

Annexure 'A'

Acceptance Criteria of cylinder for metal case drawing no. OFBH/SK/1406.

Eligibility Criteria for firm:

Essential Criteria:

1. Firm should have vertical Milling center with X-travel of 1000 mm (min).
2. Firm should have CNC turning machine.

Desirable Criteria:

3. Firm should have in-house Tool Room facility.
4. Firm should have CAD/CAM facility.

The acceptance criteria for cylinder are as follows.

1. Cylinder should be supplied as per drawing No. OFBH/SK/1406.
2. For detail of the mentioned standard, firm may communicate with the OFBH. The equivalent standard will also be provided.
3. Raw materials must be procured from the reputed vendors conforming to the specification. The manufacturer shall undertake chemical and mechanical testing of raw material in accordance with the relevant specification quoted in the drawing/specifications from NABL/GOVT LAB and NABL test Certificates to be submitted by the manufacture as per specification.
4. The Supplier shall submit the manufacturing / fabrication process schedule with relevant control points for stage inspection and quality assurance plan to the inspecting authority for approval before starting any process. Once the process of manufacture/fabrication has been documented, process sheets prepared and approval granted, no changes should be allowed without the written approval of the Inspecting Authority.
5. Components shall be manufactured as per the approved plan from the specified materials and should meet all physical, chemical, metallurgical and geometrical requirements as indicated by relevant drawing/ specification.
6. The supplier shall fabricate initial samples (prototype), which shall be taken up for further assembly & various qualification testing at OFBH. Only on clearance of the same, the bulk production clearance shall be accorded by OFBH.
7. The Supplier shall ensure during manufacturing of this container that there is no sharp edges, All edges to be rounded.
8. Cylinder should not have ovality.
9. Tests of cylinder for leaks by internal gauge pressure of 0.02 MPA (0.2kgf/cm²) for 30 s by pressure decay test method. Pressure drop of 0.02kgf/cm² maximum is allowed, further pressure drop impermissible.
10. Test for leaks, internal gauge air pressure of 0.02 MPA (0.2kgf/cm²) for 1 minute by immersion in to liquid is allowed. Air bubbles are not allowed.
11. The supplier is responsible for inspection/ testing requirement as per relevant drawing/QAP /specification using his in-house facility or as per the directive issued by the Inspecting agency.
12. Damaged during the course of transit etc., shall be replaced free of cost by the supplier. Also supplier is responsible for transportation/ storage of components in suitable transit packages in such a way that the components are protected from abrasion, corrosion, mishandling and other environmental effects.
13. After supply of container at OFBH, if any defects observed during final assembly or testing that is to be repaired free of cost by supplier.

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SRIN/AV