

TECHNICAL SPECIFICATION



**Heavy Power Equipment Plant,
Bharat Heavy Electricals Limited,
Ramachandrapuram -502032, Andhra Pradesh, INDIA.**

CONTACT PERSON'S NAME/DESIGN./PHONE NO./E-MAIL (FROM PURCHASE DEP'T.)

Date :

Specification cum Compliance Certificate for SHOT PEENING MACHINE

NOTE:-

1. The "Vendor's Offer" column and where applicable, "Remarks" column of this format shall be filled in by the
2. The offer and all documents enclosed with offer should be in English language only.

ADDRESS OF THE SUPPLIER :

ADDRESS OF THE INDIAN AGENTS :

TELEPHONE NOS.:

TELEPHONE NOS.:

FAX NOS.:

FAX NOS.:

E-MAIL ADDRESS :

E-MAIL ADDRESS :

Scope: Supply, Erection & Commissioning of SHOT PEENING MACHINE complying with specification as below.

| SL. NO | DESCRIPTION FOR BHEL REQUIREMENT | SPECIFIED / TO BE CONFIRMED BY | VENDOR'S OFFER |
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| 1.0 | PURPOSE | | |
| 1.1 | PURPOSE: Robotic Shotpeening machine shall be required to continuous shot peen various profiles on rotor components for Gas Turbines for Power Generation Industry, with the job mounted on turn table in an enclosed room or cabinet which will restrict the shots to immediate working area. The machine should be capable of handling 3 different types of shot size S110, S330, S390. At one time only one type of media will be used in the system. Provision shall also be made to easily remove different type of media in case of changeover from one type of shot size to another type. | Vendor to Note. | |
| 2.0 | JOB SPECIFICATION | | |
| 2.1 | WORK PIECE MATERIAL: Machine shall be suitable for Shotpeening machined forgings of ferrous metals like , alloy steel, stainless steel etc. (Refer attachment) | Vendor to Note. | |
| 2.2 | Maximum Length of the job:1730mm | Vendor to Note. | |
| 2.3 | Maximum Diameter of the job :Ø2200mm | Vendor to Note. | |
| 2.4 | Maximum weight of the job: 8 Ton | Vendor to Note. | |
| 3.0 | SHOT PEENING DETAILS | | |
| 3.1 | Maximum Diameter of shot peening surface: Ø1515mm | Vendor to Note. | |
| 3.2 | Maximum length of shot peening surface: 1105mm | Vendor to Note. | |
| 3.3 | Shot Size :S-110, S-330, S-390 | Vendor to Note. | |
| 3.4 | Shot Peening intensity for reference : 4-6mils on Almen strip "C" Shot Size S-330 4-8mils on Almen strip " A" Shot Size S-110 6-10mils on Almen strip "N" Shot Size S-110 4-6mils on Almen strip "C" Shot Size S-390 Vendor to supply Almen strip of above sizes 20 nos. each of type C , A & N | Vendor to note and confirm supply of Almen strips as mentioned | |
| 4.0 | FEATURES OF SHOT PEENING FACILITY | | |
| 4.1 | Fabricated Metallic enclosure with support Structures suitable for the job sizes: Qty : 1 nos. of suitable size. Enclosure walls & roof shall be fabricated from minimum 3 mm thick MS sheet. | Vendor to confirm.. | |
| 4.2 | a) Motorized door duly rubber lined : Qty: 1 Nos. Motorized door for job loading / unloading.The enclosure shall be provided with motorized main door. The doors shall be fabricated from minimum 3mm MS sheet suitably engineered and constructed for rigidity. The door shall be pasted with minimum 3 mm rubber sheet for protection against abrasion. b) Minimum grit leakage from the bottom clearance of the air lower. | Vendor to confirm.. | |

