Pre-qualification criteria for CYLINDER HEAD to Drg No.SB SB 306-02-20

Essential P&M:

- a) Firm should have following facilities for making aluminium casting:
- I. 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 1400 X 300X150 mm (L X W X H) and weight 45 kg
 - c) Radial drilling machine.
 - d) SPM / JIG BORER / boring machine to carry out the line boring operation complying all the technical requirements.
 - e) Hydraulic press for pressing the valve seat / valve guide.
 - f) Firm should be capable to design and develop the pressure testing operation.
 - g) Component washing facility like jet washing.
 - h) Skilled fitters to carry 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 indicate at essential P&M (d)

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.