

19.3	Oil circulation zone to control runner temperature	Oil circulation must be designed such that the desired temperature must be maintained effectively and uniformly in the CRB including nozzles. This may be achieved by providing multiple zone CRB preferably two zone. Oil must not leak or must not interfere with the rubber flow.
19.4	Silicone runner guide	These runner guides are silicone injection rubber movement from the main nozzle to the required injection points/ nozzles connected to the mold. There should be arrangement to use the mould in any combination so as to use any one cavity OR both cavities at any time (in case of multiple cavity)
19.5	Nozzles	Nozzles or injection points must located such that the runner wastage must be minimum during in the molding process. Vendor has to submit drawing for BHEL approval before taking up manufacturing of the mold and CRB. The drawing / detail must show the minimum wastage. Number of nozzles to be mentioned by the vendor in techno-commercial bid (Part A).
19.6	Insulation Slab	Slab must provide effective insulation between heating plat and the CRB block.
19.7	Heating Plate	Heating plate must be multi-zone preferably three zone heating plate with proper electrical Plug-In type connection. Vendor has to submit the electrical load by this heating plate in techno-commercial Bid Part A.
19.8	Silicone flow control	Manual silicone rubber flow control system to be provided in CRB / mold to control the Silicone rubber flow for different molding lengths.
19.9	Dimensions	Matching to mould and machine platen and locating ring position.
20	Compatibility	Machine and offered CRB in sl no 19 of this specification shall be compatible with the molds matching to 800 x 1600 platen size available at BHEL EPD, Bangalore
21	Domestic maintenance team	The machine manufacturer must have service agency in India to attend the problem associated with the machine, Mold and CRB on need bases.


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26/3/16
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DGM/ CTI

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Sr Manager / WEX

Yogesh Sharma
26/03/2016
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Sr Manager / CI

Seshapathi S
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Sr Manager/ IE

Y Ravi
26/3/16
Y Ravi
Dy Manager / WEX

 EPD - BANGALORE	Purchase Specification for Silicone Rubber Injection Moulding Machine- 630 T	SPECIFICATION NO. EP-WEX-IM/2015-16
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22	Pre Bid Meeting	<p>Pre-bid meeting shall be arranged at BHEL EPD with prior intimation, for clarifications and suggestions and any possible improvements. Vendors may suitably participate.</p> <p>Revision in the specification if any, it will be incorporated after the pre-bid meeting.</p> <p>Interested vendors are requested to submit their offer in line with the latest specification (after prebid meeting) which will be updated on the website subsequent to the pre-bid meeting.</p>
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**Note : 1. Any technical deviation should be brought out in a separate sheet
2. Offers must consist of basic Injection moulding machine, CRB and moulds.
The offer will be summarily rejected for non compliance of this criteria.**

Qualification criterion

Sl. No	BHEL Standard Terms & Conditions	Documentary Evidence provided for Compliance along with offer
1	The vendor shall be an Original Equipment Manufacturer (OEM).Dealers have to submit authorisation certificate from OEM	Copy of Company Incorporation or Management System certification e
2	The vendor shall have qualified personnel, their own adequate manufacturing / integrating and testing facilities for the equipment offered.	Submit company profile with details of qualified staff
3	The vendor shall have manufactured, supplied and successfully commissioned two injection Molding Machine for manufacturing of Composite insulators with a clamping force of Minimum 5500 kN and Injection volume of 10000 CC, platen of 800 x1400 and reference of equipment supplied minimum 3 nos in the last 3 years	PO copies to be submitted along with performance certificate from the users
4	The vendor shall submit audited balance sheet or tax returns or profit loss account for the last 3 years	Copy to be submitted

Wan
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Yogesh Sharma
Yogesh Sharma
Sr Manager / CI

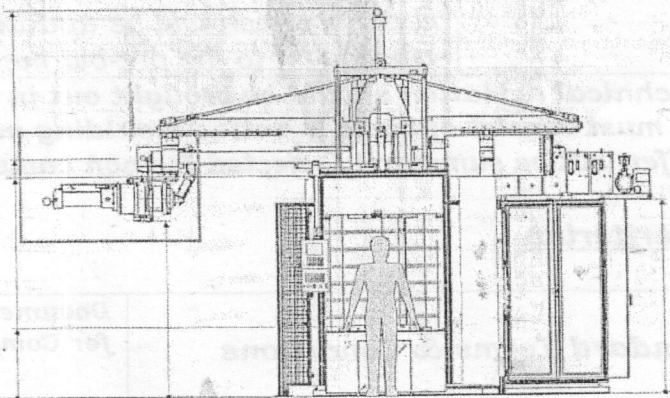
Seshapathi S
Seshapathi S
Sr Manager/ IE

