

- f) Machine structure should be rigid so that vibrations do not occur during machining of blade insertion grooves.
- g) Independent lubrication system for Ram slide and other parts to be provided.
- h) There should not be any leakage / spillage of oil during operation or otherwise.
- i) Proper lifting arrangement shall be provided for shifting of machine from one place to another place.
- j) Portable machine light having flexible arm, magnetic base & having suitable length of supply wire shall be provided.
- k) Standard tool kit for operation and maintenance of the machine shall be provided.
- l) 3-Phase MCB-DB Industrial Plug-Socket box of 30A rating should be provided and it should be properly fitted on the machine near operator area.
- m) Power supply cable 20 meter length of suitable rating should be provided for connection of machine to the main supply.
- n) All AC motors on the machine should be of reputed make like Siemens, ABB, Crompton Greaves, Kirloskar.
- o) Phase sequence controller to avoid reverse rotation of motor & Indication lamp on the control panel to indicate proper phase sequence to be provided.
- p) First filling of all required Oils & Grease etc. for the machine to be supplied by vendor. Indigenous (Indian) source or Indian equivalent and specifications of oils/ greases are also to be provided by the vendor.
- q) All the necessary fasteners required for clamping the machine on bed plates to be provided.

4. POWER SUPPLY :

AC 3-Phase, 415V +10 % / -15%, 50 HZ +/- 3%.


5. SPARES :

- (a) Bevel gear- 1 set
- (b) Overloading clutch - 1 set
- (c) Lubrication Pump with its piping - 01 set of each type.
- (d) All oil seals - 01 set.
- (e) Lead screw with nut for ram movement - 01 set.

Shiv
(Operator)


(Ramesh Kr.)^{2/4}


Anand


(A.K. Choudhary)

- (f) Lead screw with nut for tool head slide - 01 set.
- (g) Motor - 01 No. each
- (h) Set of all jibs (Taper wedge) – 1 set.
- (i) Power Contactor - 02 nos. of each type.
- (j) Relays - 02 nos. of each type.
- (k) Overload relays - 02 nos. of each type.
- (l) Single phase preventer - 02 nos.
- (m) Push buttons - 05 nos. of each type.
- (n) Push Button contacts (N/O) - 20 nos.
- (o) Push Buttons contacts (N/C) - 20 nos.
- (p) Selector Switch – 5 No. each type
- (q) MCB/MPCB – 2 No. each type
- (r) HRC Fuses – 10 No. each type
- (s) MCB-DB Box 3-Phase/30A with plug & Socket – 2 No.

6. MANUALS :

- a) 5 sets of operation / maintenance manuals, containing electrical circuit diagram, detailed assembly drawings of each sub assembly with part list shall be provided.
- b) 5 sets of complete spares part list of m/c along with unit price(in Rs) is to be provided.

7. COLOUR :

Colour of the machine : Vendor to specify.

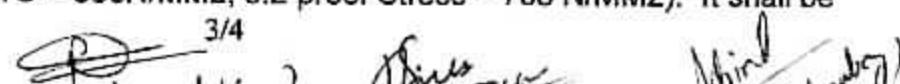
8. WARRANTY :

Supplier shall provide full and complete Warranty/Guarantee for two years trouble free operation after successful commissioning of the machine.

9. PRE DESPATCH INSPECTION:

- a) Pre despatch inspection of the machine will be made by BHEL's team at supplier's work prior to dispatch. Specification compliance and performance of the machine on a test piece shall be checked.
- b) The test piece material shall be of Alloy steel plate of min. 50 mm thickness matching the property close to (UTS < 980N/MM2, 0.2 proof Stress – 700 N/MM2). It shall be

3/4



the responsibility of the supplier to arrange the test piece and cutting tools. 10 No. of slots shall be machined to check accuracy of the machine. (Ref: Insertion groove drg. Annexure III)

- c) Geometrical accuracy test certificate shall be furnished along with the machine.

10. INSTALLATION AND COMMISSIONING :

- a) Party shall take full responsibility for carrying out start up and testing of the machine. Successful proving shall include complete machining of blade insertion grooves in one Rotor meeting the drg. requirements. Reference drgs. of the Rotor and insertion groove are attached. (Annexure III) .
- b) Final acceptance of the machine shall be made by BHEL at its plant following successful commissioning and achieving specified accuracy.

Shiv
(S. SIOGON)
E2/PTX

R
(Ratnesh Kori)
(E2/WEX-BL3/EM)

