

**VENDOR QUALIFICATION CRITERIA FOR EXTRUDED STEEL PROFILES DATE 22/10/2021**

SL No	NOMENCLATURE & DRAWING NO	MANUFACTURING TECHNOLOGY & TESTING / INSPECTION FACILITIES REQUIRED TO PRODUCE THE ITEM	MUST BE POSSESSED BY THE VENDOR IN HIS OWN PREMISES (LIST OF PLANT & MACHINERY AND TESTING / INSPECTION FACILITIES TO BE SUBMITTED)	MAY BE POSSESSED BY THE VENDOR IN HIS OWN PREMISES (OR) MAY BE OUTSOURCED (NAME AND ADDRESS OF SUB CONTRACTOR, LIST OF PLANT & MACHINERY AND TESTING TO BE SUBMITTED)	
Raw Material: As per GOST : 19526-74(PNO : KE 857) material specification and technical requirements as per SPECIAL STEEL GRAGE 2Π or JACKAL (As per Drg No. 188.11.007) Vendor shall procure Raw Material from M/s. SAIL which is approved source of HVF as of now or any other source approved by HVF in future or Russian OEM with document proof.					
6	0185599019 GOST:19526-74(PNO:KE 857) ARMOUR STEEL	TECHNOLOGY - 1	Die Designing	Technical expertise and CAD/CAM Software for designing of dies suitable to profile as per given drawings.	
TECHNOLOGY - 2		Die Manufacturing	Converting the die drawing to Dies using CNC and Conventional Machines.		
TECHNOLOGY - 3		Cutting of Blanks	Band Saw / Power Saw cutting machine to cut the Raw material to required length.		
TECHNOLOGY - 4		Furnace	Oil furnace/ Electrical furnace/Induction Heating capacity with minium 1200°C for Heating the blanks.		
TECHNOLOGY - 5		Hot Extrusion	Hydraulic Extrusion press of capacity minimum 800T on with container Dia of 150mm minium.		
TECHNOLOGY - 6		Cooling	Cooling facilies after extruding the profiles min 3-5 °C /Sec		

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0185599019 GOST:19526-74(PNO:KE 857) ARMOUR STEEL	TECHNOLOGY - 7	Stress relieving	Furnace to stress relieve with temprature up to 600 - 700 °C.	
	TECHNOLOGY - 8	Tensile remediation	Suitable equipment to for tensile remediation of extruded profile. Min 20 Ton capacity.	
	TECHNOLOGY - 9	Roll Straightening	Facility for Roll straightening of the profile.	
	TECHNOLOGY - 10	Cutting to Length	Band Saw / Power Saw cutting machine to cut required length.	
	TECHNOLOGY - 11	Press Straightening	Suitable hydraulic press for straightening the Profile length. Min 50 Ton capacity.	
	TECHNOLOGY - 12	Final Inspection	Inspection instruments: Vernior Caliper, Bevel Protractor, radius gauges and accessories for measuring and confirming the dimensions.	