



BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL VALVES PLANT
433, INDUSTRIAL COMPLEX
GOINDWAL SAHIB
DISTT. TARN TARAN- PUNJAB – 143422

No.BHE:IVP:
SC:ISL:AD
2015-16/02
Dated
18.01.2016

NOTICE INVITING APPLICATIONS FOR REGISTRATION OF SUB CONTRACTORS

BHARAT HEAVY ELECTRICALS LIMITED [BHEL] is manufacturing Industrial Valves and other Boiler accessories at its Industrial Valves Plant, Goindwal Sahib unit. Isolating valves are new addition to BHEL IVP Goindwal product range and machining vendors are required for machining of various castings & components. App. Annual procurement value for year 2015-16: 60 Lakh.

Expression of interest and applications for registration are invited from sub-contractors (including MSE & MSE-SC/ST vendors) for doing the machining job of various components of Isolating Valves. Major areas for which subcontractors are required are Casting Machining, VTL, Horizontal Boring Machine. Items for which vendors required immediately are:

Isolating/HM/LM Valves	Casting Machining of Body, Bonnet, Disc, Cover and other machining components for HM/LM range of valves. List of components, where machining vendors are required, is attached herewith as Annexure-II. Sample drawings of some components are also attached.
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BHEL is looking for prospective Sub Contractors for above detailed job work for BHEL.

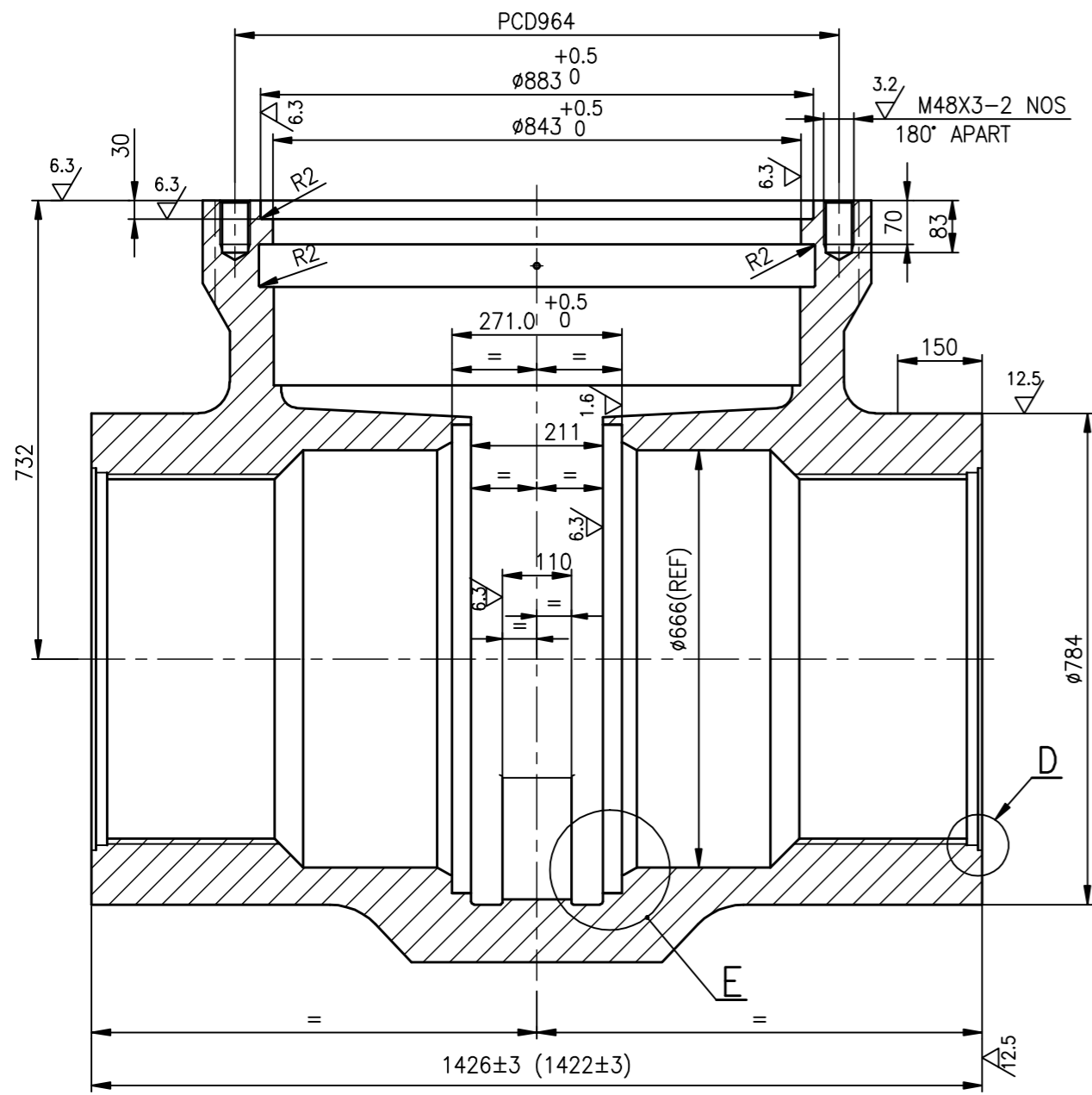
BHEL shall evaluate the vendors as per its established vendor selection, evaluation and registration procedure. Supplier registration form can also be downloaded from our website www.bhel.com available as a downloadable link at http://www.bhel.com/images/pdf/vendor/Guidelines_Indian_Suppliers_SEARP2010Amdt.02.pdf

BHEL invites such vendors to visit its above located plant on any working day from Monday to Saturday between 0930 Hrs to 1730 Hrs and contact undersigned for any clarification regarding:

