



**PRE-QUALIFICATION CRITERIA FOR CYLINDER BLOCK CRANKCASE (CASTING & FULLY MACHINING) TO DRG No.SB 20-01-02-9**

1. EFA plans to develop vendors for aluminium alloys casting for Cylinder Block Crank Case (Casting & fully machining).
2. The prospective vendors must be supplying or must have supplied large intricate aluminium engine casting to reputed engine manufactures.
3. The vendors, who are interested in supplying such castings, with fully machining should have their own manufacturing facilities or getting the casting from reputed manufacturers should have tie-up with them. The firm should have a large manufacturing base, adequate financial strength as a well-documented quality system. The manufacturer should have adequate infrastructure like large area industrial shed, power backup, air compressors etc.
4. The casting manufacturer shall buy all input materials for liquid metal as well as for moulding and core making from reputed manufacturers only. Necessary material certificates for all input materials and additives should be available.
5. The vendors must have adequate trained, experienced and skilled manpower.
6. It is preferable that the firm is registered with any government organization like DGQA/Depts/PSUs.

**Cylinder Block Crank Case Casting to Drg. No. 20-01-16-10**

**7. THE FIRM SHOULD HAVE FOLLOWING FACILITIES AND REGULARLY MANUFACTURING OF ALUMINIUM CASTINGS.**

- a) Aluminium melting (Electrical resistance or LPG fired only) furnaces with control systems of adequate capacity from 500 kg to 1 ton.
- b) Transfer Ladles, holding (preferably with dosing facility) furnaces.
- c) Resin sand moulding.
- d) Capacity of the Auto resin mixer should be 5 to 10 ton preferably.
- e) Suitable core making facilities (like hot box, cold box and shell core) with latest core shooter and related mixers, core ovens etc.
- f) Ladle and dies LPG pre – heating facilities.
- g) The firm should have Argon Degassing (MDU) plant.
- h) The firm should have density meter to check the effect of the degasification.
- i) Facilities for backelizing.
- j) Hydraulically operated gravity die casting machines.
- k) Heat treatment (solution sign aging facilities.)
- l) Vacuum Impregnation plant for sealing to eliminate of micro porosity.
- m) Firm should have or create autoclave chamber with 6 bar pressure (Firm to indicate the commitment in the tender alternative facility (incase autoclave chamber not available for making the casting).
- n) The general quality requirement of the casting to be manufactured by the vendor shall confirm to the technical document TTM 27-87 (copy enclosed).
- o) Pressure testing facilities.
- p) Abrasive blasting / surface cleaning facilities.
- q) Fettling facilities like band saw, mechanical grinders etc.

**8. THE FIRM SHOULD HAVE THE FOLLOWING FACILITIES COMPULSORY AT THEIR PREMISES FOR FULLY MACHINING Cylinder Block Crank Case Assembly to Drg. No SB 20-01-02-9.**

- a. HMC/VMC /VTL with axes strokes to accommodate component size 900x1000x700 mm and weight 160 Kg.-
- b. CNC horizontal boring / HMC size 1.5 m x 1.5m x 1.5m minimum.
- c. CNC vertical machining centre size 1m X 1m minimum.
- d. CNC VTL swing dia 1 m minimum.

