

BHARAT HEAVY ELECTRICAL LIMITED

UNIT'S ADDRESS:

UNIT'S PHONE NO.:

CONTACT PERSON'S NAME/DESIGN./PHONE NO./E-MAIL
(FROM PURCHASE DEPT.)

Enquiry No.:

Due Date:

Supplier No.:

Specification Rev. No.:

Rev. Date:

SPECIFICATION CUM COMPLIANCE CERTIFICATION FOR

CAST IRON BED PLATES WITH T SLOT GROOVES ALONG WITH ANCHORING BOLTS AND JACKING SCREWS
NOTE:-

1. Vendor must submit complete information against clause no. 8.0 (Qualifying Conditions). The offer meeting this clause would only be processed.
2. The "Offered" Column and where applicable, the "Deviations" & "Remarks" Column of this format shall be filled in by the Vendor and submitted along with the offer. Inadequate / incomplete, ambiguous, or unsustainable information against any of the clauses of the specifications/requirements shall be treated as
3. The offer and all documents enclosed with offer should be in English language only.
4. All dimensions are in mm unless otherwise stated.

Prakash
18/11/13
19/11/13
(S.M. PRASAD)
Prakash
Prakash

SCOPE : SUPPLY, ERECTION & COMMISSIONING OF CAST IRON BED PLATES, SIZE 3500 MM X 1500 MM X 400 MM AS SPECIFIED BELOW					
S.NO	DESCRIPTION FOR BIEL REQUIREMENT	REQUIRED	OFFERED	DEVIATIONS	REMARKS
1.0	PURPOSE				
	Cast iron bed plates with T-slots shall be used for mounting and clamping of weld overlay system during erection.	Vendor to note			
2.0	SCOPE OF SUPPLY				
2.1	Size of Bed Plate- 1500mm x 3500mm x 400mm	Vendor to confirm			
2.2	Qty- 16 nos	Vendor to confirm			
2.3	Scope is inclusive of all anchoring bolts, jacking screws, support plates & taper wedges etc. required for grouting, leveling and joining of each plate on all the four sides.	Vendor to confirm			
3.0	TECHNICAL SPECIFICATIONS				
3.1	Cast iron bed plates shall conform to IS:10602-1983 (Edition 1.1). It shall be made from plain grey iron castings conforming to grade FG:200 of IS:210-2009. Material test certificates as required by the Indian Standard shall be submitted along with the supply.	Vendor to offer			
3.2	Designation of the Bed plates shall be :				
	Bed plate 3500 x 1500 x 400 - 22H12 - I - IS:10602.	Vendor to offer			
3.3	T-slots (4 nos in each bed plate at equal distance along 3500 length) shall conform to IS:2013-1995.	Vendor to offer			
3.4	Details of wall thickness, ribbing pattern, leveling pockets and method to join the plates shall be informed by the vendor.	Vendor to offer			
3.5	The access holes for leveling shall be suitably closed, to avoid entry of coolants, dust, chips etc. into the pockets.	Vendor to offer			
3.6	Load bearing capacity of the bed plate shall be specified by the vendor.	Vendor to specify			
3.7	The bed plates shall be finish machined on their top working surface as well as four sides at their periphery. Top surface may be hand scrapped to achieve the specified flatness accuracy. The cast iron bed plates shall be free from cracks, burrs, pits and other defects.	Vendor to offer			
3.8	The flatness accuracy of each bed plate shall be within 0.075 as per grade-I, IS:10602. Inspection certificates with traceability shall be furnished by the vendor along with the bed plates.	Vendor to offer			
3.9	Overall size of all 16 nos bed plates will be 14000mm x 6000mm. Layout of bed plates is as per annexure-1. The flatness accuracy of all the sixteen nos of bed plates (over all size: 14000 X 6000 mm) after erection and commissioning by vendor shall be within 0.400mm.	Vendor to offer			
3.10	Machined and un-machined surfaces shall be suitably preserved.	Vendor to offer			
3.11	The bed plates shall be marked at an appropriate place with designation and the manufacturer's name and trade-mark.	Vendor to confirm			
3.12	All anchoring bolts, jacking screws, support plates & taper wedges etc. required for grouting, leveling and joining of each plate on all the four sides, shall be specified and included in the offer but quoted separately.	Vendor to offer			
3.13	Vendor shall mention and explain in details, the method to be adopted for checking and recording the flatness accuracy during manufacture and during pre-dispatch inspection by BHEL at their works.	Vendor to offer			