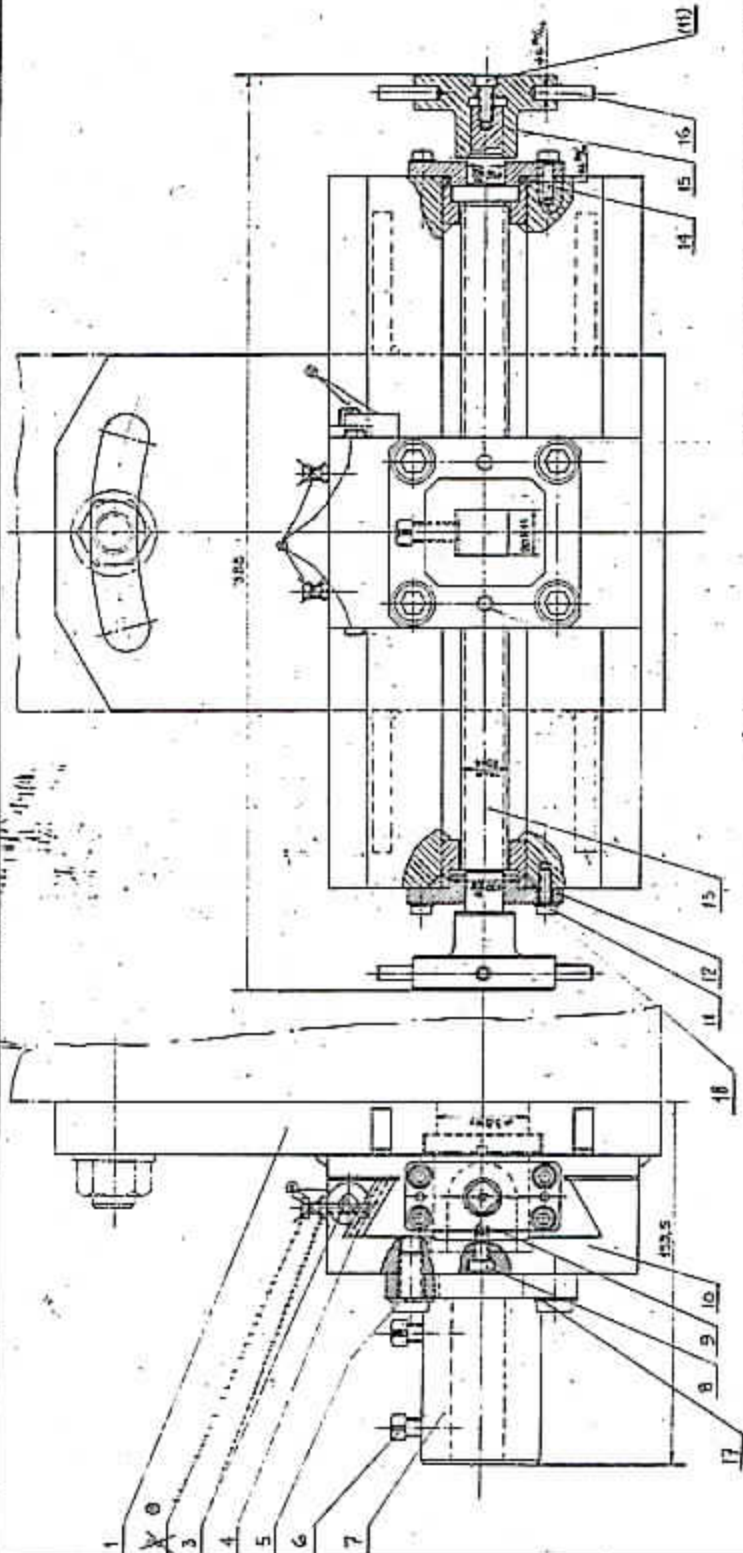
Hansraj
(Hansraj Pal Singh)
EPT/WEX/NTS

P. Kumar
(P. Kumar)
E3(WEX-BL-3)

Ashish
A.K. Choudhary
(Engr. / TUM / AD-3)

<PART NUMBER> <PART REVISION NUMBER>

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN MM)



B. I. S. I.
RG729-0002

4. TO BE USED ON SHARIF MODEL RGP-24.
7. ONLY RING 2 INCH AS IS MOUNTED TO RETAIN LAMP.
MOUNT ON RETAIN R WITH MIN. CLEARANCE PLACING DET.

Sl. No.	Part No.	Description	QTY	Material
1	PH 10x1.5x30	PH 10x1.5x30	1	PH 10x1.5x30
2	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
3	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
4	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
5	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
6	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
7	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
8	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
9	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
10	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
11	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
12	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
13	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
14	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
15	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
16	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
17	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
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21	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
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26	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
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29	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
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34	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
35	WASHER 10x1.5x1.5	WASHER 10x1.5x1.5	1	WASHER 10x1.5x1.5
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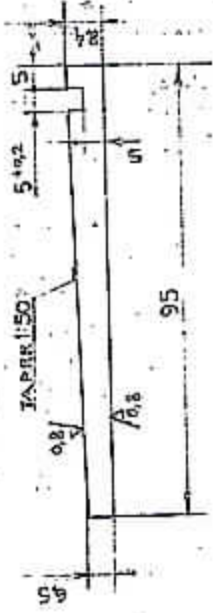
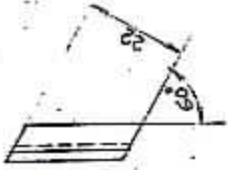
TYPE OF PRODUCT		DRAWING NO. / REV.	
NAME OF CUSTOMER/PROJECT		DATE / SCALE	
DRAWING NO. / REV.		DATE / SCALE	
BHARAT HEAVY ELECTRICALS LIMITED			
KANPUR			
DESIGNED BY		CHECKED BY	
DRAWN BY		APPROVED BY	
DATE		DATE	
SCALE		SCALE	
SHEET NO.		SHEET NO.	
TOTAL SHEETS		TOTAL SHEETS	
PROJECT NO.		PROJECT NO.	
CUSTOMER NAME		CUSTOMER NAME	
CUSTOMER ADDRESS		CUSTOMER ADDRESS	
CUSTOMER PHONE		CUSTOMER PHONE	
CUSTOMER FAX		CUSTOMER FAX	
CUSTOMER E-MAIL		CUSTOMER E-MAIL	
CUSTOMER WEBSITE		CUSTOMER WEBSITE	
CUSTOMER LOGO		CUSTOMER LOGO	
CUSTOMER SIGNATURE		CUSTOMER SIGNATURE	
CUSTOMER SEAL		CUSTOMER SEAL	
CUSTOMER STAMP		CUSTOMER STAMP	
CUSTOMER MARKS		CUSTOMER MARKS	
CUSTOMER NOTES		CUSTOMER NOTES	
CUSTOMER COMMENTS		CUSTOMER COMMENTS	
CUSTOMER REVISIONS		CUSTOMER REVISIONS	
CUSTOMER APPROVALS		CUSTOMER APPROVALS	
CUSTOMER SIGNATURES		CUSTOMER SIGNATURES	
CUSTOMER DATES		CUSTOMER DATES	
CUSTOMER INITIALS		CUSTOMER INITIALS	
CUSTOMER MARKS		CUSTOMER MARKS	
CUSTOMER STAMPS		CUSTOMER STAMPS	
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CUSTOMER CHARACTERS		CUSTOMER CHARACTERS	
CUSTOMER WORDS		CUSTOMER WORDS	
CUSTOMER SENTENCES		CUSTOMER SENTENCES	
CUSTOMER PARAGRAPHS		CUSTOMER PARAGRAPHS	
CUSTOMER DOCUMENTS		CUSTOMER DOCUMENTS	
CUSTOMER FILES		CUSTOMER FILES	
CUSTOMER FOLDERS		CUSTOMER FOLDERS	
CUSTOMER DRIVES		CUSTOMER DRIVES	
CUSTOMER NETWORKS		CUSTOMER NETWORKS	
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CUSTOMER APPLICATIONS		CUSTOMER APPLICATIONS	
CUSTOMER SERVICES		CUSTOMER SERVICES	
CUSTOMER SUPPORT		CUSTOMER SUPPORT	
CUSTOMER TRAINING		CUSTOMER TRAINING	
CUSTOMER DOCUMENTATION		CUSTOMER DOCUMENTATION	
CUSTOMER RECORDS		CUSTOMER RECORDS	
CUSTOMER ARCHIVES		CUSTOMER ARCHIVES	
CUSTOMER BACKUPS		CUSTOMER BACKUPS	
CUSTOMER RESTORES		CUSTOMER RESTORES	
CUSTOMER MIGRATIONS		CUSTOMER MIGRATIONS	
CUSTOMER UPDATES		CUSTOMER UPDATES	
CUSTOMER PATCHES		CUSTOMER PATCHES	
CUSTOMER HOTFIXES		CUSTOMER HOTFIXES	
CUSTOMER RELEASES		CUSTOMER RELEASES	
CUSTOMER VERSIONS		CUSTOMER VERSIONS	
CUSTOMER BUILD NUMBERS			

