

PRICE BID FOR " ASSISTANCE IN REPAIR OF FOUNDRY MACHINES IN 04,05 BLOCK & PATTERN					
Sl.No	WORK DESCRIPTION	Unit	Qty	Total Amount in Rs	G.Total Amount in Rs.
<b>NON-FERROUS FOUNDRY &amp; FETTLING SHOP [05 BLOCK]</b>					
<b>30Ton Annealing Furnace</b>					
1	i) Butterfly gas valves cleaning	Nos	20	4174.8	65648.73
	ii) Air valves cleaning	Nos	40	8349.6	
	iii) HUDCO gas valves cleaning	Nos	30	7827.75	
	iv) Pipeline Tar cleaning (12" dia)	metres	90	9393.3	
	v) Pipeline Tar cleaning (6" dia)	metres	50	5218.5	
	vi) Trolley wire rope annual replacement	metres	120	12524.4	
	vii) Ceramic hole & trolley lining repair	Sq. mtrs	12	6262.2	
	viii) Flue channel cleaning (Once/yr)	metres	25	2609.25	
	ix) Door ceiling checking & replacement, if any	metres	40	4174.8	
	x) Refractory activity removal & relining activity	Sq.Meters	49	5114.13	
<b>Shot Blasting</b>					
2	i) Rubber lining replacement (Once/yr)	metres	12	2504.88	25466.28
	ii) pipeline cleaning (20" dia) (Thrice/yr)	metres	30	6262.2	
	iii) Shots collecting chambers (4 Times/yr)	Nos	2	6262.2	
	iv) Shots conveyor belts repair & cleaning (3 Times/yr)	metres	20	10437	
<b>Induction Furnace</b>					
3	i) heat exchanger plates acid cleaning, Assembly (2 Times)	Nos	300	62622	112302.1
	ii) Cooling Tower cleaning	No.of Occasions	3	9393.3	
	iii) Coil cleaning [chemical] (3 Nos)	No.of Occasions	9	3757.32	
	iv) Raw water & DM water tank cleaning	No.of Occasions	8	33398.4	
	v) Bus bar trench cleaning from panel to furnace	No.of Occasions	12	3131.1	
<b>Khandelwala Furnace</b>					
4	i) Water tank cleaning (Once/yr)	Cu.metres	36	37573.2	206652.6
	ii) Furnace pit cleaning (4 Times/yr)	Cu.metres	40	83496	
	iii) Refractory activity removal & relining activity	Sq.Meters	41	85583.4	
<b>Gas Fired Furnace</b>					
5	i) Flue channel cleaning (1/2mx1m size)(Once/yr)	metres	100	52185	52185
<b>Swing Frame Grinder</b>					
6	i) Exhaust pipeline cleaning(20" dia)	metres	200	83496	83496
<b>FERROUS FOUNDRY [04 BLOCK]</b>					
<b>Induction Furnace</b>					
7	i) in case of furnace coil repair or replacement, the furnace accessories such as hose pipes, power leads, shunts etc,[inclusive of the coil] need to be shifted to a distance of 0.5 KM	No.of Occasions	48	25048.8	207696.3
	ii) In case of heat exchanger failure, the heat exchange plates need to be cleaned after pickling activity for which they need to be transported to a distance os 0.6 KM up and down.	No.of Occasions	100	52185	
	iii) Cleaning of jammed non return valves of all the induction furnace.	Nos	250	130462.5	

Continuous Core Sand mixers					
8	i) In case of replacement or repair of screws [approx. 4m length] they need to be dismantled and shifted to the 10Rs and again brought back to for refixing [approx. 1.5 KM up&down]	No.of Occasions	16	8349.6	17221.05
	ii) The belt conveyor repair/replacement for CCSM No-3 when the conveyor need to be totally replaced by a new one, it has to be transported to a distance of 0.4 KM.	No.of Occasions	17	8871.45	
Sand Plant					
9	i) Repair/replacement of sand conveyors, both magnetic and non-magnetic [These conveyors are to be transported to a distance of 0.5 KM]	No.of Occasions	46	96020.4	177429
	ii) Assitance to belt joint experts while making joints and fixing of new conveyors	No.of Occasions	19	39660.6	
	iii) Removal of rotating table of the sand mixer for repair works, if any, to be transported to a distance of 0.3KM.	No.of Occasions	20	41748	
New Sand Plant [Liners Manufacture]					
10	i) Shifting of gear assembly along with accessories to a distance of 0.3KM	No.of Occasions	26	54272.4	98107.8
	ii) Repair/replacement of sand conveyor attached to the machinery.	No.of Occasions	21	43835.4	
Spinners					
11	i) Belt conveyor replacement/repair of the centrifugal machine [0.3KM]	No.of Occasions	2	10437	161773.5
	ii) Shifting of pipes, valves, spinner parts to a distance of 0.5KM.	No.of Occasions	7	73059	
	iii) Replacement of damaged hose pipes for die cooling.	No.of Occasions	5	26092.5	
	iv) Transport and replacement of gas pipelines [0.5Km] for die heating purpose.	No.of Occasions	5	52185	
Drying Ovens					
12	i) Removal and replacement of insulation material of quantity [10 Cu.m]	No.of Occasions	5	52185	130462.5
	ii) Cleaning of gas pipelines and valves, with replacement activity as and when required.	No.of Occasions	15	78277.5	
Moulding Activities					
13	i) Removal and replacement of piston rings	No.of Occasions	15	31311	83496
	ii)Lubrication and hose pipe replacement	No.of Occasions	25	26092.5	
	iii)Replacement of piston	No.of Occasions	5	5218.5	
	iv)Replacement of air valves	No.of Occasions	10	20874	
Welding In Production					
14	i) Welding and cutting of angulars for supporting the cores in mould boxes	No of Occasion	25	26092.5	162817.2
	ii)Cutting ,repair & weldiong of damaged parts of laddles	No of Occasion	9	9393.3	
	iii)Furnaces Earths Probes Making and fixing[each furnace required 2 nos]	No of Occasion	11	11480.7	
	iv)Repair of damaged furnaces spouts	No of Occasion	10	10437	
	v)Continuos Core Sand Mixer Body Repairing Works	No of Occasion	11	11480.7	

