

RAMMER CHAIN TO DRG NO 172.26.004CB-5

Sl no.	Nomenclature & drawing No.	Manufacturing technology & Testing / Inspection Facilities required to produce the item	Essential (To be possessed by the vendor in his premises)(P&M list and testing / inspection equipment list to be submitted)	Desirable (May be posses by the vendor in his premises or out sourced)(Self declaration to be submitted)	FIRM Compliance (Y/N)	Remarks
1	172.26.004CB-5 RAMMER CHAIN	TECHNOLOGY-1	Turning	CNC Turning centre suitable to accommodate components of diameter 100mm with 0.010mm accuracy		
			Milling & Drilling	VMC/ HMC suitable to component size 100 x 250mm or more with 0.010 accuracy		
			Grinding	Internal/ External /Surface grinding machine as per child parts component requirement upto 0.010mm accuracy		
		TECHNOLOGY-2	Assembly	Work Benches and standard tools for assembly		
				Should develop/position the suitable fixtures required for assembly, Torque Wrenches, Lapping of cam clutch etc. as per process sheet & Ty Specification & Firm should submit the undertaking in this regard that they will create the required fixture facilities within 6 months from the date of receipt of order.		
		TECHNOLOGY-3	Experience	Firm should have experience in manufacturing the Chain type assemblies and Armoured items. Proof to be submitted.		
			Gas Carburizing	Gas carburising furnace		
			Hardening & Tempering	Hardening & Tempering furnace with Oil quenching facility		
			Protection coating	Oxidising Plant		

Devesh Kumar

Sum/smt

Sum/Trans

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1	172.26.004CB-5 RAMMER CHAIN	TECHNOLOGY-4 Raw material		Firm should be capable to arrange the raw material like forging, bar material etc as per drawing specification and standard.		
		TEST / INSPECTION-1 Test bench for testing the assembly performance	Should develop/position Test stand for Cycle testing as per drawing Specification & firm should submit the undertaking in this regard that they will create the Test stand facilities within 6 months from the date of receipt of order			
		TEST / INSPECTION-2 3D CMM Surface Roughness Tester		3D CMM 300 x 300 mm Surface Roughness Tester for Ra & Rz values		
		Gauges	Standard Gauges for checking Holes and threads suitable to the requirement of the components			
		Measuring Instruments	Vernier Calliper, Radius gauge, Feeler Gauge etc. suitable to the requirement of the components			
		TEST / INSPECTION-3 Hardness measurement		Brinell Hardness Tester Rockwell Hardness Tester Hardness Case depth testing facility		

Note : Justification for alternate facilities may be shared to prove that alternate facilities can be utilised to manufacture the item wherever the facilities are mentioned above are not available, but vendor has alternate facilities.

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