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| 4.3 | <p>a) Man door : Qty :1 Nos. A hinged type man door atleast of size 600 mm (W) x 1800 mm (H) shall be provided for operator's entry/exit from the metallic enclosure. The door shall be pasted with minimum 3mm thick rubber sheet for protection against abrasion. A vision window atleast of size 200 mm x 200 mm x 6mm thick shall be provided. The door shall be fabricated from minimum 2 mm thick steel sheet.</p> <p>b) Door shall fully open/close (90 Deg) without any hindrance in the long run.</p> <p>c) Door shall be locked from outside as well as inside.</p> <p>d) Minimum grit leakage from the bottom clearance of the door as a baffle plate is fitted on the door bottom.</p> | Vendor to confirm.. | |
| 4.4 | <p>Rubber Lining on Side Walls: Complete Rubber lining with hangers for side walls & door of enclosure. Minimum 3 mm thick rubber hanging sheets shall be provided on inside walls for full height of the walls for protection against abrasion. The rubber lining shall be made of good quality natural rubber having shore hardness 40 ± 5A, off white colour & specific gravity 1.1. These rubber sheets shall be of easily replaceable type.</p> | Vendor to confirm.. | |
| 4.5 | <p>Illumination with wiring & switch panels. : Suitable number of LED fitted with fixture shall be provided at suitable location for illumination of the enclosure. The illumination lamps shall be wired with suitable copper conductor unarmored wiring and the wiring shall be routed through cable trays / flexible PVC Conduit Pipes. Illumination switch panel shall be mounted suitably on the side wall of the enclosure with MCB switches. SS wire mesh shall be fitted at the front of the LED lamps for protection against abrasion.</p> | Vendor to confirm.. | |
| 4.6 | <p>a) Fully Automatic Type Media Recovery Screw Conveyor Systems : Qty : 1 Set.</p> <p>Hopper with Grating : Heavy floor grating panel removable type for enclosure shall be provided to facilitate the transfer of used abrasives into hopper. The hopper shall be fabricated from minimum 3 mm steel sheet provided with perforated sheet to avoid damage to buckets and belt and provision to remove broken parts. It is to be noted that the grating shall not bear the weight of the job or any material handling system / Trolley / Fork Lifter etc. inside or outside the enclosure.</p> <p>b) Gratings shall be fabricated by Electro-forged welding to give burr free surface.</p> <p>c) Load bearing capacity of each grating shall be 400 kgs per Sq.mtr.</p> <p>d) Grating shall be fabricated in a closed dimensional tolerance for easy removal and re-fitment.</p> <p>e) Load bars shall be closely spaced to avoid the pass through of any big tool into the hoppers.</p> <p>f) A civil structure design for the pit and blast room to be submitted by the vendor for better and error free foundation construction to be carried-out by the civil contractor of purchaser</p> | Vendor to confirm.. | |
| 4.7 | <p>Media Recovery Screw Conveyor : The system shall consist of screw conveyor system. When used abrasive falls through the floor grating into screw conveyor hopper, The screw conveyor delivers the abrasive to the boot of the bucket elevator.</p> | Vendor to confirm.. | |
| 4.8 | <p>Bucket Elevator :a) The abrasive conveyed by the screw conveyor will be elevated by the bucket elevator to the top. The buckets shall be of seamless type made of minimum 3.15 mm thick steel sheet. Bucket elevator shall be fabricated from MS material of minimum 5 mm thick at boot section, minimum 3.15 mm thick at trunk and top section, respectively.</p> <p>b)The bearing housing and shaft shall be designed such that a sleeve will get wear out instead of complete shaft thereby reducing the spare cost.</p> <p>c) Bottom pulley shall be fitted preferably with both side bearings.</p> <p>d)Bucket elevator top pulley shall be directly driven instead of chain driven so that belt tensioning is much easier and faster.</p> | Vendor to confirm.. | |

