

Pre-Qualification Criteria for Machining of 250Kg Steel Bottles/Shell Body (As per Drawing)

**Essential Facilities:**

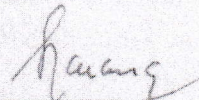
- 1) Horizontal Boring Machine
- 2) Lathe/turning (CNC or manual) machine having suitable dimensions (Bed Length/Chuck Dia.) to accommodate the job. All the necessary attachments i.e. Steady Rest, Revolving centre etc. of suitable dimensions required for machining of the component.
- 3) CNC Turning Centre of minimum 4m bed length and having:
  - a) Swing over carriage wings : 600 mm.
  - b) Turning over cross slide : 500 mm
  - c) Chuck dia.: 500 mm
  - d) Anti-vibration boring bar of suitable length to finish inside machining.
- 4) Slotting machine/milling machine/Radial drill machine.
- 5) Welding Machine (Arc/Gas)
- 6) Facility for measuring of wall thickness (Ultrasonic Thickness Gauge machine/open ended caliper) and other measuring equipments.

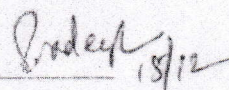
**Desirable Facilities:**

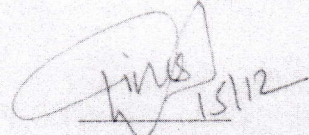
1. Band Saw Machine
2. Grinding Machine (Pneumatic Grinder)

**Note:**

1. The facilities indicated above are bare essential, better machine configurations also recommended.
2. Firm shall preferably have all the essential facilities "in-house" or having maximum one facility outsourced (except essential facility mentioned in point no. 3 which is mandatory essential facility required for the machining). For outsourced facilities, firm shall produce a MOU with a firm who has the capability and capacity to support the intended tenderer. In such cases, CV team shall ensure capacity verification of the supporting firm too.
3. For desirable facilities the firm shall have proper quality assurance plan and system to ensure desired level of quality of inputs/input services.
4. All the facilities, whether in-house or outsourced should be capable and suitable for producing the machined job/component as per drawing.

  
Jt. GM/Prod 15/12/18

  
WM/GMS

  
WM/EO&QC  
(for QC)