

Technical Details for Supply & retrofitting of Chip Conveyor for HMC-650 Model Max pro 650
Make BFW milling CNC machine.

New Chip Conveyor required to be retrofitted in HMC-650 machine wherein combined Coolant & dual type chip conveyor (Slat & Scrapper Type Sl. No- 1966 & 1967) of Make Filcon (Drawing No- 23307523) is installed (Refer Machine layout & conveyor tank details attached). The scope of work shall include supply, retrofitting, commissioning & testing of Chip conveyor as per details mentioned under:

1	Pitch of Chain	50 mm (Minimum)
2	Load section length	Minimum 1900 mm
	Max Cross-section height	300 mm
3	Chain width	500 mm +/- 10% (approx) with heavy duty rollers/pin/links.
4	Overall Conveyor Length	4250 +/- 10% (approx) including the load & incline section.
5	Thickness of conveyor tank sheet/body & connecting duct.	Minimum 3 mm
6	Motor gear box	Geared motor of Make Bonfiglioli with limit switch of TEKNIC Euchner/ Balluff / Telemacanique/ Siemens/L&T Make only.
7	Mechanical overload protection	The new Chip conveyor should have limit switch for mechanical overload protection.
8	Colour	Apple Green

- Combined Slat & scrapper Hinge type steel belted chip conveyor with scrapper at every 250-300 mm. The scrapper should be suitable for removing chips generated in milling operations.
- The vendor has to retrofit above supplied chip conveyor with existing Chip conveyor using MS duct of cross sectional area of approx 200 mm x 200 mm (approx) (included in scope of vendor) & total length of 5 meter (in L Shape). The duct should have fine mesh filter (02 Nos. fitted + 02 Nos. Spare) to restrict movement of chips in coolant tank.
- The conveyor should have sprocket with sealed ball bearings on motor & non drive ends.
- The Chip conveyor should be supplied without any chip bin which will be arranged by BHEL.
- The Chip conveyor should have control panel for operation.

Terms & Conditions:

1. The successful vendor may visit the site for measurement after placement of PO & has to submit final G.A. Drawing within 30 days of issue of same. The inspection & vetting of G.A drawing by BHEL shall be necessary before dispatch of material by vendor.
2. The vendor should quote the Commissioning Charges separately (including accommodation & lodging charges, Travel & local travel charges.). On receipt of Chip conveyor at BHEL Varanasi, the vendor shall be intimated by BHEL HERP for commencement of installation & commissioning work. The vendor shall complete the retrofitting work within 30 days of receipt of intimation else, a penalty @ 0.5% of above service Charges only (LD on supply shall be as per standard LD clause of BHEL) per week shall be deducted (subject to maximum of 10%).
3. The retrofitting, installation & testing work should be completed by vendor for which total shutdown of machine for 24 hrs will only be provided at a stretch. BHEL Varanasi reserves the right to fix the date for next shutdown as per production load on machine.
4. The vendor shall arrange for all T&P required for commissioning & prove out at HERP. However facility of welding, material handling after receipt at BHEL Stores shall be extended on free of cost basis.
5. Final acceptance of the equipment will be given by HERP Varanasi after commissioning & prove out at BHEL HERP Varanasi.