<PART NUMBER> <PART REVISION NUMBER>

DRAWING NUMBER
R6729-0002/00

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

3/2 THE REST



THIS DRG. SUPERCEDES THE
 OLD DRG. UNDER THE SAME
 NUMBER. (C.I.C. IS 310/51-84/81)

C-40
 MAT.

HARDEN TO HRc 35 ± 40.

TYPE OF PRODUCT
 OR
 CUSTOMER'S NAME

BHARAT HEAVY ELECTRICALS LTD.
 RAMIPUR - HARDWAR.



DEPT. JTD	CDS 125	SCALE 1:1	WEIGHT (KG) 0	REF. TO ASSY. DRL.	DATE
WEDGE				NAME: DAVIS	DATE
				CHECKED: KHANNU	
				APPROVED:	

Dimensions to be Controlled Within Limits as Shown
 Machining Tolerance ± 0.5 mm Unless Otherwise
 Shown. Non Machining Tolerance ±

DRAWING NO. R6729-0002/001
 SHEET NO. NO. OF SHEETS

REV. DATE ALTERED CHECKED

REV. DATE ALTERED CHECKED

REV. DATE ALTERED CHECKED

REV. DATE ALTERED CHECKED

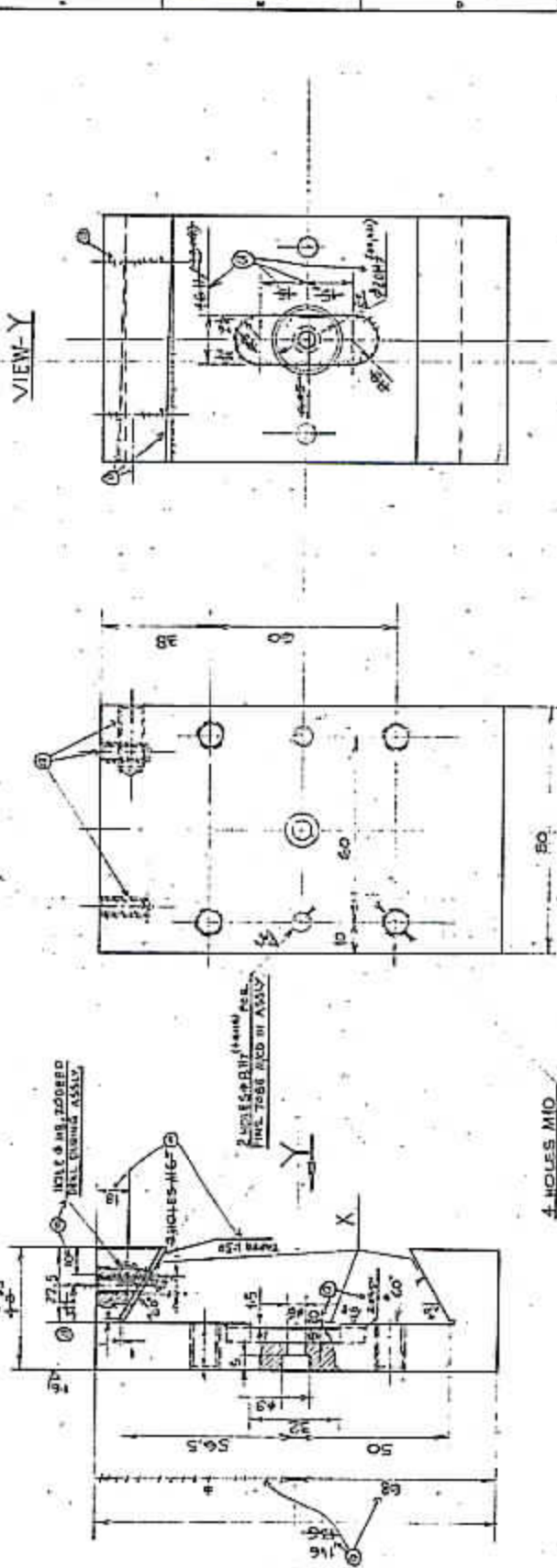
REV. DATE ALTERED CHECKED

REV. DATE ALTERED CHECKED

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

RG729-0002/003
DRAWING SHEET

BY THE PARTY



1. SURFACES MARKED X TO BE CARBURRED & HARDENED TO HRC 45-50
2. BOUND OFF SHARP EDGES.
3. 4 HOLES SHOULD CORRESPOND TO D.D. OF RG729-0003/001