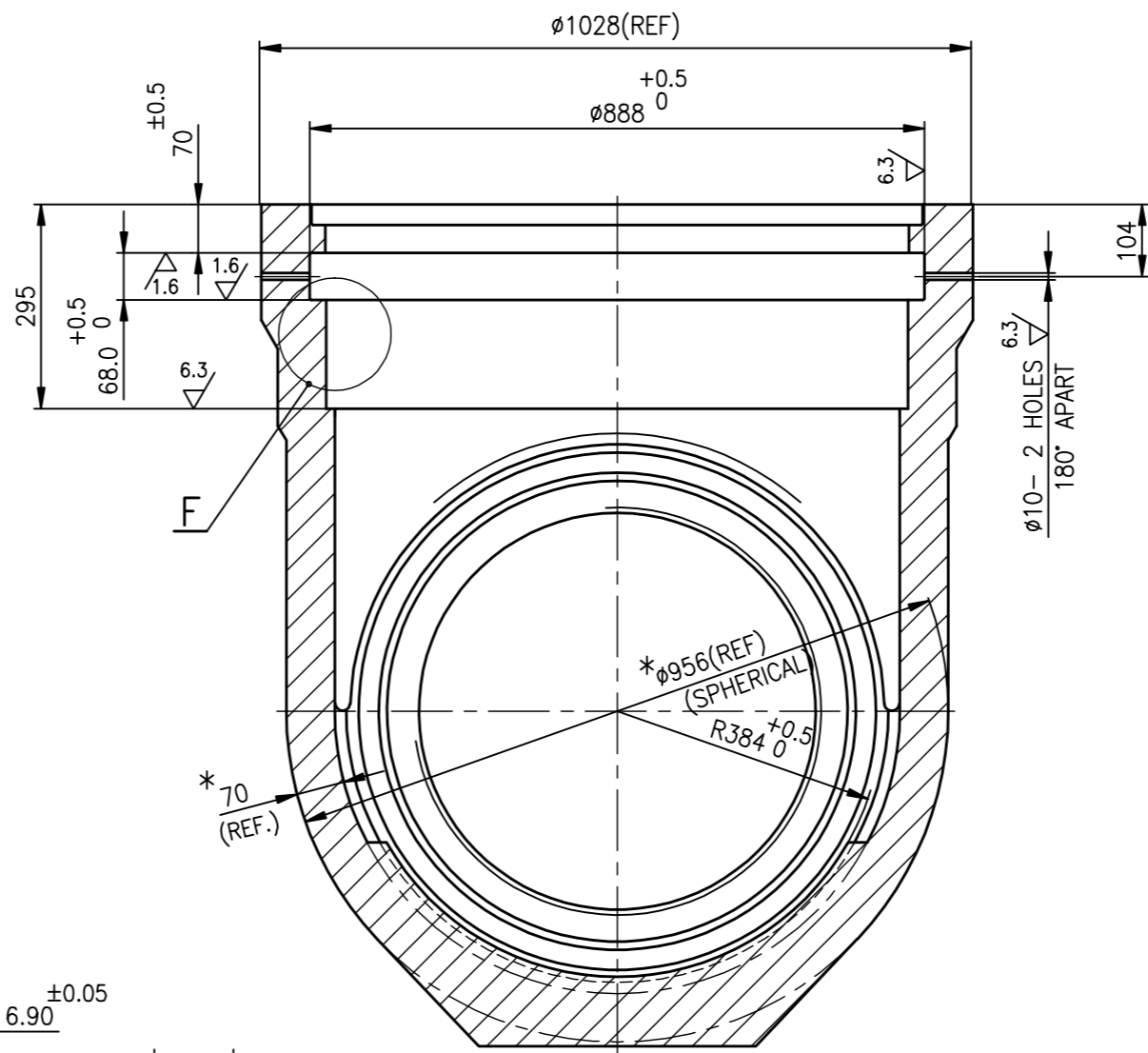
Items details and requirement		Vendor registration form/procedure
Sumeet Bansal Dy. Manager (Sub-Contracting)	Gaurav Gangwar Sr. Engineer (Sub-Contracting)	Prikshit Ravesh Sr. Engineer (Sub-Contracting)
Phone: 01859-224647	01859-224643	01859-224654
Mobile: 098780 06105	08427001944	098880 62649
E-mail: sb@bhelivp.in	gsg@bhelivp.in	prikshit@bhelivp.in

Fax: 01859-222061

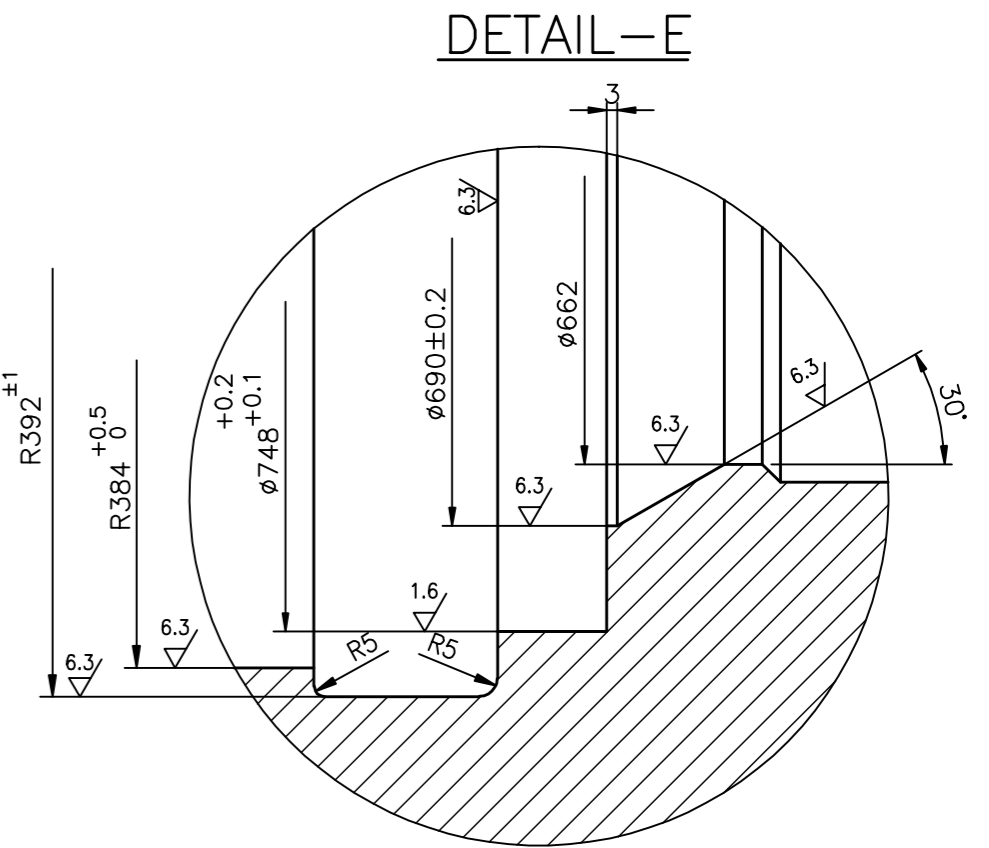
BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL VALVES PLANT, 433, INDUSTRIAL COMPLEX,
GOINDWAL SAHIB, DISTT. TARN TARAN, PUNJAB – 143 422



