PRE-QUALIFICATION CRITERIA FOR TRADE ASSISTANCE IN MACHINING OF CYLINDER HEAD LH & RH 20-06-16-5 & 20-06-34-5 (OPN.NO 20-530)

a) HMC/VMC with axes strokes to accommodate component size 800 X 300 X 150 mm (L X W X H) and weight 30 kg.

b) Firm should have expertise in designing complex fixture special tools and gauges in house / tie up for designing and manufacturing of the above.
c) Firm should have sufficient space and facilities for deburring and checking the components.
d) Radial drilling machine.
e) Horizontal boring machine.
f) Hydraulic press for pressing the valve seat / valve guide.
g) Valve seat generation / chamfering facility.
h) Firm should be capable to design and develop the fixture and other facilities required to carry out the pressure testing operation. Firm should have (or) create pressure testing facilities at their premises after receipt of the supply order. After completion of all machining operation the last operation pressure testing should be carried out. Final acceptance of the component / assembly may be decided based on water pressure testing outcome. Water temperature; pressure and duration of testing should be maintained as per drawing / process sheet.
i) Components washing facility like jet washing facilities should be available / created.
j) Adequate material handling facilities like EOT cranes forklift etc.
k) Firm should have skilled fitters to carry out the critical fitting operations.

QC CRITERIA

1. CMM to check the cylinder jacket.
2. Instruments / gauges to check the critical parameters of the component.
3. Skilled manpower to handle the sophisticated measuring iinstruments / gauges.
4. Firm should ensure the supply of items as per drawing dimension and technological requirements.
5. Firm should send the component inspection data for each component.

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