

SCOPE OF WORK

1. Tube sheet shall be loaded on vendors who are having the deep hole drilling machine facility with drilling depth of 550 mm.
2. A certificate to be produced along with technical bid by mentioning machine specifications , make and date of manufacturing of machine and machine condition.
3. Tube sheet forging will be supplied with Stainless steel overlay and machining and inspections of overlaid surface.
4. Tube sheet supplied with material attestation marks by concerned inspection agencies.
5. Material for Mock up piece shall be provided by BHEL. Three tube hole clusters shall be made on the mock up piece for our BHEL QC or BHEL appointed TPIA inspection, prior to start tube holes drilling on actual job.
6. Clearance for drilling of tube holes to be taken from the BHEL QC or BHEL nominated inspection agency.
7. All notes given on Tube sheet drawing shall be followed.
8. Mark axis on as per drawing and punch on marking at ends.
9. Every marking on tube sheet shall get inspection by BHEL nominated inspection agency.
10. All Tube holes to be drilled in single setting.
11. Get inspection of Tube holes after every 10 cycles for finish, ovality, ligament and drift.
12. Tube holes finish as indicated in the drawing shall be maintained.
13. Tube holes shall be drilled according to tube holes layout and as per tube sheet drawing.
14. Drift on Tube holes will not be acceptable.
15. Tie rod holes to be drilled and tapped on shell side as per drawing.
16. T3, T4 and T5 Nozzle holes on periphery shall be done as per drawing.
17. Chamfering of Tube holes both on shell side and Tube side shall be done as per det.-P of drg.
18. Get dimensional inspection of tube holes for layout, tubehole finish, ovality, ligament and drift.
19. Tube holes shall be answered to the BHEL supplied Go-No Go gauge.
20. Any deviation on the job is not acceptable.
21. Easily removable rust preventive shall be applied on all machined surfaces.
22. Machining of shell side step as per det.-R and tube side weld bevel as per det.-Q will be carried out at our BHEL works.
23. Submit dimensional report sheet along with dispatch of Tube sheet.
24. Machined Tube sheet shall be covered properly while transportation. BHEL will not provide any packing material.