DATE	BY	CHKD	APP'D	DESCRIPTION	DRAWING NO.	MATERIAL CODE	QTY	UNIT	REMARKS
							51	42-5	

STATUS	TYPE OF PRODUCT	NAME OF CUSTOMER/PROJECT
DATE	OR	

BHARAT HEAVY ELECTRICALS LIMITED
HARDWAR

LOGO: 115
TITLE: SLIDE

REV. DATE: ALTERED / CHECKED

NO. OF SHEETS: 1

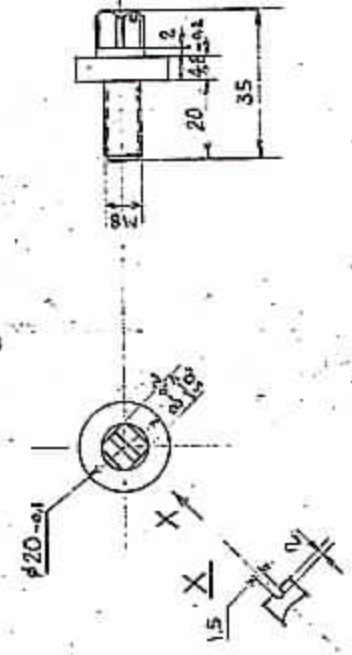
SIZE: A2

21

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm.) Form DG-39

DATE	REV	DATE	ALTERED	CHECKED	DIMS NO./DR. SP. NO.	STATUS OF DRG
					APPROVED	SIGN
					NAME	DATE

32
A
ALLOWER



HARDEN TO IRC 2.B: 30

13	MATERIAL CODE	14	UNIT WEIGHT
15	VAR.	16	MATERIAL SPECN
17	18	19	20
21	22	23	24
25	26	27	28
29	30	31	32
33	34	35	36
37	38	39	40
41	42	43	44
45	46	47	48
49	50	51	52
53	54	55	56
57	58	59	60
61	62	63	64
65	66	67	68
69	70	71	72
73	74	75	76
77	78	79	80
81	82	83	84
85	86	87	88
89	90	91	92
93	94	95	96
97	98	99	100

BHARAT HEAVY ELECTRICALS LTD.
HARDWAR

SCALE: 1:1

GRADE OF UNFOLDRING: C/M/P

WEIGHT (N):

REF. TO ASSEMBLY:

DRAWING NO.: R 6729-0002/007

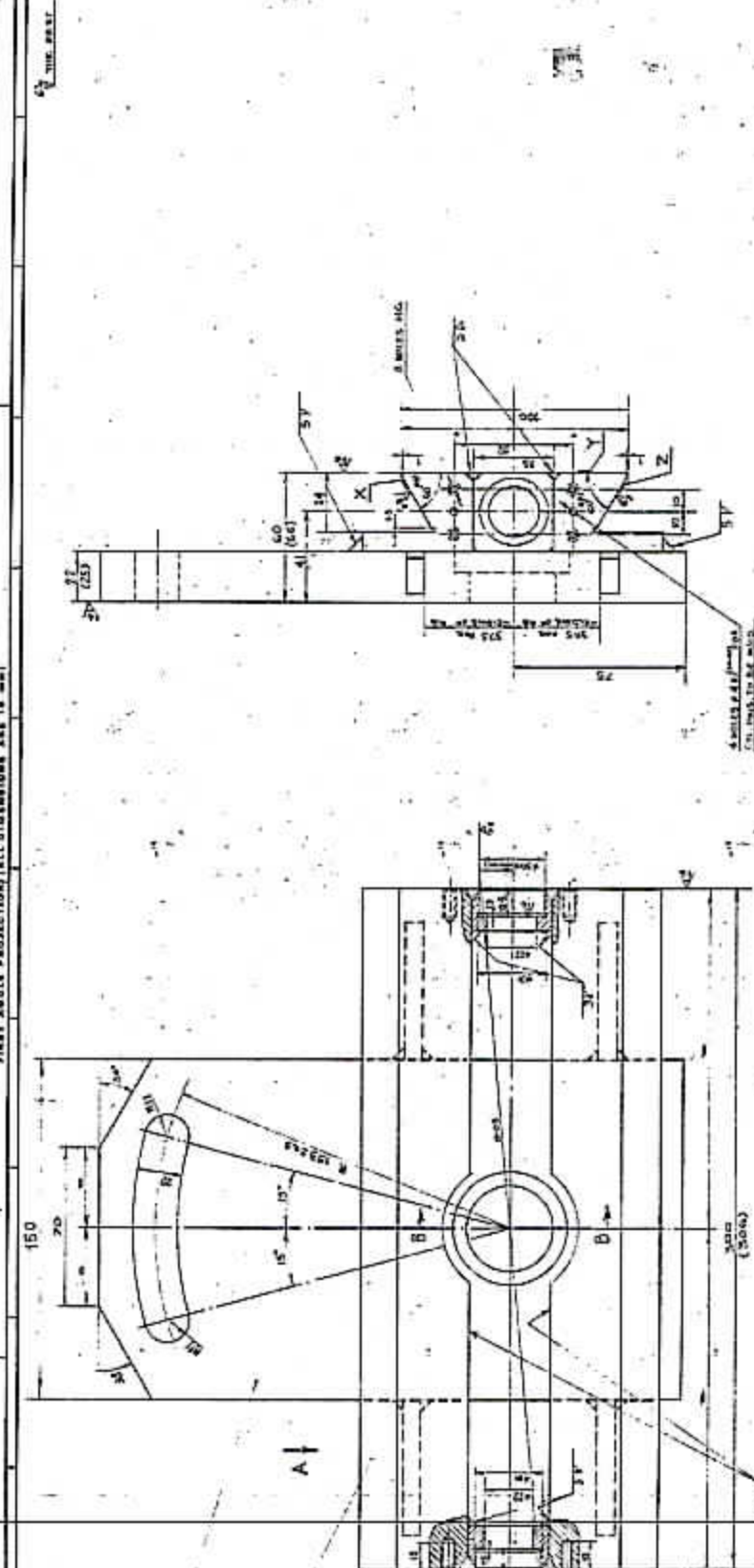
CARD CODE: SPL. SCREW

SHEET NO. 1 OF 1

NO. OF SHEETS: 1

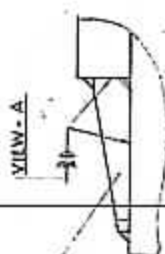
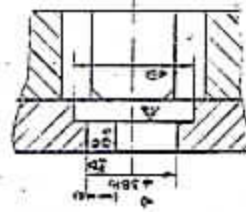
SIZE: A3

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN MM)



NOTES:-

- TO BE CHECKED - ROUNDED AFTER MACHINING.
- REWORKING & RE-ASSEMBLY WORK CONTAINED IN THE DRAWING, CENTER BOX OR CAPTION, MUST BE STORED IN THE STORE ROOM, 312-24, TO BE RE-CHECKED & REORDERED TO IS 9: 35-70.
- & Co. Supply catalogue No. 6673-0001/02.



NO.	DESCRIPTION	MATERIAL	QTY
1	PLATE	MS 1018	1
2	PLATE	MS 1018	1
3	PLATE	MS 1018	1
4	PLATE	MS 1018	1

TYPE OF PRODUCT: **BARBANS**

NAME OF CUSTOMER/PROJECT: **BHARAT HEAVY ELECTRICALS LIMITED**

DATE: **11/11/2011**

BY: **...**

CHECKED: **...**

APPROVED: **...**

DESIGN NO: **6673-0001/02**

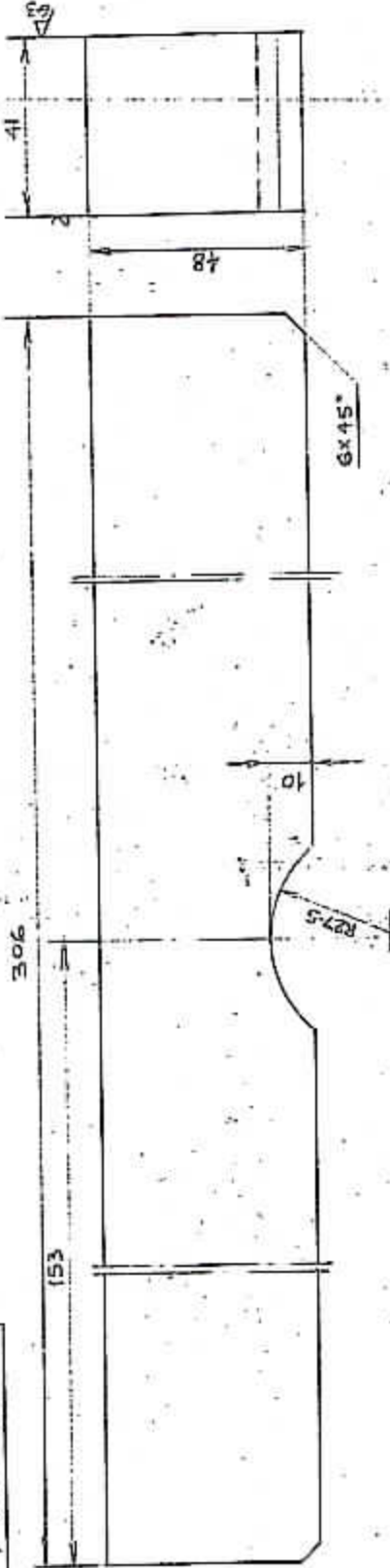
REV: **...**

<PART NUMBER> <PART REVISION NUMBER>

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

125 THE REST

R6729-0002/011
DRAWING NUMBER



BLANK

ST. 42-W					
MATERIAL					

TYPE OF PRODUCT
OR
CUSTOMER'S NAME

BHARAT HEAVY ELECTRICALS LTD.
RANIPUR - HARDWAR.

DEPT. JST	CODE 125	SCALE 1:1	WEIGHT PCS 4.5	REP. TO ASBY. DRIS.	ITEM NO.
DRAWN	DATE	CHECKED	APPROVED	DRAWN	DATE
				DAVA S.	
				KUNAN	

BLOCK

DRAWING NO. R6729-0002/011
 Dimensions to be Controlled Within Limits as Shown
 Machining Tolerance ± 0.25 mm. Unless Otherwise
 Shown. Non Machining Tolerance ±

SIZE A3

REP. DATE	ALTERED
	CHECKED

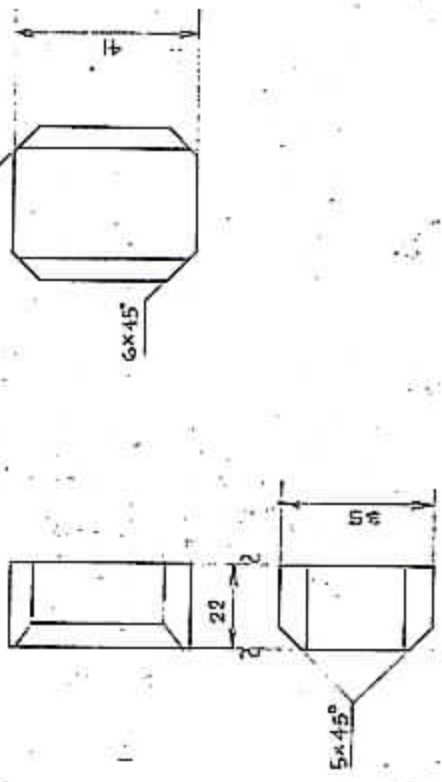
12

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm.)