SECTION-BB



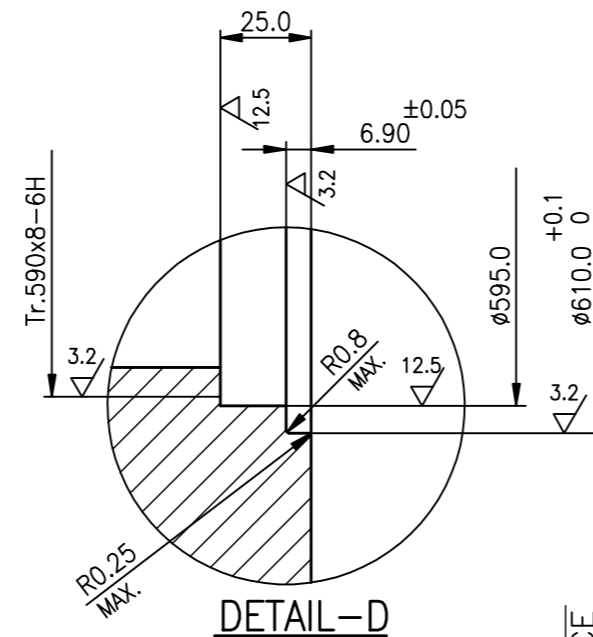
SECTION-CC



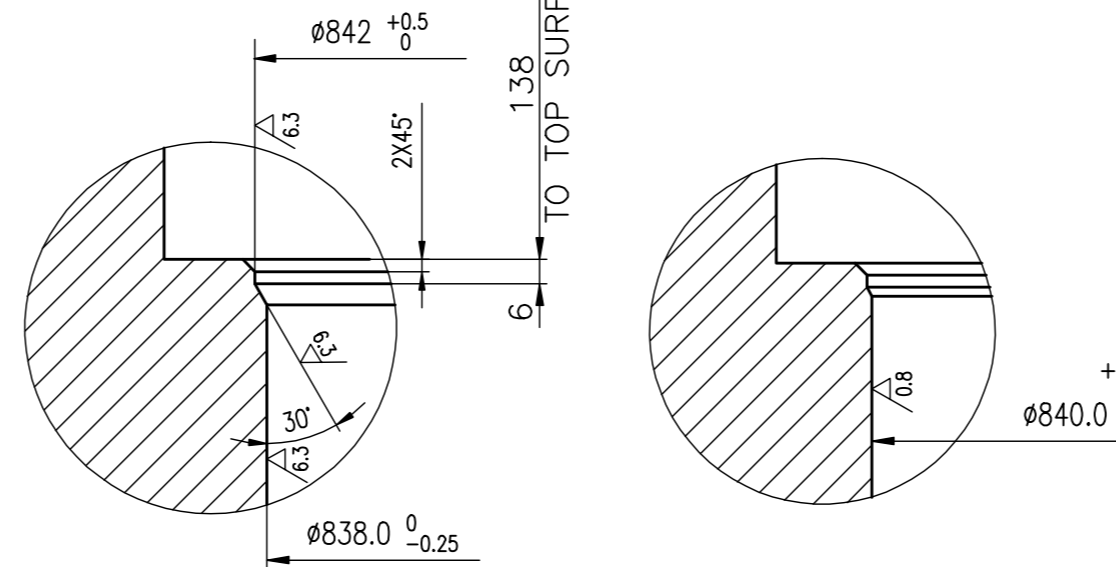
DETAIL-E

NOTES

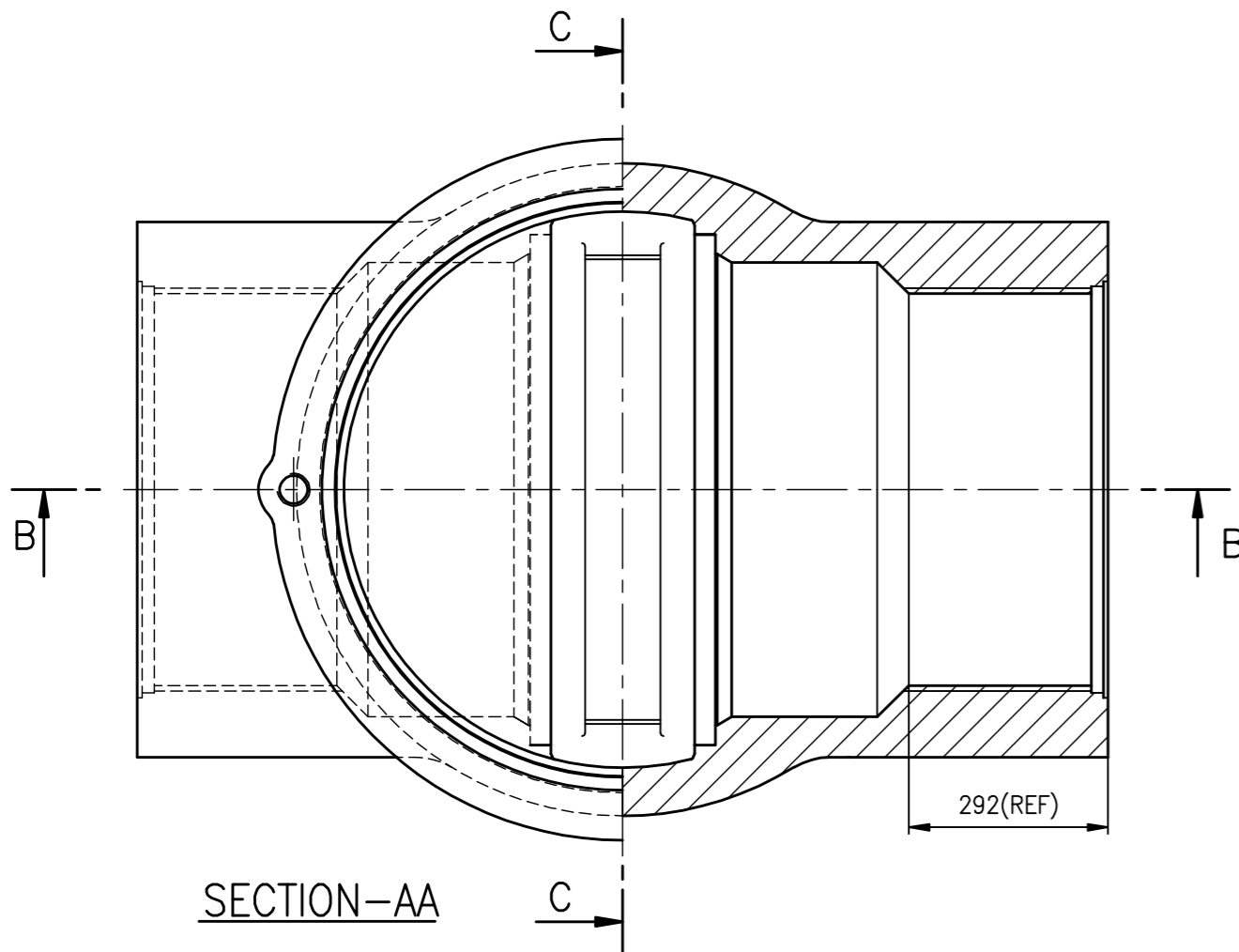
- UNSPECIFIED SHARP CORNER TO BE CHAMFERED TO 1 X 45°
- EDGE PREPARATION IS TO BE DONE AFTER HYD. TESTING.
- THESE DIMENSIONS ARE INDICATED FOR IBR CALCULATION PURPOSE ONLY.



DETAIL-D