	vi)Core supports welding works	No of Occasion	44	45922.8	
	vii)Excess metal removal from poured castings	No of Occasion	35	36529.5	
	viii)Repair of damaged parts of sand plant or new sand plant	No of Occasion	11	11480.7	
<b>ELECTRICAL MAINTENANCE WORK</b>					
15	Replacement of Modular Range of Switches, ICTPS, Fuses, sockets etc- in RM Boards,MCB Boards:	Nos	78	1628.172	6512.688
a	Routine preventive and electrical breakdown maintenance for pattern shop machineries (including cleaning & any replacement of contactors, fuses, starters, hose pipeline).	Nos	78	2442.258	
b	Including necessary replacement(contactors, connectors, relays, indication lamps,electrical switches, any spare parts in the control panel board etc.)	Nos	78	2442.258	
16	CEILING FANS/MAN COOLER/Pedestal FANS/EXHAUST FANS				
a	Attending all break downs of fans such as suspension arrangement in the concrete/slab/roof members.,Fan box with MS hook (to be provided under civil works) . Replacement of double ball bearing type, copper wound motor complete with canopy, down rod,blades etc. Maintenance of fanS shall be provided with electronic regulator. Electronic Regulator shall be suitable for 240 volts A.C supply 50 Hz and shall be of continuous duty type	Nos	9	939.33	6418.755
b	Attending all break downs of mancoolers such as suspension arrangement in members., Replacement of double ball bearing type, copper wound motor complete with canopy, down rod,blades etc. Maintenance of fan shall be provided with DOL starter. DOL starter shall be suitable for 240 volts A.C supply 50 Hz and shall be of continuous duty type	Nos	32	5009.76	
c	Attending all breakdowns of Exhaust fans [ heavy-duty type with double ball bearing and conforming to IS standard]. Exhaust fan shall be complete with copper wound motor,capacitor, Louver/shutter, frame and mounting bracket. Exhaust fan shall be suitablefan operation on 240 volts single phase A.C supply.	Nos	3	469.665	
17	Motors:-				
a	Periodic maintenance of AC/DC motor to be checked such as carbon brushes, commutator, terminal connection,DOL starters etc. for the machines.	Nos	25	3913.88	6523.14
b	Motor wiring throughly checked.	Nos	25	1304.63	
c	Replacement of fuse/breaker if it is blown off/tripped.	Nos	25	1304.63	
18	Electrical insulated Rubber Matts			0	

	Rubber mats to be laid in front of all electrical MCB/RM Boards	Nos	14	1461.18	1461.18
19	Providing Internal lighting			0	
a	The work include such as installing replacement of blown off bulbs/new bulbs and lamps, ballasts, adjusting, focusing or refocusing or operation of any permanent or temporary flood lighting systems, including parking lighting at entrance point/cabins/ shop floor area.	Nos	200	20874	20874
20	Cleaning			0	
	a. All the distribution boards in shop floor area should be thoroughly clean including interior parts of MCB & RM board.	Nos	78	16281.72	24422.58
	b. Storing of all electrical materials is to be kept clean and to be stored in an specified area as per BHEL Engineer instruction.	Nos	78	8140.86	
21	Protection			0	
	a. All material and work shall be securely fastened so that it cannot be easily removed or stolen	Nos	25	2609.25	5218.5
	b. All unused materials will be stored away in secured area.	Nos	25	2609.25	
22	WELDING :			0	
	Welding on electrical works shall be done wherever it is necessary at the time preventive maintenance work.	Nos	25	2609.25	2609.25
23	HANDLING MATERZAL:-			0	
	The handling and moving of all electrical material, equipment and apparatus shall be performed by whenever the machine is under break down/ periodic maintenance stage.	Nos	70	7305.9	7305.9
				1666100.07	1666100

Tenderers are required to quote their tender value on % age basis in the following table at

Tender (%)	In Figures
Excess	
Less	
Estimate Rate Only (On Par)	

	Applicable taxes	%
1	Service Tax on above	

(Signature & Stamp of the Vendor)