

**BHARAT HEAVY ELECTRICALS LIMITED**  
**HEAVY POWER EQUIPMENT PLANT,**  
**RAMACHANDRAPURAM, HYDERABAD – 502032**

**Notice No.- HY/AGM/EOI/1**

**03.03.2011**

**Sub** : Expression of interest for annual breakdown & Preventive maintenance of machine tools used for Steam turbine ,Compressors and Gas turbine manufacturing shop (01 SHOP).

Services from Interested Parties are required for Annual Maintenance contract (Breakdown & Preventive maintenance of **Conventional ,CNC and Special purpose machine tools used for Steam turbines ,Compressors and Gas turbine manufacturing shop** (Block 01) )as per details given below:

1. CNC Machines: 15 Nos.
2. No. of conventional m/c's 169 nos. (Total = 184 and DRO's= 50 nos)
3. No. of Shifts: 03 plus Sundays and Holidays.
4. Proposed minimum period of contract: 24 Months

Interested parties may submit their proposals detailing (a) Management & Commercial Terms and conditions, (b) Budgetary offer. Technical suitability of the received offers shall be evaluated for further action. Parties may visit the plant between 8 AM and 3 PM except on Sundays & Holidays before submitting their expression of interest. Interested parties must submit their Expression of interest in sealed envelope to the under mentioned person on or before 4.00 PM , 24/ 03/ 2011. For any other clarification please contact:

Contact Person:-

**A.B Ravichandran**  
**AGM/PRODN & SERVICES**  
**HPEP, BHEL,**  
**RAMACHANDRA PURAM ,**  
**HYDERABAD- 5020032**

Phone: 04023183401,23184099. CELL.NO:09490165771,,09490165778

Email: [abrchandran-h@bhelhyd.co.in](mailto:abrchandran-h@bhelhyd.co.in)

**NAME OF WORK: Expression of Interest for Annual Break Down & Preventive Maintenance of Special purpose machine tools used for Steam turbines ,compressors and Gas turbine manufacturing shop.**

**1. SCOPE OF WORK :**

Annual Maintenance contract (Break down & Preventive maintenance) of CNC's and conventional machine tools listed below to ensure its Annual Average Availability of more than 95% in trouble free running condition on three shifts basis.

**Types of machines:**

<b>SL.NO</b>	<b>Machine description</b>	<b>No of machines</b>
1	Lathe machines(H22,B32,NH22,L22,LB20 ,L45,L50,SU 63,BOMBAY 63,SRM 125, SR 2000,S3150,DP3150 etc..)	24
2	Grinding machines( G17,G22,CENTERLESS GRINDING MACHINE, GVS 30,BPV 700,BRH 40,PRAGA GRINDER,SFW etc)	17
3	Milling machines(M2V,M2H,M3H,FA4V,BFW 3.5,FD40,FB40,FC63,FB50, FGSH 50,TOS DUPLEX	24
4	Thread rolling machine	1
5	Radial drilling machines, (VR4,RM52,RM 55,RM65,A WHEEL DRILLING ,PRAGA DRILLING)	9
6	Slotting machines (Cooper slotting,wmw slotting machines)	2
7	High speed thread cutting machine	1
8	Welding generators K320,welding rectifiers	8
9	Tig welding machine	2
10	Welding manuplators	3
11	Fume extraction system	1
12	Horizontal boring machines( H100, W100,BH100,BH130,HP80)	7
13	Planing machines(FP16,FP 20,BECO PLANNER)	3
14	Vertical boring machines(CVT 150,SK12,SK25)	4
15	Metal arc distringetor	1
16	Special purpose machines(CINCINNATI 100,300,400 MILLING M/S, STARRAG ST 124,KA200,ST144/9,ST144/E,BROACHING M/C,BATIBIO 2 SPINDLE,4 SPINDLE MILLING ,)	13
17	Tumbler vibrator	1
18	Power saw	2
19	Shot pining machine	1