DETAIL-F



SECTION-AA

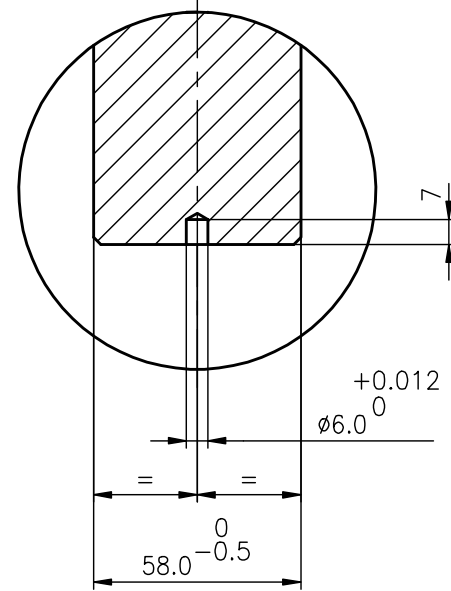
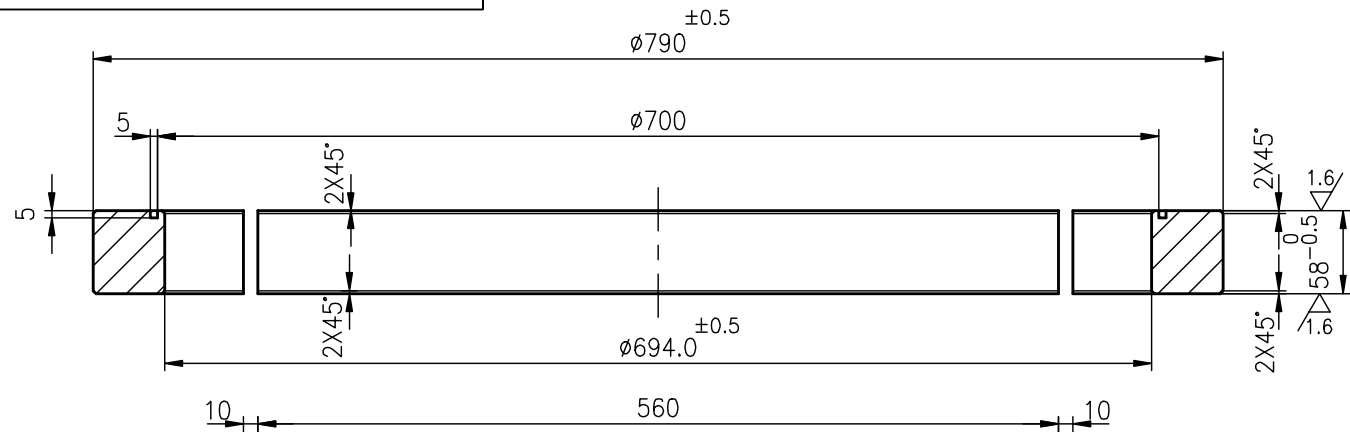
REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN
02	05.03.11	CHD & APPD	M.RAJAKUMAR	01	02.11.09	CHD & APPD	M.RAJAKUMAR
DETAIL- F AND DIMENSIONS Ø838, Ø842 AND 6 INCLUDED.				DRAWING Nos. 2.V.3315.14088 AND 2.V.3316.14088 INCLUDED.			
DCP: 801155							

SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMPONENT CODE	ITEM No
03	CASTING	92 201 874	ASTM A217 C12A-ATTEST	NORMALISED & TEMPERED	20	2390	2710	2.V.3316.14088/01 932017540000	001
02	CASTING	92 201 640	ASTM A217 WC9-ATTEST	NORMALISED & TEMPERED	20	2390	2710	2.V.3245.14088/01 932010330000	001
01	CASTING	92 201 873	ASTM A216 WCC-ATTEST	NORMALISED	10	2390	2710	2.V.3315.14088/01 932017530000	001

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI - 620014.									
DRN	M.SRINIVASAN	SIGN	DATE	NO.OF VAR.					
CHD	P.Boomnathan		07.03.07	07					
APPD	M.RAJAKUMAR		07.03.07	07					
DEPT	VL	SCALE	WEIGHT (KG).	REFERENCE INFORMATION			NO. OF ITEMS		
CODE	320	NTS	2390	CAD: F214088					
TITLE				CARD CODE	DRAWING NO.		REV		
BODY (750mm)				U 01	2-V-0000-14088		02		

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DRAWING NO. 3-V-0000-06644

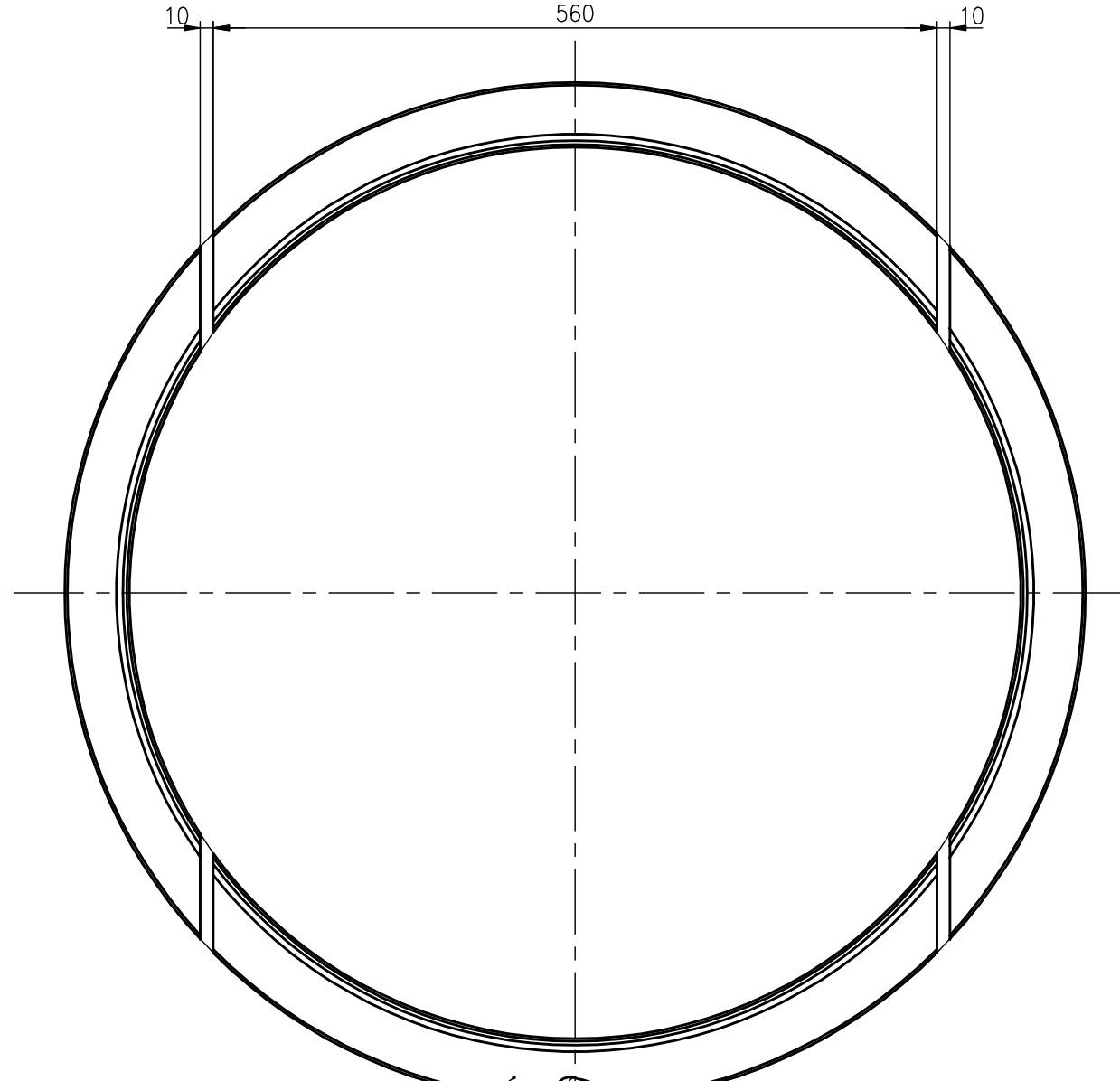


12.5 / 1.6

BEFORE FIXING THE PIN

NOTE:

- 01. FIX ONE CYL. PIN $\phi 6 \times 14$ FOR ASSEMBLING WITH BODY.
- * 02. CHROMIUM PLATING SHOULD BE DONE ON THE FINISHED SPLIT RING ASSY TO A THICKNESS OF 0.03 mm TO 0.04 mm.



