PRE-QUALIFICATION CRITERIA FOR FORKED CON ROD (UPTO OPN NO. 100), DRG NO. 20-04-12-4

a) Firm should have Tie up with ISO Certified firm for purchase of input material (Steel 18X2H4MA)
b) Cluster of forging hammers with suitable capacity to forge steel components of 7 to 10 Kg in weight.
c) Should have supplied forgings of similar complexity and weight.
d) Firm should have capacity to manufacture Forging Dies, Jigs or Fixtures as per requirement.
e) Firm should have cluster of CNC Vertical Machining Centers with suitable spindle power and table size
f) Pneumatic de-burring equipment to apply neat and uniform de-burring.
g) In house heat treatment facility and Shot/Sand Blasting equipment for heat treatment and de-scaling.
h) Inspection room with proper illumination, clean work space and adequate inspection equipment (Co-Ordinate Measuring Machine, height master, surface table, bore dial gauges, Vernier Calipers).
i) Firm should have standby power and compressed air sources
j) Firm should have enough staff/workmen with adequate technical knowledge /skills for making subject component
k) Firm should have in house inspection facility to check physical, chemical mechanical properties of raw material, crack detection equipment OR tie up with reputed NABL accredited Laboratories.
l) Firm should submit relevant test certificates, test reports, inspection report during the time of sample delivery / bulk delivery.

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