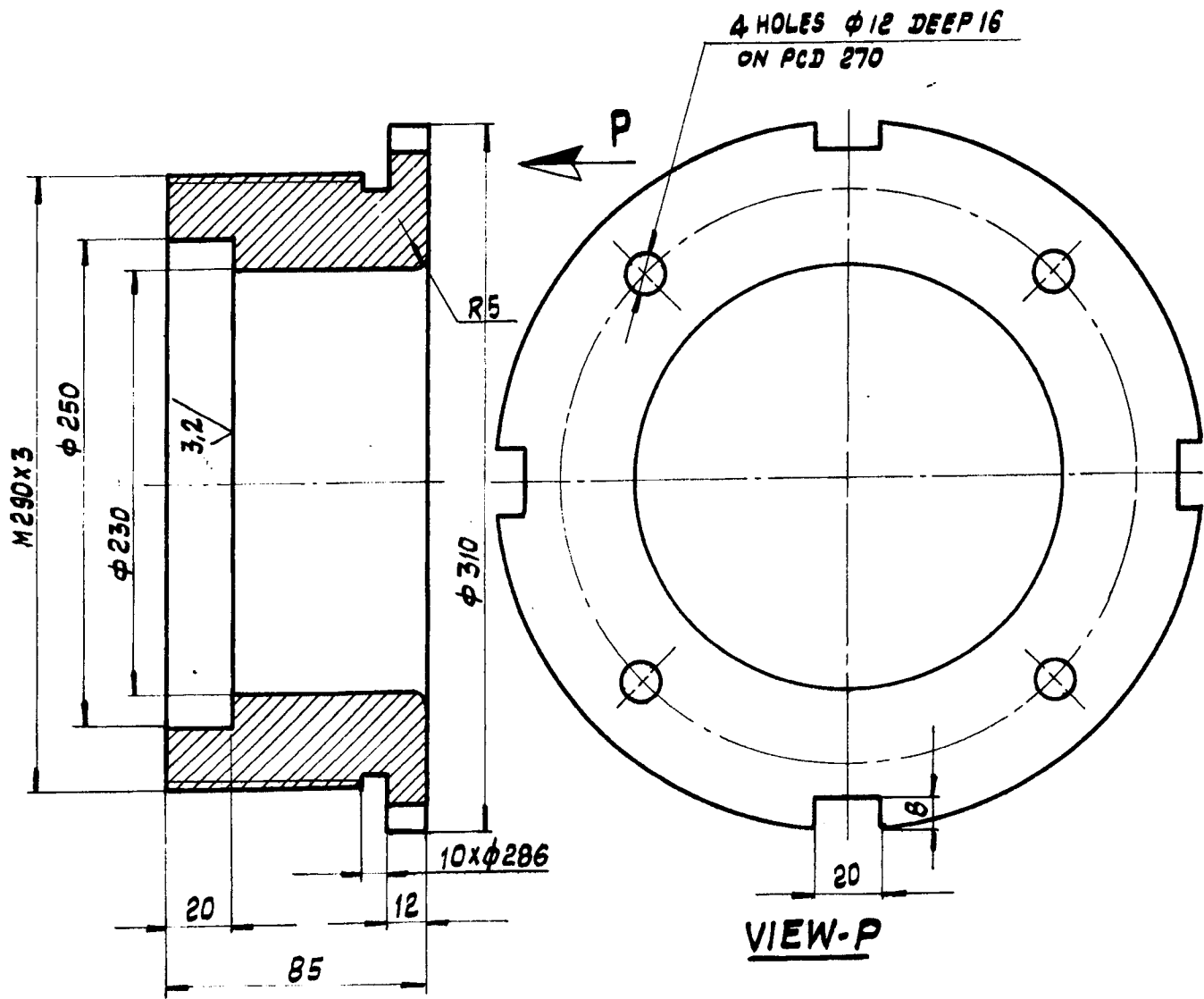
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**TIRUCHIRAPALLI-14**

6.3

3.2

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		C 40 15:2073				2-M-08f-1832		2	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt(kg)	GROSS Wt(kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE	DRAWN	REFERENCE		ALTERATIONS		DATE	SIGNATURE	INDEX	
	CHECKED								
	APPROVED								
	STDS. OFFICER								
	DATE	28-12-1978.							
MACHINE DEEP HOLE BORING LATHE			TYPE: 60-6 FLB		INV. NO.				
TITLE: <b>NUT M290X3</b>			DRAWING NO. <b>4-M-08f-18334</b>		03				
NO. OF SHEETS			SHEET NO.						