SCOPE : SUPPLY, ERECTION & COMMISSIONING OF CAST IRON BED PLATES, SIZE 3500 MM X 1500 MM X 400 MM AS SPECIFIED BELOW

3.1.4	To facilitate proper evaluation of the offer, Sketches / Drawings / Catalogues etc. showing all details (of the offered bed plate) shall be submitted by the vendor.	Vendor to submit	
3.15	The vendor shall also indicate their max. production capacity of machine finished bed plates / annum in the last ten years, by providing relevant documents.	Vendor to submit	
4.0	Foundation details along with dimensioned drawing shall be submitted by the vendor within one month after placement of purchase order. Civil work as per the details given by the vendor shall be done by BHEL under supervision of vendor. Soil condition at BHEL, Haridwar is mentioned below :	Vendor to confirm & note	
a)	Soil strata : Silty sand up to 2.5 meter depth		
b)	Average density of soil = 1.8 T/cubic m		
c)	Angle of internal friction = 35° (up to 3.0 m depth)		
d)	Coefficient of elastic uniform compression "Cu" = 3.0 Kg/cubic cm (at 7m depth for 10sq m base area and 1.0 Kg/sq.cm confining pressure)		
e)	Bearing capacity at 1.5 meter depth = 10T/sq.m		
f)	Water table = 25 meter below ground level		
5.0	PRE-DESPATCH INSPECTION AND ACCEPTANCE :		
	Provisional acceptance of the Bed plates shall be made by BHEL at vendor's work prior to dispatch. Test certificates, Specification compliance and flatness accuracies of the individual bed plates shall be checked and verified.	Vendor to confirm	
6.0	FINAL ACCEPTANCE:		
	Final acceptance shall be after erection and commissioning of the Bed plates at BHEL by the vendor to the full satisfaction of BHEL. The criteria for acceptance of the bed plates after erection shall be "satisfying all the clauses from 3.1 to 3.15 of Technical Specifications" given above.	Vendor to confirm	
7.0	GUARANTEE :		
	Vendor shall provide full and complete Guarantee for two years trouble free performance after successful commissioning.	Vendor to confirm	
8.0	QUALIFYING CONDITIONS :		
8.1	The vendor should have experience of manufacturing same /nearly similar size Bed plates and should provide reference list of customers to whom bed plates of same /nearly similar sizes have been supplied in the past five years, mentioning contact person of the customer, broad specification, flatness accuracies achieved & year of supply.	Vendor to confirm & submit	
9.0	POINT WISE CONFIRMATION :		
	Vendor should confirm /clarify point wise (All the points) as per specification at the first instance in the offer.	Vendor to note	

[Signature]
JITENDRA K.
 (Co-Engt/Wt)

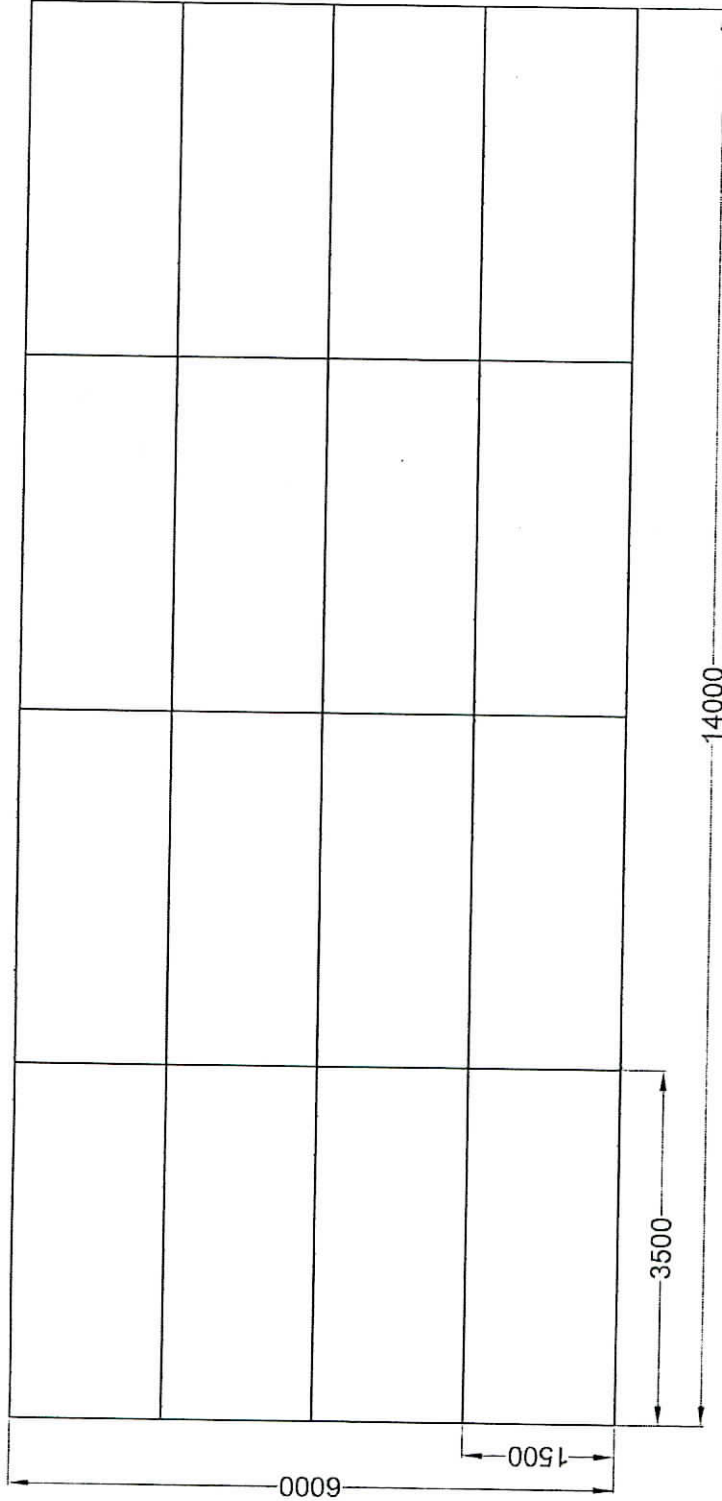
[Signature]
AS3
 14-8-13
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 AGN (Wt)

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 15/10/10
C VIVEK ARYA
 Dy. Mgr. DL-2

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J.K. RANBY
 DGM (WER-CN)

ANNEXURE-1

ARRANGEMENT OF LAYOUT OF BED PLATES



TOTAL No. OF PLATE=4x4=16Nos.
SIZE OF EACH PLATE=3500mm. x 1500mm. x 400mm.
OVERALL SIZE=14000mm. x 6000mm.

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