

SCOPE OF WORK

(UP TO 1ST STAGE MACHINING)

Introduction:-

Production of T-90 MKIII Hull up to 1st stage machining, involves manufacturing various major sub assemblies followed by Hull assembly & welding then machining. The scope of work is furnished below.

1. Production of T-90 MKIII Hull up to 1st stage machining, involves manufacturing of major 9 sub assemblies as indicated below.
 1. Rear plate
 2. Crank Case RH
 3. Crank Case LH
 4. Bottom plate
 5. Side plate RH
 6. Side plate LH
 7. Roof Rear
 8. Roof Front
 9. Nose Plate

The above sub assembly is then subjected for

- I. Hull assy (Box making)
 - II. Full welding of Hull structure
 - III. 1st stage machining (Crank case RH&LH free bore machining and stern milling)
- 2 Manufacturing process of Hull to be followed as per Russian technical documents and drawings provided by HVF.
 - 3 Assembly & Welding Fixtures are to be positioned by the firms as per the process requirements.
 - 4 Welding consumables required for manufacturing to be obtained from HVF approved suppliers only. Approved sources will be provided by HVF.

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- 5 Armour qualified Welders are to be engaged for welding of Hull structure. The details of welders planned to be engaged for hull fabrication has to be provided to HVF and all such welders have to qualify the test either at HVF Avadi or welding research institute (WRI) at BHEL, Trichy. Without qualifying the test no welder shall be allowed to carry out Armour Welding.
- 6 Raw materials required for manufacturing of Hull specifically Armour plates are to be procured from M/s SAIL, RSP as per the specification or from other sources as approved by HVF. For components made out of thermo press technology are to be procured from the approved sources of HVF only.
- 7 Machining facilities like 5 -Axis Plano Milling machine for Horizontal and vertical operations having minimum bed size of 8mX3.5m (Length x Width) is required for Hull machining.
- 8 Inspection reports of all the sub assemblies, up to 1st stage machining to be provided by the firm as per the process requirements provided by HVF for necessary clearance.
- 9 Proper preservation of all assemblies and Hull to be maintained as per the requirements.
- 10 In case of any clarifications, the firm may get clarified in advance from HVF.