REV	DATE	ALTERED	REV	DATE	ALTERED
		CHECKED			CHECKED

R6729-0002/012

12.5 THE REST



BLANK

ST. 42-W	MATERIAL
----------	----------

BHARAT HEAVY ELECTRICALS LTD.
RANIPUR - HARDWAR.

REP. J&T	SCALE 1:1	WEIGHTED	REF. TO ASBY. DRG.	ITCING
125	0.025			
NAME	BOOK	DATE		
DESIGN	DATE			
CHECKED	KHAN			
APPROVED				

PLATE

Dimensions to be Controlled Within Limits as Shown
Machining Tolerance ± 0.25 mm Unless Otherwise
Shown. Non-Machining Tolerance ± 0.25 mm

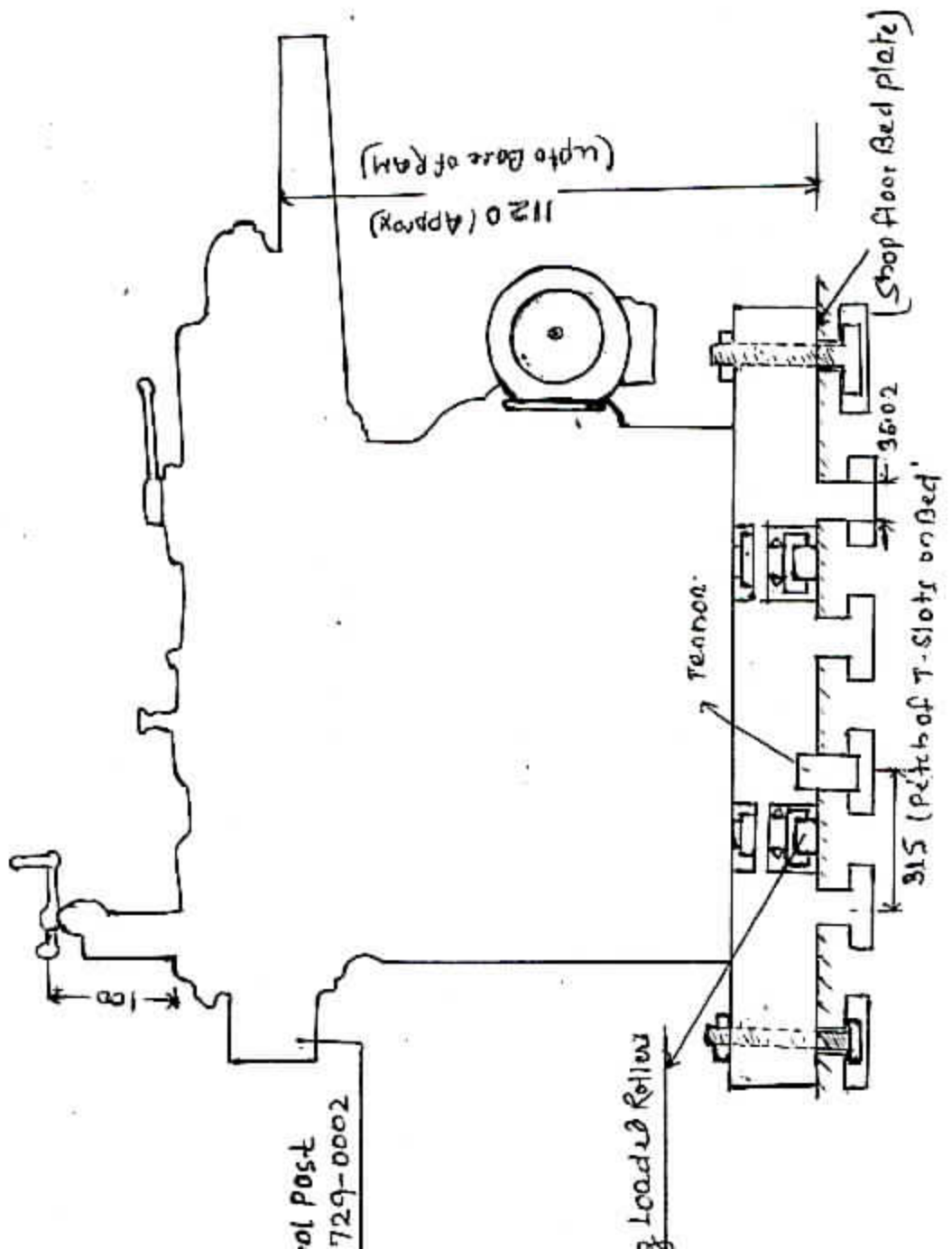
DRAWING NO. R6729-0002/012

SHEET NO. NO. OF SHEETS. SIZE A4

ANNEXURE-II

FOR REFERENCE ONLY

ALL DIMENSIONS ARE IN MM



Schematic Diagram of shaper

12

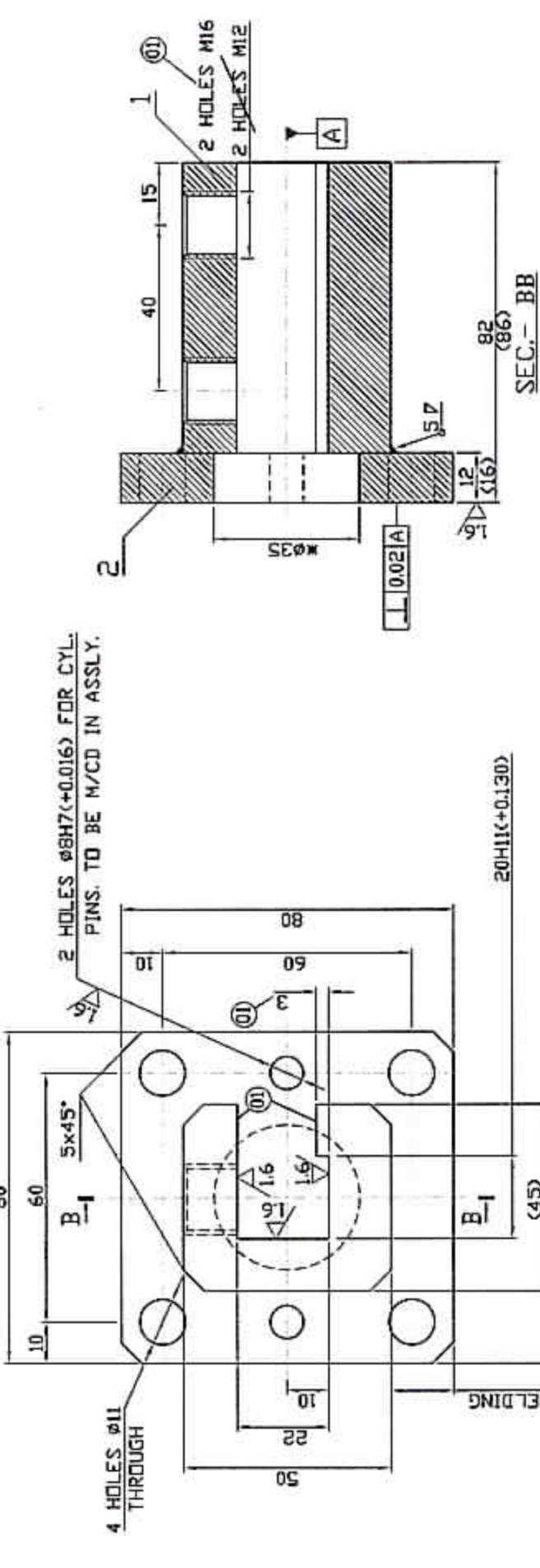
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)		THE REST	
