Pre-qualification criteria for CRANKCASE ASSY to Drg No.SB 3301-15-30 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 blasting, 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 same will be verified during capacity verification.
- b) HMC/VMC with axes strokes to accommodate component size 1400 X 600 X 350 mm (L X W X H) and weight 150 kg.capacity of the tool magazine should be minimum 60 tools.
- c) Radial drilling machine to drive the studs with interference of 0.14 to 0.16 mm in to crank case.
- d) JIG BORER /Boring machine to carry out the 3 stages of boring operation complying all the technical requirements.
- e) Firm should be capable to design and develop the pressure testing fixture required to carry out the pressure testing operation.
- f) Components washing facility like jet washing.
- g) Skilled fitters to carry out the critical fitting operation.
- h) 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 indicated at essential P&M (e).

INTRUMENTS & GAUGES

- 1. CMM to check the crank case.
- 2. Instruments / gauges to check the critical parameters of the component.
- 3. Skilled manpower to handle the sophisticated measuring instrument /gauges.