

ANNEXURE-A

VENDOR SCOPE OF WORK:

- Dismantling of existing test rig.
- Blue matching of casing by scraping as required. Assembly of new stage diaphragms with compressor casing & alignment.
- Assembly of two journal bearings and thrust bearing with the bearing housing and alignment of the bearings by maintaining proper clearances & tolerances.
- Removal of old impeller from the shaft and shrink fitting of new impeller on the shaft for testing and combined run-outs (dynamic balancing of combined shaft, adaptor & impeller).
- Installation of rotor shaft assembly boxing-up and alignment. Installation of coupling & torque meter between the gear box & rotor shaft and alignment as required.
- Continuous trial run at 9000 rpm for 4 hrs.

BHEL WILL PROVIDE THE FOLLOWING:

1. All the drawings, necessary details whenever required.
2. All spares required during execution of the job
3. Special T & P like slings & spanners.
4. EOT Crane along with operator etc.
5. Work shop facility for any machining jobs.
6. Gas cutting & welding jobs.
7. D.A. & Oxygen cylinders shall be provided.
8. Sealants like , Hylomer tubes, RTV Compound, molykote etc.
9. Consumables like Rustoline, Diesel, Emery paper, old cotton cloths, welding electrodes etc.
10. Oil Gaskets, steam gas kets etc.
11. SS Shims for alignment of TG Set.
12. Fooding for vendor at your canteen.

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