REV. DATE 10/01/13	ALTERED 10/01/13		
R6729-0002/013		ST. 42-W MATERIAL	
		BHARAT HEAVY ELECTRICALS LTD. RANIPUR - HARDWAR.	
SGN. D. DATE 1-5030	INVENTOR NO.	SGN. CODE JAT 125	WEIGHT (KG) 0.025
RIB		SCALE 1:1	REF. TO ASSY. DREL.
Dimensions to be Controlled Within Limits as Shown Machining Tolerance ± 0.15 mm Unless Otherwise Shown. Non Machining Tolerance ±		DRAWING NO. R6729-0002/013	ITEM NO.
It must not be used directly or indirectly in any way detrimental to the interest of the company.		SHEET NO.	NO. OF SHEETS.
SIZE A1			

ALL DIMENSIONS ARE IN mm

FIRST ANGLE PROJECTION

020/2000-62798 No. DRAWING

6.3/ THE REST



2 HOLES $\phi 8H7(+0.016)$ FOR CYL. PINS. TO BE M/C/D IN ASSLY.

4 HOLES $\phi 11$ THROUGH

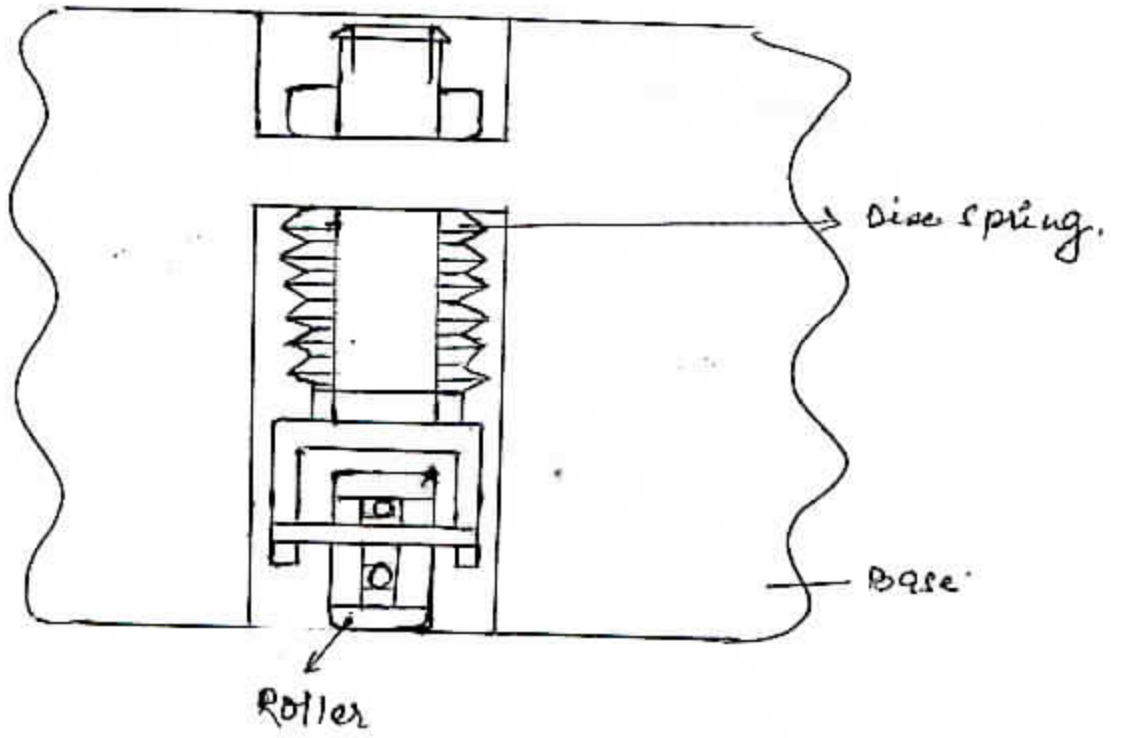
20H11(+0.130)