Total: 03 pages

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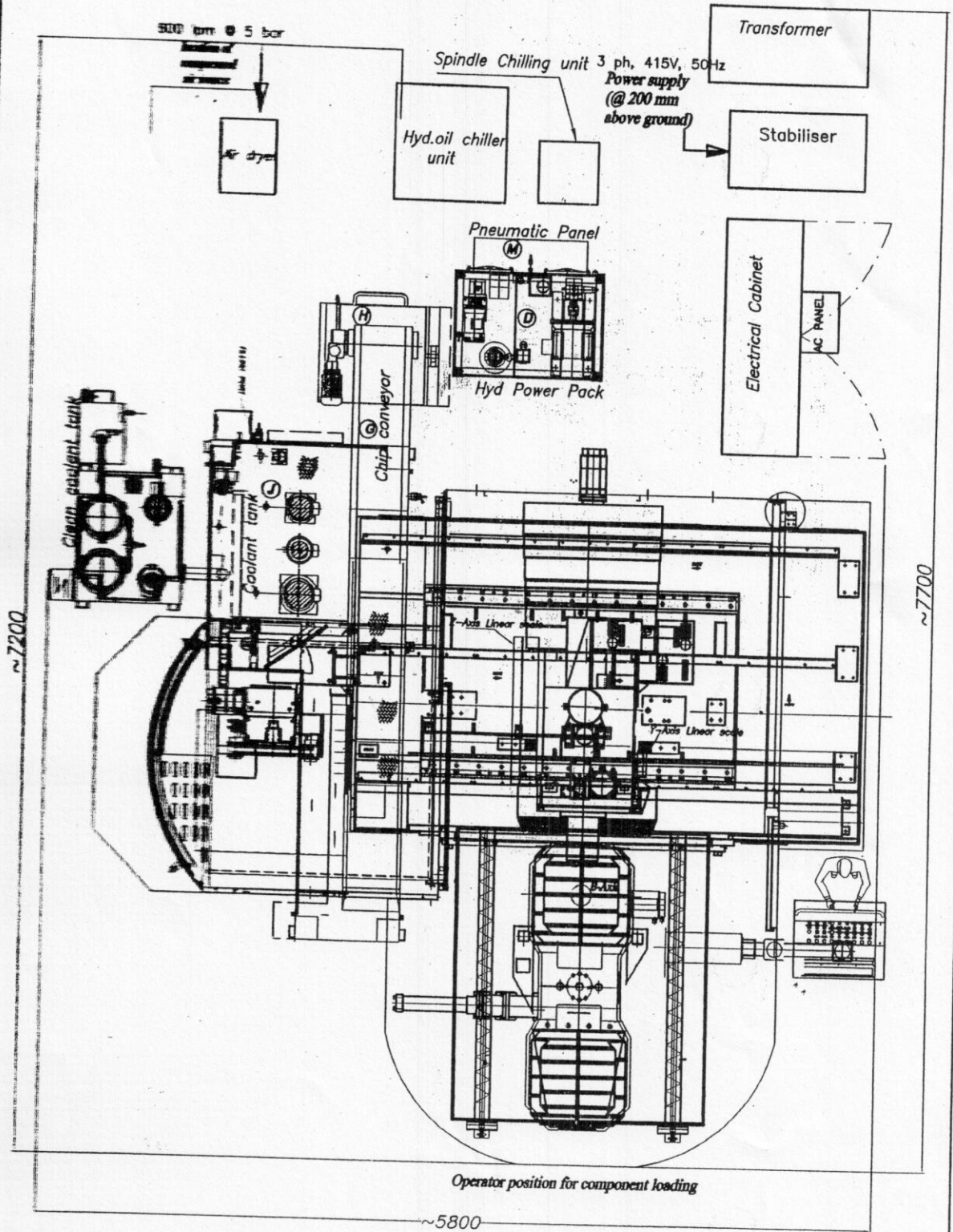
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Reading



Machine Layout - Floor plan

MPH650



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Drawn : GM
 Approved : VRH
 Date : 20.01.07