016
* 017

S.L. No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMP. CODE	ITEM No
02	CYL. PIN $\phi 6 \times 14$	-	BPS 417 02	-	-	0.01	-	BPS 41702 417 02 06 014	017
	SUGG. MIN. SIZE PL.60 X $\phi 810-\phi 680$	-	SA 387 Gr 22 CERTIFY	NT	20	51.2	71.0	3.V.3205.06644/01 93 166 499 0000	016
01	CYL. PIN $\phi 6 \times 14$	-	BPS 417 02	-	-	0.01	-	BPS 41702 417 02 06 014	017
	SUGG. MIN. SIZE PL.60 X $\phi 810-\phi 680$	-	SA 515 GR 70 CERTIFY	NORMALISED	10	51.2	71.0	3.V.3204.06644/01 93 166 493 0000	016

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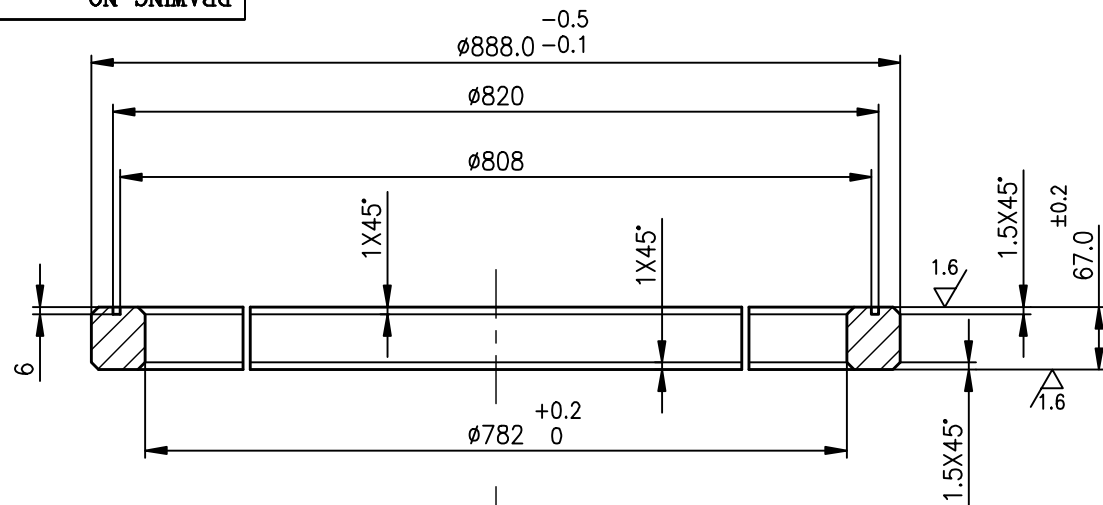
REV	DATE	ALTERED
01	29.05.09	M.SRINIVASAN
		CHD & APPD P. BOOMINATHAN

DCP:800948
DIMENSION $\phi 694$ WAS $\phi 690$

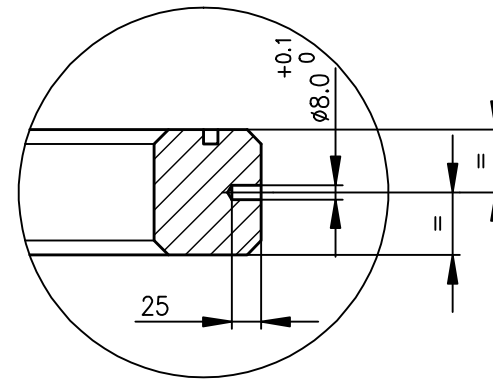
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					DRN		NAME	SIGN	DATE	NO. OF VAR.
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.					365-121		M.SRINIVASAN		13.10.90	
							N.P.ESWARAN		13.10.90	
							N.NAGARAJAN		13.10.90	
DEPT	VL	SCALE	WEIGHT (KG)	REFERENCE INFORMATION			NO. OF ITEMS			
CODE	320	NTS	51.21	CAD :F306644						
TITLE					CARD CODE	DRAWING NO.			REV	
SPLIT RING ASSY					U 01	3-V-0000-06644			01	

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP.