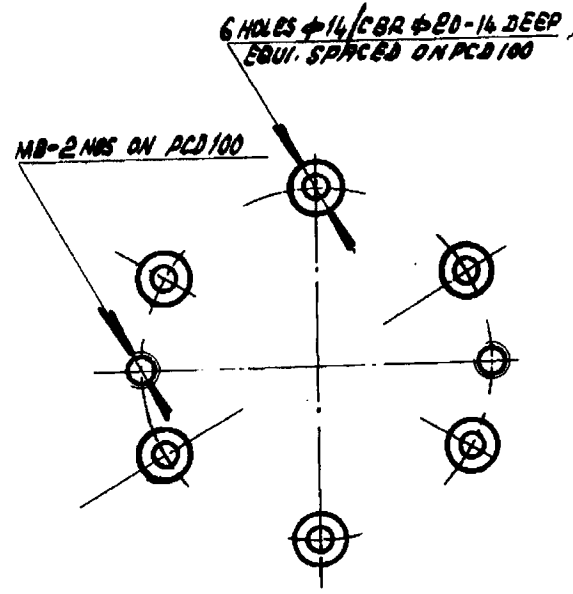
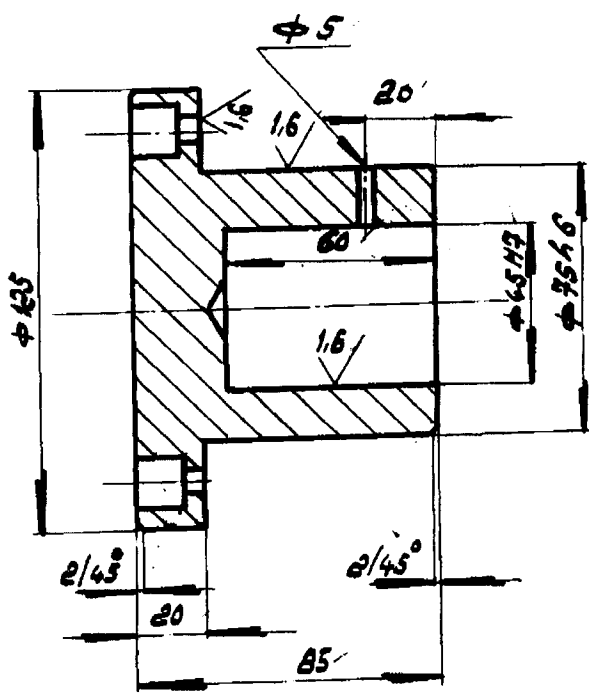


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 TIRUCHIRAPALLI-14

32 / 16

φ 45 H7	+0,025
	+0,000
φ 75 h6	-0,000
	-0,019



			BM-C45			J-M-08F-987		71	
NO. OF PIECES	DESCRIPTION	SEMI-PRODUCT	FINAL MATERIAL	INITIAL MATERIAL	SCRAP SORT	NET Wt (kg)	GROSS Wt (kg)	DRAWING NO.	ITEM NO.
REMARKS				TOTAL NET Wt (kg)					
SCALE 1:2	DRAWN	<i>H. S. S.</i>		REFERENCE	ALTERATIONS		DATE	SIGNATURE	INDEX
	CHECKED	<i>S. S. S.</i>							
	APPROVED	<i>K. S. S.</i>							
	STDS. OFFICER	<i>K. S. S.</i>							
DATE	5-3-80								
MACHINE DEEP HOLE DRILLING LATHE			TYPE: 60-6 FLB		INV. NO.				
TITLE: <b>END COVER</b>			DRAWING NO. 03		<b>4-M-08F-19420</b>				
NO. OF SHEETS			SHEET NO.						



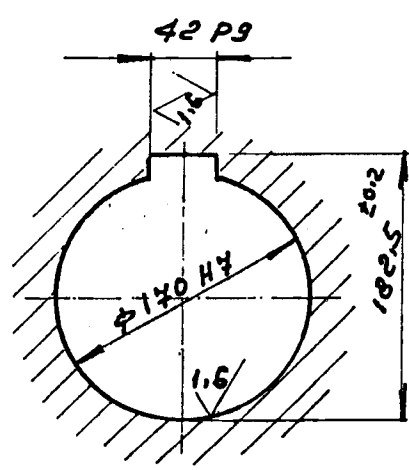
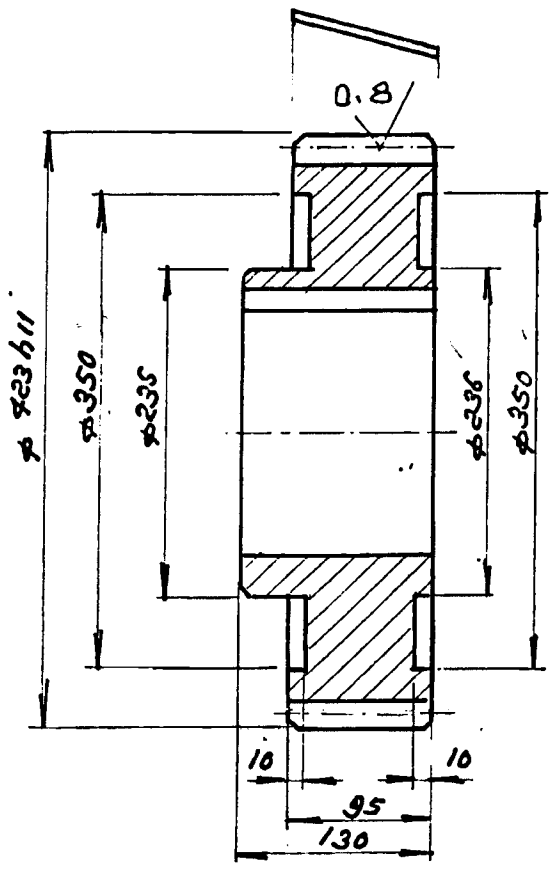
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39-607 A