Y Ravi
Y Ravi
Dv Manager / WEX

Note : The general arrangement shown is only indicative , however vendors offering better features may provide for enhancing operational productivity , quality etc.,

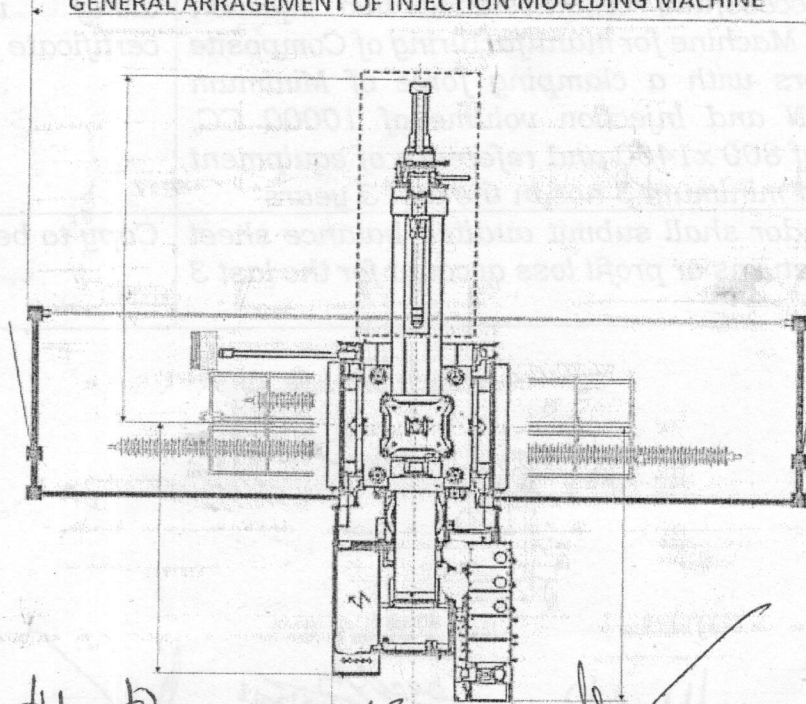
Annexure - I

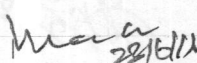
GENERAL ARRANGEMENT OF INJECTION MOULDING MACHINE

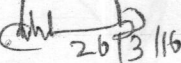


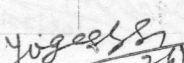
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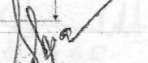
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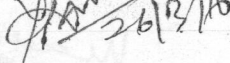



