

SCOPE OF WORK FOR CONVERSION OF 6082 GRADE ALUMINIUM ALLOY ROD WITH SIZE: 85MM DIA MM INTO 20+0.2/-0.1 MM THICKNESS X 85(+0.2/-0.2) MM DIA MACHINED BLANKS TO OFAJ DRG NO CC-496E.

1.0 Scope of work

- 1.1 Collection of Aluminum Rod from OFAJ.
- 1.2 Slug Cutting of rod by shearing operation followed by machining as per drawing CC-496E
- 1.3 Dispatching of machined blanks to OFAJ along with suitable protection ensuring safe delivery to OFAJ.

2.0 Delivery Condition:-

- 2.1 Firm has to maintain the supply rate on weekly basis @ 2000nos minimum or 8000 nos. monthly whichever higher.
- 2.2 The Firm shall deliver the machined blanks duly passed to OFAJ for final inspection.
- 2.3 The Firm has to arrange transport for collection of Aluminum rod from OFAJ to their Works and return to OFAJ after conversion, at their own cost and risk. Necessary laborers shall be provided by the Firm for Loading and Unloading of Aluminum rod /machined blanks and scrap at OFAJ. OFAJ shall only provide overhead Crane/forklift if required to facilitate loading and unloading of component free of cost.
- 2.4 Failing to meet the monthly supply schedule committed by the firm even after lapses of 02 months from the date of contract, OFAJ reserves the right to reduce the order Qty to the limit of average monthly supply by firm in previous months.

3.0 Pre-qualification Criteria:

- 3.1 The firm must have in-house adequate shearing and machining facilities (shearing machine and CNC machine with cutting capacity minimum 2000 nos. of said blanks per week) available at their works required for slug cutting and machining operations for the subject components as per attached drawing. The firm should attach the exhaustive List of Plant and Machinery indicating machining capacity of given component (Drg no. CC-496E).
- 3.2. Firm should provide the evidence of experience of the same/similar (Cutting /machining of Aluminium component having greater than 20mm diameter/ thickness) in the form of Supply order copies along with Job completion certificate/ Customer satisfaction certificate from any of the central govt./PSUs/state govt./ reputed private firm (listed in NSE/BSE) and submit along with the bid.
- 3.4 If feels necessary, OFAJ may carryout capacity verification of the firm to ascertain the slug cutting and machining capacity mentioned by the firm in bid.

4.0 Consignee :-General Manager, Ordnance Factory Ambajhari, Nagpur, Maharashtra. Pin-440021

5.0 Conversion of Aluminium rod into Blank dia.85mm :

- 5.1 The FIM quantity for one blank is 400 gm.
- 5.2 Firm shall convert the rod into round blank to size dia. 85 (+0/-0.3)mm X 20.5(+0.2mm) thickness.
- 5.3 Final weight of machined blank is 310 gram max.
- 5.4 Process loss up to 5% on input material weight is allowed.
- 5.5 Return of material is as follows:
 - a) Input FIM for one blank = 400 gm
 - b) Output weight of finished machined blank = 310 gm max
 - c) Process loss on input @5 %(maximum that includes shearing and machining loss) = 20 gm per blank
 - d) Scrap generated, $a - (b+c) = 70$ gm
 - e) Both the faces of blanks must be machined to remove uneven surfaces. The blanks having uneven surface in finished blanks will not be accepted by OFAJ.

The firm should ensure entry of code and description in the invoice/cnslan as given below during each time of supply/return of scrap/rejection/FIM etc.

SL.	FIM Description/FIM return code	Scrap return code	Finished product code (for OFAJ use)
01.	Item Code BAMR000085 ALUMINUM ALLOY ROD DIA 85MM	0699222900	W472015005

6.0 Inspection:-

- 6.1 Final Inspection shall be carried out at OFAJ. However OFAJ reps may visit the firm for audit inspection if required. Firm has to provide all necessary arrangement for the same.
- 6.2 The inspecting authority or the purchaser shall have free access to the works of the manufacturer at all reasonable times. The outcome of final inspection at OFAJ shall be binding for both the parties.
- 6.3 Maximum allowable rejection is 1% on input material and rejected components has to be returned to OFAJ. If the rejection is beyond 1%, cost of each rejected blank will be recovered from the firm both from MSD, PSD or any pending bills at OFAJ equivalent to FIM of each blank and return the rejected blank to OFAJ for which no residual value of rejected blank shall be paid to the firm.

7.0 Protection and Packing:-

- 7.1 Machined component to be packed and protected suitably to avoid any damage/deterioration during loading, unloading and transportation.
- 7.2 Notwithstanding anything contained in the specification, the responsibility of carrying out proper packing and following good engineering practices to ensure safe and damage free delivery of finish component shall rest with the firm.

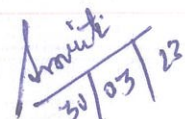
8.0 Payment:-

Payment shall be made as per OFAJ payment terms and condition mentioned in bid.

9 General Conditions:-

- 9.1 The Firm may check the dimensions of the input material before undertaking for the processing of the job at their end and point out deviation, if any.
- 9.2 Appropriate inspection facilities to be provided by the Firm as and when required by OFAJ authorized inspectors.
- 9.3 Necessary tools fixtures, Gauges and measuring equipment's to be arranged by the firm at his own cost.


HOS/CCS


WM/CCS