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42 P9	-0.1025	φ 423h11	-0.000
	-0.053		-0.030
		φ 170H7	+0.046
			-0.000

3.2 / 1.6 / 0.8



NO. OF TEETH	66
MODULE	06
PR. ANG	20°
HAND OF HELIX	RH
HELIX ANGLE	18°
CORRECTION FACTOR	-0.5
WIDTH A/C 9 TEETH	154.9
QUAL. & TOL. ZONE	8E DIN. 3967
MATING GEAR NO. OF TEETH	18
MATING GEAR DRG. NO.	J-M-08F-11666
CENTRE DISTANCE	265

CHAMFER ALL SHARP CORNERS TO 1/45°  
HARDENED TO HRC 28±2

		45 C2	10:5517	60:29			
					1-M-08F-0963	15	
NO. OF	DESCRIPTION	MATERIAL	STD/BPS	DATE	DRAWING No.	Item	
REFERENCE:	ALTERATIONS		CC: 03	EC: 03	DCN	DATE	SIGN. INDEX
SCALE	DRAWN	CHECKED	APPROVED	DATE			
1:5	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	07-06-98			
MACHINE: CENTRE LATHE		TYPE: 60-6-FLB (PTC-400)		Total wt. (kg.)			
TITLE		DRAWING No.		REV.			
HELICAL GEAR 66T		03					
(φ 423 x 130)		4-M-08F-26205					
(HEAD STOCK ASSY)		No. of Sheets:		Sheet No.			

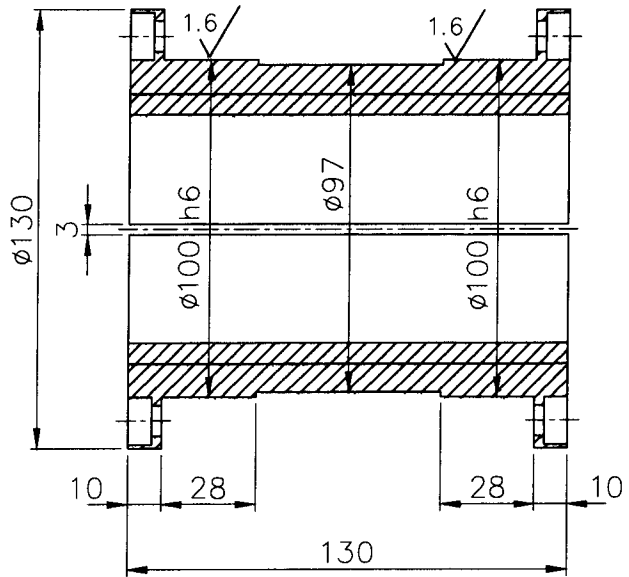
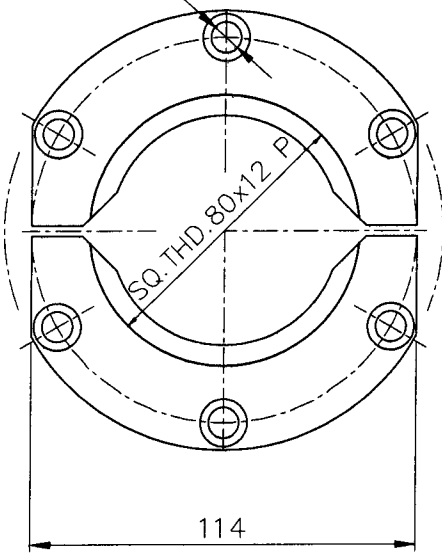
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ALL DIMENSIONS ARE IN MM

ø100 h6	-0.000
	-0.022

3.2//1.6/

6HOLES ø9/CBR ø14-7DEEP  
ON PCD 100



NOTE:  
SHARP CORNERS TO BE REMOVED 1/45°

		PCu.Sn.7	IS: 28	-			
No. of Pieces	DESCRIPTION		MATERIAL	STANDARD	NET.WT.IN KGS.	DRAWING No.	ITEM No.
	REFERENCE:		ALTERATIONS:		DCN REF	DATE	SIGN.
SCALE 1:1	DRN.	P.Albert Ross					
	CHD.	G.Govindaraj					
	APPD	K.Ramanan					
	DATE	30/08/12					
MACHINE: DEEP HOLE BORING LATHE/60-6 FLB			TYPE: PTC-400				
	TITLE: BOX NUT SQ.TH.D.80x12 P (APRON ASSY.)		DRAWING No: 4M08F0329521			REV.	