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| 4.9 | <p>a) Blast Generator 10CFT Qty : 1 No: The blast generator of machine shall be made of a pressure vessel, mushroom valve, exhaust valve and an outlet with Magna valve & mixing tube assembly to feed the nozzle through a blasting hose. Capacity of pressure vessel : 10 Cft. Approx Blasting Nozzle : Tungstan Carbide Lined 8 mm ID Compressed air consumption : 135 Cfm.At 90 psig Blast Hose : 25 mm I.D having suitable Length to shot peen the components. The material of hose should be Antistatic & wear resistant in nature. Blast Control : Through PLC</p> <p>b) Pressure vessels are fabricated from minimum 6mm thick IS-2062 grade MS plate and are hydraulically tested at 250 psig as per IS-2825. One set of air filter, pressure gauge and air regulator is provided.</p> <p>c) The machine shall be equipped with conical head pop-up valve and coated with hard-wear resistant coating for long service life.</p> <p>d)The machine shall be supplied with flexible light weight blast hose of NR/SBR/BR, Black smooth abrasion resistant and antistatic property.</p> <p>e) Machine shall be supplied with large throat Venturi nozzle made of Tungsten Carbide material for greater productivity.</p> | Vendor to confirm.. | |
| 4.10 | <p>a) Shot Flow Controller, Magna Valve :- Magna Valve with controller shall be provided to control the flow of media S-110 S-330 & S-390. Magna valve should be normally closed magnetic valve typically used to measure and control the flow of media. The valve construction includes a permanent magnet operation and an electromagnet to activate shot flow.</p> <p>b) The valve construction includes a permanent magnet for normally closed operation and an electromagnet for controlling shot flow rates by regulating the voltage to the electromagnet. Any desired flow rate may be achieved. When power is off, the valve will hold shots due to the permanent magnet.</p> | Vendor to confirm.. | |
| 4.11 | <p>Motorized Turntable: The complete table shall be supported on a sealed bearing housing. The drive for Turn table shall be mounted outside the enclosure. The drive is transferred by means of Belt/chain Drive. The speed should be selected to achieve the defined shot peening intensities.</p> <p>Diameter : Ø1700 mm or more Drive motor details : Vendor to provide Speed : Variable (vendor to provide details) Load taking capacity : 8000kg of uniformly distributed load.</p> | Vendor to confirm.. | |
| 4.12 | <p>Suitable provision for loading and unloading of the job on turn table shall be provided. Details of the provision shall be submitted with the offer</p> | Vendor to confirm.. | |
| 4.13 | <p>Vibratory Sieve Classifier Unit: Multi deck type vibratory screens are provided to segregate the usable and un-usable media. The deck and screen are constructed in stainless steel material. It consists of five deck. Each deck has one outlet with a flexible connection. Drive Motor : Suitable Capacity drive motor should be provided and the vendor should submit the details of the motor in their offer.</p> | Vendor to confirm.. | |
| 4.14 | <p>Spiral Shot Separator-(FOR S-110, S-330 & S-390 SHOTS ONLY) Spiral separator shall be provided for the separation of round shots from non-round shots through gravity flow operation means hence no power consumption. The spiral separator shall have inner cone as separator and outer spiral as conveyer to transfer the useable round shots into the storage tank. It shall be constructed in G.I steel with heavy duty steel frame. All welded construction to ensure strength and withstand vibration in production. Separator shall be designed for steel shots of size S-110, S-330, S-390 . The vendor should submit the details of the separator used for the application.</p> | Vendor to confirm.. | |

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| 4.15 | <p>Robot with controller & Display Monitor. 6 Axis: ROBOT, IRB 4600 ABB or similar meeting the following conditions criteria in FANUC or ABB. Coordinated movement between robot and turntable should be provided. The robot shall move the peening nozzle in a curved path to cover the root profile and curvatures of the Peening job. Demonstrative Job profiles are given in the attachment. Robot Capacity : 16Kg payload 2033 mm or more reach, measured at centre of 5th axis Absolute position sensing with resolvers. Brakes in all axes Minimum 7m connecting cable between robot mechanics and robot controller. Repeatability ± 0.15mm</p> | Vendor to specify the model. | |
| 4.16 | <p>PLC Operated Control Panel: For Teaching & Operating the robot controller with the following features: EMERGENCY STOP , Drives ON/OFF, mode selector switch and enabling switches. Port for additional keyboard HDMI port for archiving interface with a PC. Minimum possible speed to be more generalised</p> | Vendor to confirm.. | |
| 4.17 | <p>Pleated type dust collector : Qty :1 Set. Suitable capacity of dust collector to be connected to the mettalic enclosure D.C. to be constructed from 2 mm thick M.S. Sheet. Suitable bag /Cartridge cleaning arrangement to be given. Dust emission level: less than 10mg/N cubic mtr. Vendor Should specify Dust Collector capacity ,motor H.P. & CFM of Dust Collector.</p> | Vendor to confirm.. | |
| 4.18 | <p>Suitable silencer with canopy is mounted at the outlet of the exhaust fan to reduce the noise level below 85 dbA. Low pressure drop across the bag filters. DC should be designed for Dust bins to be provided with heavy duty castor wheels/dust collection below DC.</p> | Vendor to confirm.. | |
| 4.19 | <p>DUCTING: Suitable ducting from enclosure to dust collector and from dust collector to the exhaust fan shall be provided. However, ducting beyond the exhaust fan shall be arranged by the buyer. Ducting is constructed by 14G mild steel sheet</p> | Vendor to confirm.. | |
| 5 | FIRST FILLING OF SHOTS | | |
| 5.1 | First filling of S-330 size Shots, 1 TON to be supplied by vendor. | Vendor to confirm.. | |
| 6 | ELECTRIC CONTROL PANEL (PLC Controlled) | | |
| 6.1 | <p>The motor control panel shall be a centralized control panel housed with switchgear items. The motor control panel shall be provided with 1 No. suitable rating MCB for incoming supply. Individual MCB and thermal overload relay shall be mounted for motor below 12.5 HP for all motors. star delta starter with overload protection and MCB should be provided for motors above 12.5 HP.</p> | Vendor to confirm.. | |
| 6.2 | <p>Preferably Floor mounted cubical control panel in Mild steel construction with powder coated both inside & outside shall be provided. Control panel should be housed with reputed make standard electrical Siemens/Scheinder switch gears and MCB suitably interlocked for the sequence of operation. All equipments shall be suitably earthed and shall be connected with centralized control panel through copper cables and glands fitting. Push buttons with switch indication shall be provided along with 3 Phase input supply indication. Centralized control panel shall have proper ventilation fan and suitable lighting. All copper cables shall be laid in cable tray. Vendor to indicate the model of PLC & HMI. The selected model for PLC should be equivalent to siemens model S-200/300/1200 series. For HMI the selected model should be equivalent to KTP-600</p> | Vendor to confirm.. | |

