

PRE-QUALIFICATION CRITERIA FOR CRANK SHAFT (FULLY FINISHED) TO

DRG No. 3305-06-15

1. The firm should have Forging manufacturing facility for manufacturing similar type of steel forging (i.e.V-46-6 crank shafts) (or) should have tie-up with good forging manufacturing firms. The firm should produce the past records for supply of similar type if components.
2. The firm should have band saw (or) circular saw cutting machine (or) any other suitable machines to cut the end piece to carry out the mechanical & metallurgical properties to meet the drawing requirement.
3. The firm should have facing & centering machine (or) suitable alternate machine for carrying out facing & centering operation.
4. The firm should have heavy duty centre lathe (or) CNC lathe for carrying out the end turning operations.
5. The firm should have Horizontal boring machine (or) CNC HMC for carrying out the reference hole drilling, dia 50mm clearance slot milling operation.
6. The firm should have internal / external whirling machine (or) turn mill center to carry out rough/finish milling of journals, pins & webs. The firm should have capacity to produce minimum 40 Nos. per month.
7. The firm should have heat treatment facility to carry out the hardening process (or) should have tie-up with good HTP firms. The HTP firm should produce past records for carrying out the similar type of items.
8. The firm should have bend removal equipment (roller type) to remove the bend taking place during hardening. The bend removal should be done in hot stage.
9. The firm should have magnetic flaw detector (or) alternate machine to check the internal cracks.
10. The firm should have CNC turning centres for carrying out various turning operations like turning, boring, internal threading, chamfering as per drawing dimensions.
11. The firm should have special purpose machine (or) HMC for carrying out dia 45mm deep hole drilling operation. The firm should have capacity to produce minimum 40 Nos. per month.