Ryadh

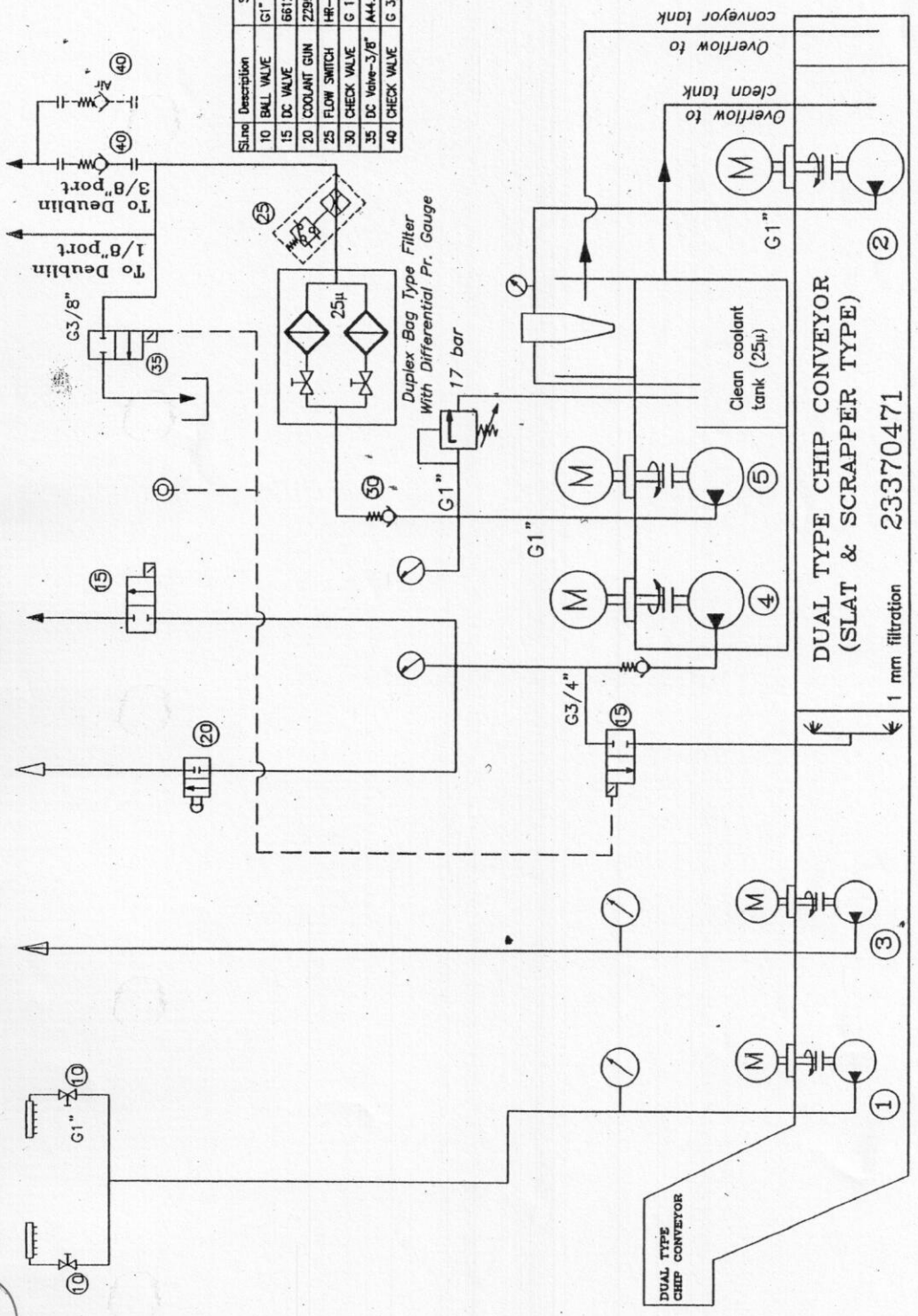
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Prashant

COOLANT THROUGH TOOL

FLOOD COOLANT

SHOWER WASH

BEED WASH



S/No	Description	Specification	Qty	Make	C.P. No.
10	BALL VALVE	G1"	2	CM ITALY	48779119
15	DC VALVE	6612025/54/BSP/3MSV(NC)/24 VDC	1	AVCON	48770431
20	COOLANT GUN	Z299 12 01 G1/4"	1	LEGOS	48780883
25	FLOW SWITCH	HR-15-KI	1	SWITZER	27901339
30	CHECK VALVE	G 1" ports	1	CM	48782816
35	DC Valve-3/8"	A44-46.TT.BT/90.05.DM/SV	1	AUDCO	27910884
40	CHECK VALVE	G 3/8" BSP ports	2	Fairtech	27910850

- 3HP, 2900 RPM
200LPM@2 BAR H10 = S
RK-6/311
- 2HP, 2900 RPM
100LPM@2 BAR
RK-5/311
- 1.5HP, 2900 RPM
100LPM@ 1.25 BAR
RKM-252
- 2.66HP, 2900 RPM
60LPM@ 4 BAR
RKM-255/445
- 3HP, 2900 RPM
25LPM@ 16 BAR
CRK 2-220/22

DUAL TYPE CHIP CONVEYOR
(SLAT & SCRAPPER TYPE)

23370471

Alterations		M/N		Customer		Drawing No.		RL	
Advice No	Checked	PMN	PMN	M/5 B.H.E.L., VARANASI-5862	23307523	00	Sheet No.	1 / 1	8
Area	Approved	ANB	ANB						
Date	Date	23.02.2007	23.02.2007						
Name	Machine type	MPH650	MPH650						

Coolant Circuit Diagram



HEAVY EQUIPMENT REPAIR PLANT, VARANASI

Annexure-B

PRE QUALIFYING CRITERIA (PQR)

S.N	PQR & Warranty Clause	Our requirement	Vendors Comment
1	The Vendor should be Original Equipment Manufacturer and should have registration with Central Excise.	Vendor to submit details with Excise, Sale Tax, CST registration details.	
2	The vendor should have supplied similar/higher rating item to any Public sector undertaking/ Public limited or Government organization during last 03 years.	Vendor shall provide copy of PO & performance certificate and contact details of authorized person in concerned organization.	

Amr-8 (11)

R. K. Mishra