Pre-qualification criteria for CYLINDER HEAD to Drg No.SB 20-06-01-5

ESSENTIAL P&M:

- a) firm should have following facilities for making aluminium casting:
 - Aluminium melting furnace with adequate capacity, core making, heat treatment, surface cleaning / abrasive, fettling backelizing, degassing (MDU)
 - ii. Testing facilities like spectroscope ultrasonic testing microscope for structural analysis, macro analysis and wet and gravity chemical analysis.

OR

- iii. Firm should have written MOU with an Indian firm having the above facilities to manufacture and supply the casting the same will be verified during capacity verification.
- b) HMC/VMC with axes strokes to accommodate component size 800 X 300 X 150 mm (L X W X H) and weight 30kg.
- c) jig borer /boring machine to carry out the line boring operation complying all the technical requirements.
- d) radial drilling machine
- e) Hydraulic press for pressing the valve seat / valve guide.
- f) Firm should have capable to design and develop the pressure testing fixture required to carry out the pressure testing operation.
- g) Component washing facility like jet washing.
- h) Skilled fitters to carry out the critical fitting operations.
- i) Adequate material handling facilities like EOT cranes forklifts etc.

DESIRABLE P&M:

1. Special purpose machine to carry out the boring operation in place of machine indicated at essential P&M (c).

INSTRUMENTS & GAUGES:

- 1. CMM to check the cylinder head.
- 2. Instruments / gauges to check the critical parameters of the component.
- 3. Skilled manpower to handle the sophisticated measuring instruments / gauges.