DRAWING NO. 3-V-0000-24536



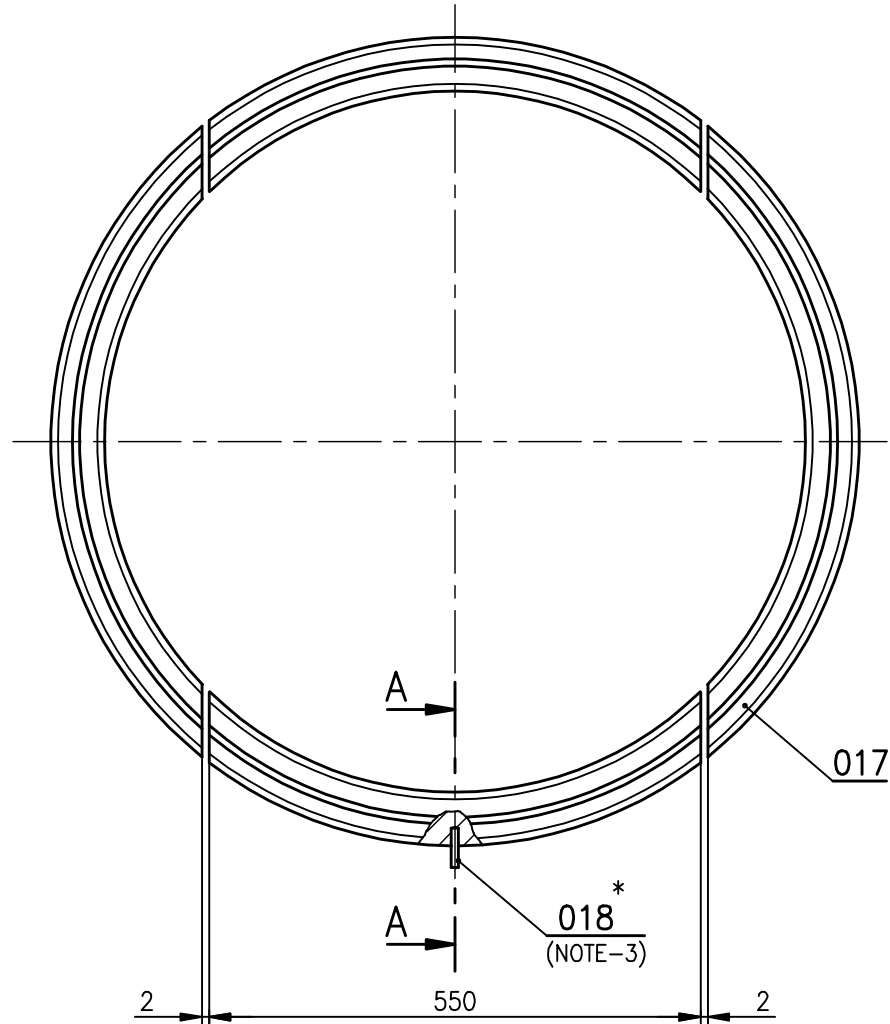
SECTION-AA



SECTION-AA

NOTE

- 01. BREAK ALL SHARP CORNERS.
- 02. CHROME PLATING SHOULD BE DONE ON THE FINISHED SPLIT RING ASSEMBLY TO A THICKNESS OF 0.03mm TO 0.04mm.
- * 03. FIX ONE CYLINDRICAL PIN $\phi 8 \times 55$ FOR ASSEMBLING WITH BODY AT THE TIME OF ASSEMBLY.



01	CYL PIN $\phi 8 \times 55$	-	-	-	-	0.01	-	BPS 41702 417 02 08055 00	018
	SUGGESTED SIZE PL68 -892 X 892	--	SA387 GR.22 CERTIFY.	NORMALISED & TEMPERED	20	71.99	333.6	3-V-3245-24536/1 93 201 042 0000	017
SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMP. CODE	ITEM No

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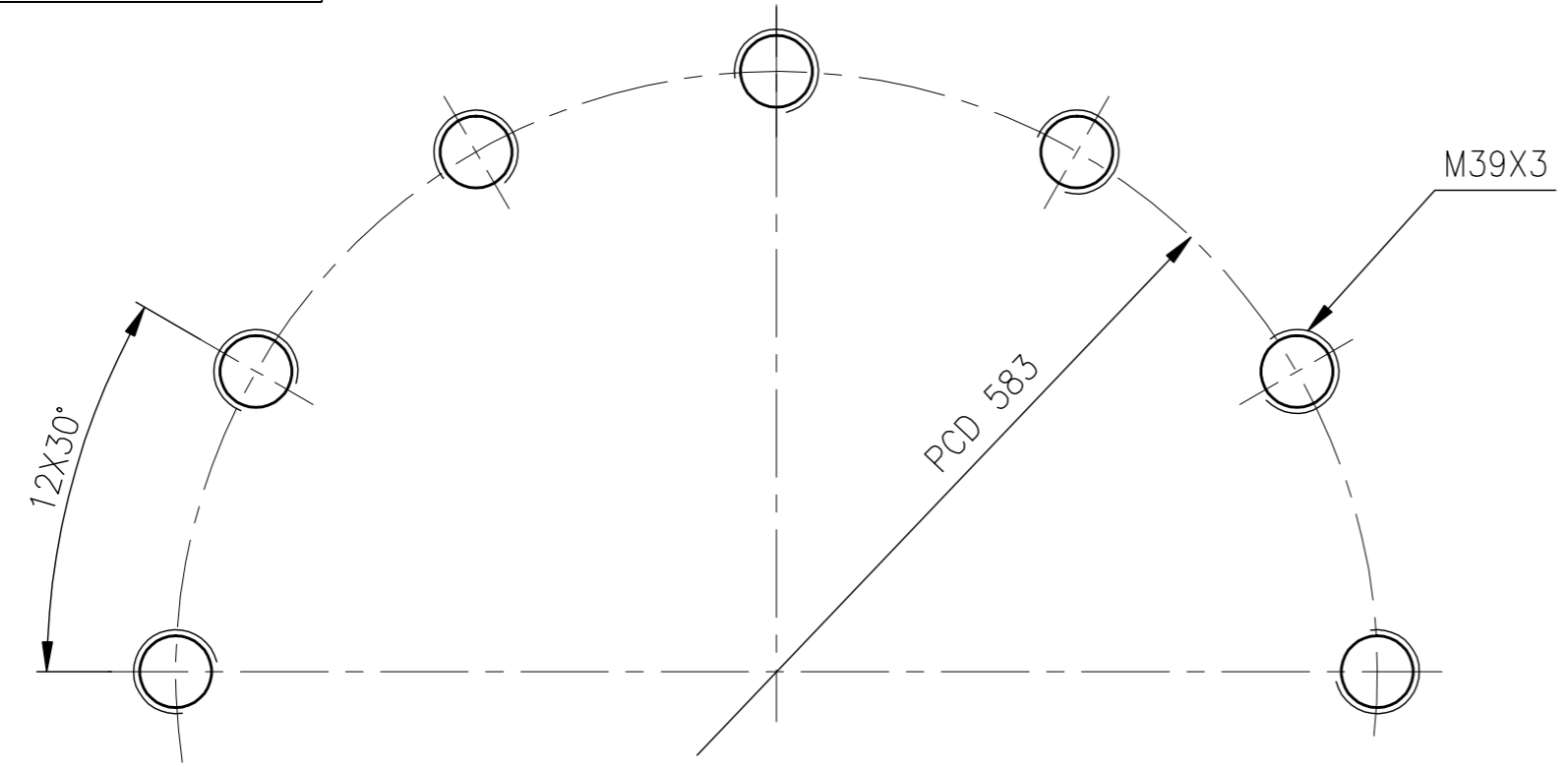
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										
		BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.				DRN	M.SRINIVASAN	SIGN	DATE	NO.OF VAR.
365-121						CHD	P.Boomnathan		07.03.07	
						APPD	M.RAJAKUMAR		07.03.07	
DEPT	VL	SCALE		WEIGHT (KG).		REFERENCE INFORMATION			NO. OF ITEMS	
CODE	320	NTS		72.0		CAD : F324536				
TITLE						CARD CODE	DRAWING NO.		REV	
SPLIT RING						U 01	3-V-0000-24536		01	

REV	DATE	ALTERED
01	02.11.09	M.SRINIVASAN CHD & APPD M.RAJAKUMAR
MATERIAL SA387 GR.22 WAS SA 515 GR.70		

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP.