 Ravichandran S
 DGM / CII

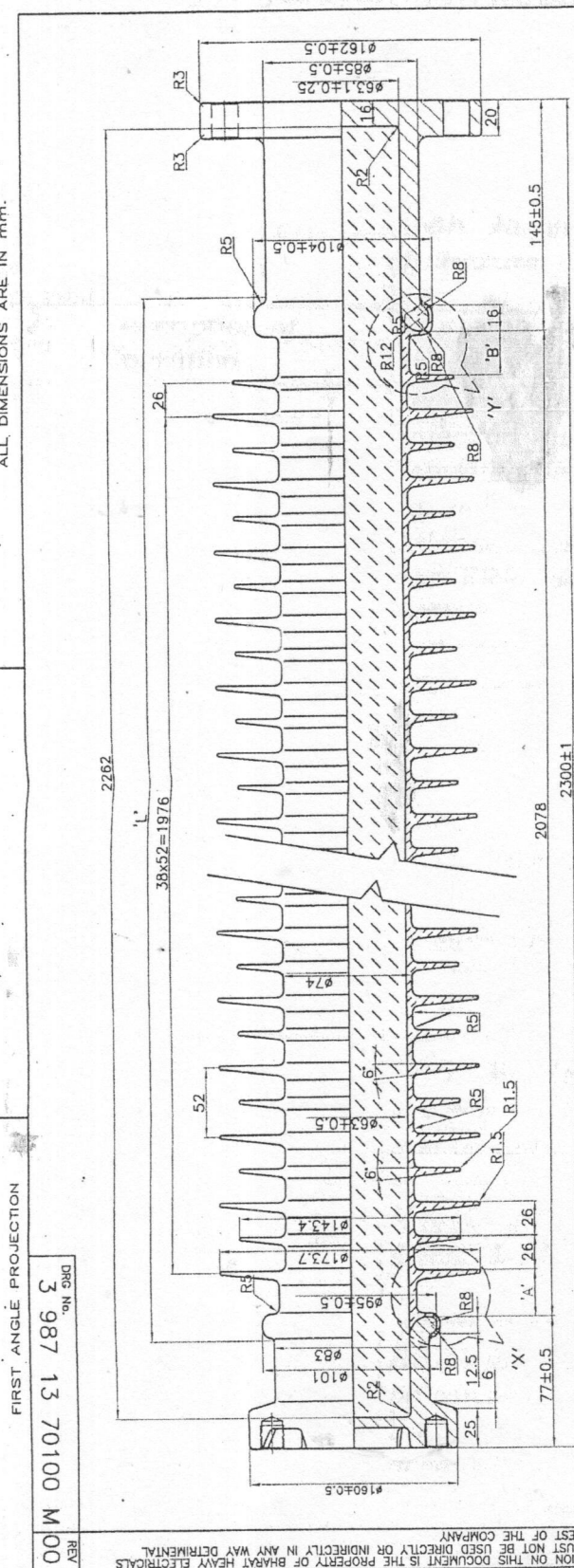

 S. Arunachalam
 Sr Manager / WEX


 Yogesh Sharma
 Sr Manager / CI


 Seshapathi S
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 Y Ravi
 Dy Manager / WEX

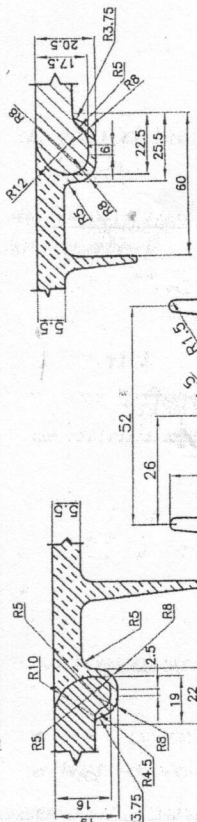
ALL DIMENSIONS ARE IN mm.



FOR FLEXI MOULD PROCUREMENT ONLY

- NOTES:**
1. ALL DIMENSIONS PERTAINS TO FINAL PRODUCT.
 2. CONSIDERED 1% SILICONE RUBBER SHRINKAGE ALLOWANCE AND OTHER PROCESS VARIATIONS WHILE DESIGNING THE MOULD DIMENSIONS.
 3. MOULD SHOULD CONFORM TO SPECIFICATION No. CI-MOULD-00-4. (LATEST REVISION)

CONTROL COPY



DETAIL Y

ITEMS	L	A	B	SHOT
33KV	319.5	27.5	23.5	1
44KV	332	32	25	1
66KV	627.5	24	23	1
SHORT SAMPLE	1835	22	21.5	1
110KV/986.5	22	20	20	1
132KV/1313	54.5	54	1	1
220KV/2110.5	38	36	2	2

SHED DETAILS

REV	DATE	ALTERED	CHECKED

DEPT	GRADE OF TOL DIM C/W/F	SCALE	WEIGHT (kg)	REF TO ASSY.ORG	ITEM No. OF ITEMS
BHEL					
BHARAT HEAVY ELECTRICALS LTD; ELECTROFACELAINS DIVISION BANGALORE 560 012			SIGN NAME MCHIRKANNA Y B R Y B R Y B R		DATE 30.01.15 30.01.15 30.01.15
TITLE COMPOSITE STATION POST INSULATOR (Ø63) (FOR MOULD PROCUREMENT)			DRAWING No. 3 987 13 70100M		REV. 00
INVENTORY No.			No. OF SHEETS		SHT.24 SIZE A3 420 x 297

FIRST ANGLE PROJECTION

DRG No. 3 987 13 70100 M 00
 REV 00

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REF. DRG. No.

SIGN AND DATE