SEC.- BB

ITEM No.	DESCRIPTION	VAR.	DRAWING No.	MATERIAL CODE	UNIT WEIGHT	QTY.
2.	PLATE 80x80,t=16			C-40 AA1021B	0.500	1
1.	BLOCK 50x45,t=70			C-40 AA1021B	1.000	1

NOTES:-
 1. HOLE $\phi 35$ TO BE CUT PRIOR TO WELDING.
 2. HARDEN TO HRC32-35 AS PER PS. 0912.008

CMS No./CR.SP.No.		STATUS OF DRG		TYPE OF PRODUCT		COMP. DRG. No.		M/C TOOL TRANS No.		REF. DRG. No.	
APPROVED	NAME	SIGN	DATE	DESIGN	ORDER No.	M/C MODEL No.	NAME	SIGN.	DATE	No. OF VAR.	REV
							DRN	DAYAS.	-Sd-		
							CHD	KHAN	-Sd-		
							APD				
GRADE OF UNTOL. DIM.:-		DEPT. JTE		WEIGHT(Kg)		REF. TO ASSY. DRG.		ITEM No. OF NO. ITEMS		REV	
M/CG- MM	AA0230208	CODE 209		SCALE 1:1		R6729-0002				DRAWING No.	
WELDING-A/B/C/D AA0621104		CHECKED AJTEAM.		TITLE		R6729-0002/020				SHEET No. 01 No. OF SHEETS 01	
GAS CUTTING-T3 AA0621101		ALTERED SUTERS.		TOOL HOLDER						SIZE A 3	
REV DATE		CHECKED		JTE-10-F0087/9-12-16							
ALTERED				C/A No.							
CHECKED				DATE							



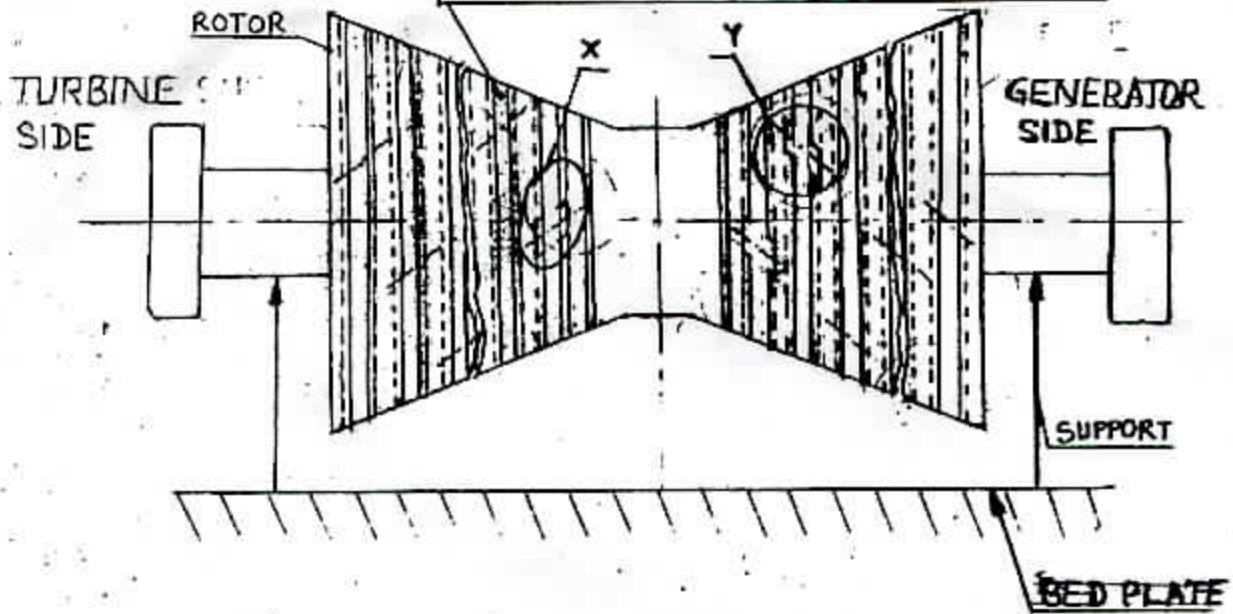
Details of Roller Assy.

ANNEXURE-3

SHEET NO. 1/2

NO. OF BLADE GROOVE

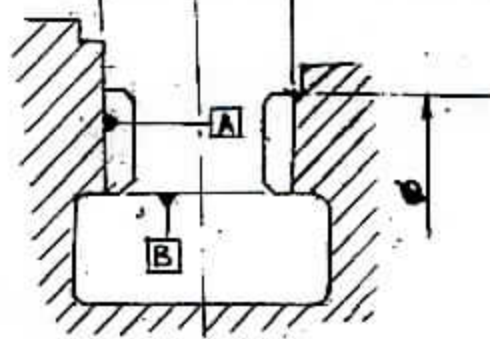
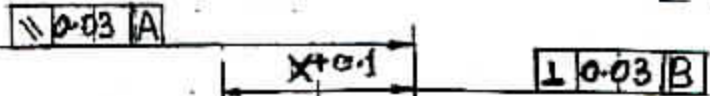
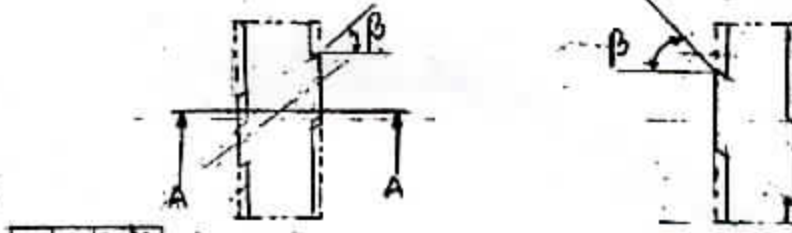
STAGES MAY VARY FROM 3 TO 20 EACH SIDE



$\angle \beta$ MAY VARY FROM 15° TO 38°

DETAIL X

DETAIL Y



SECTION AA

SKETCH SHOWING INSERTION GROOVE IN ROTOR