

ANNEXURE-A

CUTTING/BEVELLING OF ARMOUR SHEET OF VARIOUS THICKNESS AT VFJ

a) SCOPE OF WORK

1. Cutting/Beveling of armour plates using portable CNC controlled plasma machine (along with all the necessary cutting/beveling consumables) as per the drawings of the individual components at VFJ. (For cutting/Beveling for 16mm Plate – Drg No. MPV-073-VFJ, for cutting/Beveling for 12 mm Plate, 640-01-1106-01/A)
2. The drawing in Auto CAD format will be provided by the VFJ.
3. The Firm will arrange its equipment to ensure that sheet of 6mtrs length is cut/beveled with no serration marks or steps in cutting and uniformity should be maintained properly.
4. VFJ will provide all armour sheets in standard size near the machine. The maximum size of the sheet will be 6.5mtrs x 1.8mtrs and the thickness of 12mm & 16mm. Loading and unloading of the sheets & finished Components on the m/c are to be done by the contractor. Lifting tackles & help of available material handling equipments namely fork lifters & overload crane (along with operator) will be provided by the VFJ. But manpower for loading and unloading of sheets & finished component will have to be organized by the Firm.
5. Optimum cutting/beveling layout on the sheet is to be worked out by the contractor & shall be approved by VFJ representative before commencement of actual cutting/beveling. Layout shall be such that there is Minimum wastage & optimum cutting/beveling length is achieved. Cut/beveling shall be of high quality and free from burrs to avoid any other secondary operation before welding. If required, firm will use hand grinder to remove burrs and to maintain the dimensions/ angle.
6. Engineers, operators, labours etc to be provided by the firm.
7. All the accessories (hardware & software) required for converting the AutoCAD drawing into the CNC Program for Cutting/beveling are to be arranged by the contractor.
8. Installation of the machine will be done by contractor, however VFJ will provide the floor space, power & Compressed air supply. Layout plan of the m/c is to be given to VFJ one month before commencement of work for arrangement of floor space & arrangement of electrical & air supply.
9. Completion Certificate (JCC) will be issued by User section duly concurred by QC/VFJ.

b) QUALITY REQUIREMENT

1. Cut/Beveling surface shall be free from burrs, must have mutually agreed finish to ensure that cut/ Beveling surfaces are ready for welding operating without the need of any secondary operation.
2. Dimensional accuracy shall be maintained by the firm strictly.


AWM/HFS


JWM/HFS