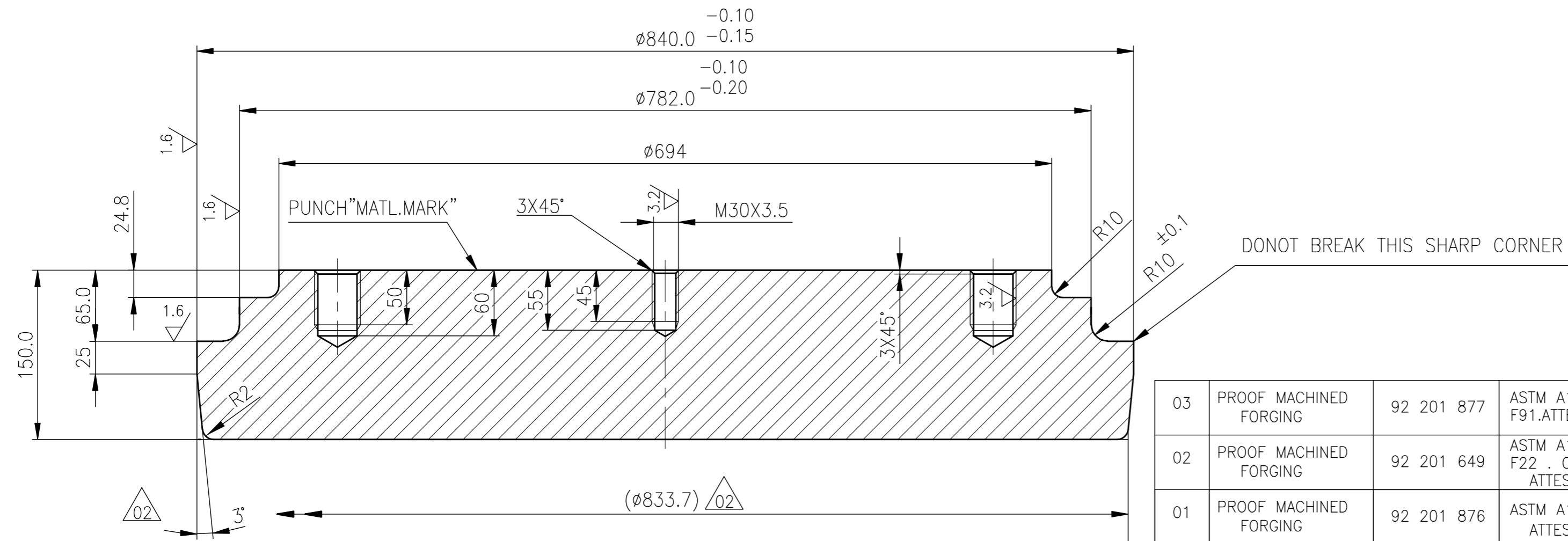
DRAWING NO. 3-V-0000-24542

6.3 / 3.2 / 1.6



NOTE

01. BREAK ALL SHARP CORNERS.



S.L. No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMP. CODE	ITEM No
03	PROOF MACHINED FORGING	92 201 877	ASTM A182 F91.ATTEST.	NORMALISED & TEMPERED	20	587	690.5	3.V.3316.24542/01 93 201 758 0000	013
02	PROOF MACHINED FORGING	92 201 649	ASTM A182 F22 . CL.3 ATTEST.	NORMALISED & TEMPERED	20	587	690.5	3.V.3245.24542/01 93 201 063 0000	013
01	PROOF MACHINED FORGING	92 201 876	ASTM A105 ATTEST.	NORMALISED	10	587	690.5	3.V.3315.24542/01 93 201 757 0000	013

REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN
02	24.08.11	CHD & APPD	M.RAJAKUMAR	01	02.11.09	CHD & APPD	M.RAJAKUMAR

ZONE \triangle 02 ANGLE 3° INCLUDED. DIMENSION (Ø833.7) WAS Ø837 DCP: 801216

DRAWING Nos. 3.V.3315.24542 AND 3.V.3316.24542 INCLUDED.

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				
		BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.		
DEPT	VL	SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS
CODE	320	NTS	587	CAD : F324542
TITLE			CARD CODE	REV
BONNET			U 01	02
DRAWING NO.		3-V-0000-24542		

Annexure-II

List of Isolating valves items in which machining Sources are required on Job work basis

S. No	Gr. No	Product Area	Description	Size
1	G2410	ISL	Body Machining	450-C500-CRHIV-BW-WCC
2	G2412	ISL	Adjusting Screw-3200/3202	450-C500-CRHIV-BW-WCB/750-C500-CRHIV-BW-WCC
3	G2413	ISL	Adjusting Screw-3202	750-C500-CRHIV-BW-WCC
4	G2414	ISL	Hex Domed Screw-3202	750-C600-CRHIV-BW-WCC
5	G2422	ISL	SUPPORT RING-3201/3200	500-C900-HRHIV-BW-WC9
6	G2432	ISL	COVER SHEET	750-C600-CRHIV-BW-WCC
7	G2434	ISL	LOCATING SCREW-3200	450-C500-CRHIV-BW-WCB
8	G2469	ISL	DISK-3200	450-C500-CRHIV-BW-WCB
9	G2470	ISL	BONNET-3200	450-C500-CRHIV-BW-WCB
10	G2471	ISL	COVER-3201	450-C500-CRHIV-BW-WCB
11	G2482	ISL	Cover-3208	550-C900-HRHIV-BW-WC9
12	G2483	ISL	Support Ring-3208	550-C900-HRHIV-BW-WC9
13	G2484	ISL	Disk-3208	550-C900-HRHIV-BW-WC9
14	G2485	ISL	Seat Ring Rough	550-C900-HRHIV-BW-WC9