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| 6.3 | 415V ± 10%, 50 HZ ±3 HZ, 3 Phase AC (3 wire system without neutral) Power Supply will be provided by BHEL at a single point near the machine, All types of cables, connections, circuit breakers etc. required for connecting BHEL's power supply point to different parts of the equipment / control cabinets, shall be the responsibility of vendor. Material detail of earthing is to be informed by vendor well in advance so that the same could be incorporated during construction of foundation. | Vendor to confirm.. | |
| 6.4 | The new PLC / Electrical & Electronic control cabinets & panels will have to be housed in the New Control Cabinet (IP54/55) and wired fully with all new switchgears, Lapp / Finolex cables . All incoming cables should be bottom entry. Proper Florescent lighting for cubicle and 2 numbers of 5A, 3 pin plug socket with switch for 230V test lamp shall be provided. Suitable power terminals shall be provided for incoming power cables. | Vendor to confirm.. | |
| 6.5 | Entry of RATS and RODENTS should be restricted in the motor control panel and Electrical control panel . All incoming cables should be bottom entry. | Vendor to confirm.. | |
| 6.6 | Electrical control panel should be complete with required electrical elements such as contactors, MCB s, fuses, rectifiers, isolators etc. of reputed make. | Vendor to confirm.. | |
| 6.7 | All electrical & electronic control cabinets & panels should be dust and vermin proof and shall have IP 54 protection. | Vendor to confirm.. | |
| 6.8 | All Motors shall conform to IEC or Indian Standards. Motor make: ABB/ Siemens / Crompton greaves / BB or any other make subject to acceptance by BHEL. | Vendor to confirm.. | |
| 6.9 | Vendor should ensure proper earthing for the machine and its peripherals. | Vendor to confirm.. | |
| 7 | COLOUR / PAINTING | | |
| 7.1 | Inside and outside surface of equipment will be brush cleaned and given two coats of Red Oxide Primer. Final coat on exterior of system is Synthetic Enamel Air Drying, Shade: As per Buyer's Choice, which will be done before despatch to BHEL. | Vendor to confirm.. | |
| 8 | COMPRESSED AIR | | |
| 8.1 | Compressed air at around 6 to 7 bar will be made available at one point. Vendor to ensure proper functioning of all systems / sub systems of the equipment at this air pressure or vendor to introduce necessary devices to increase the air pressure to the required level. The vendor shall indicate the inlet point for compressed air in the layout drawing of the machine. | Vendor to confirm.. | |
| 9 | LIGHTING | | |
| 9.1 | The lighting inside the booth shall be such that with naked eye it should be easily possible to identify and differentiate the painted / unpainted areas on the job. The fixtures should be flame proof. | Vendor to confirm.. | |
| 9.2 | Lighting wattage of each light | Vendor to specify | |
| 9.3 | Number of light fixtures | Vendor to specify | |
| 10 | SAFETY | | |
| 10.1 | The shot peening booth shall have all safety features included. Vendor has to specify the details of safety features. Proper interlocks are to be incorporated and their working to be fully functional at the time of trials | Vendor to confirm | |
| 10.2 | All the pipes, cables etc. of the equipment should be well supported and protected. | Vendor to confirm | |
| 10.3 | All the rotating parts used on equipment should be guarded and statically & dynamically balanced to avoid undue vibrations | Vendor to confirm | |
| 10.4 | If any safety / environmental protection enclosure is required it should be built in the machine by the vendor | Vendor to confirm | |
| 11 | ENVIRONMENT | | |