20	Motorised rollers (8 TONS,20 TONS,50 TONS)	6
21	TOOL AND CUUTER GRINDING MACHINE (HMT AND TOS)	6
22	Induction Heating equipment (Inductotherm)	1
23	MACHINING CENTRE OKK JAPAN,CNC ( FUNUC 0I)	1
24	3D COPY MILLING M/C CNC(SEIMENS 802DSL)	1
25	SBC CNC LATHE(HINNUMERIC2000)	1
26	VERTICAL LATHE PAL COOPER CNC(SEINOMERIC 840C)	1
27	VERTICLE LATHE KBL CNC(SEINOMERIC 840C)	1
28	WH N 10.CNC HORIZONTAL BORING M/C(HADDIEN)	1
29	CNC HMC 630/630 MACHINE (SEIMENS 840D)	1
30	COPY MILLING M/C-HELLER(FAGOR 8040)	1
31	CNC MILLING M/C-BFW(FAGOR 8040)	1
32	CNC MILLING M/C BATLIBOI(FAGOR 8040)	5
33	CNC L.P. BLADES DRILLING M/C(SEIMENS 802D)	1
34	Misllaneous machines(Pedestal grinders ,polishing machines and portable drilling machines ,etc.	30
35	20 ton electrical trolley	2
	Total no. of Machines	184

*	Upkeep ,retrofit and maintenance of DRO's and connected feedback systems in 01 shop( make consisting mainly ELECTRONICA and GIVI MISIRE)	50
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2. Machine Tools are installed in Bay-3, Bay-4, Bay-5 and Bay-6, miscellaneous equipments

and DRO's are for the entire 01 block .

3. Each work center shall be supervised by one competent supervisor and the total work shall be supervised by an engineer in each shift.

4. Three shifts manning with adequate workforce.

5. Preventive maintenance of machine tools are to be carried out as per schedule and Preventive maintenance check list. Party shall fill up the relevant formats and check lists during the course of preventive maintenance.

6. Breakdown maintenance of the machine tools is to be carried out in three shifts.

7. Party shall have experienced ( at least one year annual maintenance contract and shall have experience of reconditioning of above types of machines Sl.no 1 to 35 )of manpower including Engineer, Supervisor & Artisan for attending CNC/ Electronic, Hydraulic, Electrical & Mechanical problems.

## **Terms and Conditions**

1. Annual average breakdowns must be less 5% of total available hours of these machines on three shift basis.
2. All tools and tackles required for maintenance works shall be arranged by party.
3. BHEL shall supply, free of cost, all consumables like grease, lubricating oil, cotton waste, welding rod, washing/cleaning liquid, power and crane facility etc.
4. Rewinding of all electric motor will be undertaken by BHEL. Party shall arrange to deliver damaged motor and collect repaired motor from BHEL's electrical repair shop.
5. All spare parts shall be provided by BHEL free of cost Repair/ rebuilding/ manufacturing of mechanical spares/assemblies. Preparation of drawings/sketches for the same shall be done by Party.
6. Following records shall be maintained and kept ready for inspection by BHEL engineer incharge, at all times.
  - (a) Preventive maintenance records and relevant forms (Forms shall be supplied by BHEL free of cost).
  - (b) Daily log book for reporting of breakdowns, repair and handing over history.
  - (c) Machine wise list of replacement of spares.
  - (d) Any other report desired by BHEL regarding the contract.
7. Period of contract shall be for Two years duration in two parts. Initial award of contract shall be for one year. Contract may be renewed for one more year at the discretion of BHEL on the basis of performance, response etc. of party.
8. All works have to be carried out in BHEL premises.
9. No accommodation facility shall be provided by BHEL.
10. Office at site with relevant facility in BHEL will be provided .
11. Vendor has to abide by all labour laws applicable like PF , ESI and Bonus etc.
12. Parties have to deposit Earnest Money & Security Deposit based on tender value.

## **Format for Expression of Interest**

- 1. Name of Party:**
  
- 2. Address for communication:**
  
- 3. Company Profile :**
  
- 4. Engineering capability:**
  
- 5. Financial Capability:**
  
- 6. Business turnover in PSU'S:**
  
- 7. Proposed manpower deployment:**
  
- 8. Engineering and Technical Capability for proposed work:**

**Name, Signature & Contact Details of Authorized Signatory of the party.**