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| 11.1 | Noise level shall not exceed 85 dB (A), 1 meter away from the equipment. Reinforcement and thickness of ducts and chamber enclosure materials should be selected such that there is no unwanted noise when the shot peening booth is in operation. | Vendor to confirm | |
| 12 | AMBIENT CONDITION | | |
| 12.1 | All electrical and electronic components should be tropicalised to withstand ambient conditions of temperature max 50 degree C and relative humidity up to 85%. Both do not occur simultaneously. | Vendor to confirm | |
| 13 | SPARES : Optional | | |
| 13.1 | Itemized breakup of spares used on the equipment in sufficient quantity including shotpeening nozzles and robotic spares as per recommendation of vendor for trouble free operation should be offered by vendor. The vendor shall furnish the list of such items. (Unit Price of each item of spare should be offered separately in the price bid.) Spares related to Electrical Fuses, sensors and Electronics KTP-600 and PLC should be covered. | Vendor to confirm | |
| 13.2 | All types of spares of the equipment should be available for at least ten years after supply of the machine. If equipment is likely to become obsolete in this period, the vendor should inform BHEL sufficiently in advance and provide drawings of parts / details of spares & suppliers to enable BHEL to procure these in advance, if required | Vendor to confirm | |
| 14 | ERECTION & COMMISSIONING | | |
| 14.1 | Erection and commissioning of the entire system shall be under the scope of the supplier. 1. Supplier to take full responsibility for complete erection and commissioning. Start up, testing of equipment, it's control system & all types of other supplied equipment etc. are the responsibility of the supplier. 2. Service requirement like power, air & water shall be provided by BHEL at only one point to be indicated by supplier in their foundation/layout drawings. 3. Only crane facility will be provided by BHEL, free of cost. All other requirements like welding power source, consumables, Gas etc are to be brought by the supplier. | Vendor to confirm | |
| 15 | PROVE OUT OF THE EQUIPMENT : | | |
| 15.1 | Prove out of the equipment shall be done at BHEL works to the specified parameters for component mentioned at sub clause 15.3. Vendor shall be fully responsible for prove out the equipment as specified by BHEL to the full satisfaction of BHEL. Clarifications, if any required by vendor, regarding requirements of the prove out, whether specified or not, should be discussed and cleared by vendor during initial technical discussions. | Vendor to confirm | |
| 15.2 | Vendor shall establish the Almen strip at vendor site any one parameter from clause 3.4 | Vendor to confirm | |
| 15.3 | Vendor shall Prove the equipment on Frame 6 distance piece with shot size S330 to required almen intensity. At BHEL site. | Vendor to confirm | |
| 15.4 | Vendor to ensure first fill of shot for job prove-out with S-330 one ton capacity. | Vendor to confirm 1 Ton first fill shots supply. | |
| 16 | LEVELING & ANCHORING SYSTEM | | |
| 16.1 | Complete anchoring materials including foundation bolts, fixators, levelling shoes etc should be supplied by the Vendor. | Vendor to confirm | |
| 17 | FOUNDATION DETAILS | | |

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| 17.1 | Vendor shall submit the General arrangement layout drawing along with the offer. The layout shall show complete equipment with all accessories including space requirement for equipment and accessories. Vendor shall submit complete foundation details including static and dynamic loads within one month from the date of P.O. BHEL will construct complete foundation for the machine. | Vendor to submit.. | |
| 17.2 | The Vendor shall indicate detailed specifications of grouting compound and Grouting procedure etc. for foundation bolts of the machine. | Vendor to provide details. | |
| 18 | DOCUMENTATION | | |
| 18.1 | Three sets of following documents (Hard copies & Soft Copies) in English language should be supplied along with the machine. | Vendor to confirm | |
| 18.2 | PLC ladder / statement list with English comments (hard copy and soft copy) | Vendor to confirm | |
| 18.3 | All the backup data (PLC, HMI ,Robot) and Loading / Restoration softwares to be provided. | Vendor to confirm | |
| 18.4 | Operating manuals of Equipment. | Vendor to confirm | |
| 18.5 | Detailed Maintenance manual of the equipment with all drawings of assemblies/sub-assemblies/parts. | Vendor to confirm | |
| 18.6 | Catalogues, O&M Manuals of all bought out items including drawings, wherever applicable. | Vendor to confirm | |
| 18.7 | Make & Specification for all bearings used in the equipment should be provided | Vendor to confirm | |
| 18.8 | GA Drawing | Vendor to confirm | |
| 19 | INSPECTION AT VENDOR WORKS | | |
| 19.1 | Pre dispatch inspection will be carried out by BHEL Engineers to check the almen gauge test to be carried out for any one of the parameters mentioned as per clause 3.4 | Vendor to confirm | |
| 20 | PERFORMANCE TESTING AT BHEL: | | |
| 20.1 | Performance test will be carried out after commissioning of the equipment at BHEL. Job prove-out will be carried out as per clause 15.0. The complete machine will be demonstrated to full satisfaction of BHEL personnel. | Vendor to confirm | |
| 21 | TRAINING | | |
| 21.1 | After commissioning the Equipment at BHEL training is to be imparted to the operators and maintenance crew for a period of 2 days in the operation and maintenance of the equipment and system. | Vendor to confirm | |
| 21.2 | Robotics training to be given to the concerned BHEL Executives for better operation and maintenance. | Vendor to confirm | |
| 22 | GUARANTEE: | | |
| 22.1 | As per BHEL commercial terms & conditions | Vendor to confirm | |
| 23 | Packing (To ensure receipt of items in good condition) | Vendor to confirm | |
| 24 | GENERAL | | |
| 24.1 | Painting of Equipment - As per BHEL colour code to be done by vendor | Vendor to confirm | |
| 24.2 | Over all space required for the Shotpeening equipment including sub systems: L x W x H :- | To be specified by the vendor. | |
| 24.3 | Total connected load in KW : | To be specified by the vendor. | |
| 24.4 | Approximate total weight of the Equipment including accessories : | To be specified by the vendor. | |
| 24.5 | Weight of the heaviest Part or sub assembly : | To be specified by the vendor. | |
| 24.6 | Vendor to submit , along with offer, reference list of customers where similar or higher capacity machine have been supplied mentioning broad specifications of the supplied equipment, i.e. Model, Load Carrying Capacity etc. | Vendor to submit | |
| 24.7 | Detailed catalogues, sketch/ photographs of the equipment and accessories should be submitted with the offer. | Vendor to submit | |
| 24.8 | Vendor shall submit his latest design. In case of any variance with the present Spec., BHEL reserves the right to study & make minor changes. | Vendor to submit | |

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| 25 | Qualifying Criteria | | |
| 25.1 | Only those vendors (OEMs) satisfying the following criteria should quote. The vendor should have supplied and commissioned at least one 6-Axis or higher model of robotic shotpeening system in the past ten years (on the date of opening of Tender) and referred machine is presently working satisfactorily for more than one year (on the date of opening of Tender) after commissioning, should quote. The following information should be submitted by the vendor about the companies where referred machines have been supplied. | Vendor to Note | |
| 25.2 | Name of the customer/ company where similar equipment is installed. | Vendor to submit | |
| 25.3 | Complete postal address of the customer. | Vendor to submit | |
| 25.4 | Month & Year of commissioning | Vendor to submit | |
| 25.5 | Application for which the machine is supplied with details of accuracies achieved on the job. | Vendor to submit | |
| 25.6 | Name and designation of the contact person of the customer. | Vendor to submit | |
| 25.7 | Phone/ Fax / Email address of the contact person of the customer. | Vendor to submit | |
| 25.8 | Performance certificate from the customer regarding satisfactory performance of the equipment supplied to them. | Vendor to submit | |
| 25.9 | BHEL reserves the right to verify information submitted by vendor, in case the information is found to be false / incorrect, the offer shall be rejected. | Vendor to Note | |