

VENDOR QUALIFICATION CRITERIA (VQC) ROAD WHEEL ASSY TO DRG NO. 172.50.001CB-BCB

1	2		3		4	5	7
NOMENCLATURE & DRAWING NO	MANUFACTURING TECHNOLOGY & TESTING / INSPECTION FACILITIES REQUIRED TO PRODUCE THE ITEM		MUST BE POSSESSED BY THE VENDOR IN HIS OWN PREMISES	PROVIDE DETAILS OF THE FACILITIES ASKED IN COLUMN 3 THAT ARE AVAILABLE IN- HOUSE (SELF-DECLARED P&M LIST (Name of the facility/machine, Make, Date of installation, Capacity/Technical specification. (capacity, accuracy, precision & etc.) AND TESTING/ INSPECTION EQUIPMENT LIST (Name of the Testing/Inspection Equipments, Make, Date of calibration, Calibration agency(In- house/Out sources)) ALSO TO BE SUBMITTED)	MAY BE POSSESSED BY THE VENDOR IN HIS OWN PREMISES OR OUT SOURCED	PROVIDE DETAILS OF THE FACILITIES ASKED IN COLUMN 5 THAT ARE AVAILABLE IN-HOUSE OR OUT-SOURCED FIRMS (NAME AND ADDRESS OF THE SUB-CONTRACTOR TO BE DECLARED BY THE FIRM IN FIRM'S LETTERHEAD, SELF-DECLARED P&M LIST(Name of the facility/machine, Make, Date of installation, Capacity/Technical specification. (capacity, accuracy, precision & etc.) AND TESTING/ INSPECTION EQUIPMENT LIST LIST (Name of the Testing/ Inspection Equipments, Make, Date of calibration, Calibration agency(In-house/Out sources)) ALSO TO BE SUBMITTED)	Remarks
ROAD WHEEL ASSY Drg. No. 172.50.001CB-BCB	TECHNOLOGY 1	FORGING			FORGING PRESS FOR FORGING OF ALUMINIUM ALLOY DISC OF SIZE (MIN) 665MM (DIAMETER) WEIGHING AROUND 90 KGS OR MORE.		
	TECHNOLOGY 2	TURNING AND DRILLING	CNC TURNING CENTER (DIA 250 MM OR MORE)				
			CNC MACHINING CENTRE (300 X 300 MM OR MORE)				
	TECHNOLOGY 3	CHROMIUM PLATING			THE FIRM SHOULD HAVE TIE-UP/IN-HOUSE FACILITY FOR CHROMIUM PLATING PLANT AND PHOSPHATING PLANT		
TECHNOLOGY 4	MACHINING OF DISC	CNC VERTICAL TURNING LATHE (CHUCK DIA 800 MM OR MORE)					

ROAD WHEEL ASSY Dr. No. 172.50.001CB-BCB	TECHNOLOGY 5	HEAT TREATMENT			THE FIRM SHOULD HAVE IN-HOUSE FACILITY FOR ALUMINIUM ALLOY HEAT TREATMENT OF SOLUTIONISING AND AGE HARDENING FURNACE/CHAMBER.		
	TECHNOLOGY 6	RUBBERISATION			THE FIRM/SUB VENDOR MUST HAVE THE FOLLOWING FACILITIES AT THEIR PREMISES:: 1) RUBBER BLENDING MIXER. 2) SUITABLE INJECTION MOULDING PRESS 3) CONTROLLER ENVIRONMENT FOR STORAGE OF RAW MATERIALS AND FINISHED PRODUCTS.		
	TECHNOLOGY 7	ASSEMBLY	SUITABLE TOOLS LIKE CALIBRATED TORQUE WRENCH (0-25 KGF-M RANGE) CUTTING PLIERS ETC				
	INSPECTION 1	DIMENSIONAL CHECKING	1. SUITABLE STANDARD CALIBRATED GAUGES LIKE VERNIER CALIPERS 3 PIN MICROMETER , DIAL GAUGES ETC 2. 3D CMM i) FIRST AXIS (X-OR-Y) – 1200MM OR MORE ii) SECOND AXIS (Y- OR-X) – 900MM OR MORE. iii) THIRD AXIS(Z) – 600MM OR MORE		1) CHROMIUM PLATING THICKNESS CHECKING METER/DEVICE RANGE 0-100 MICRONS		

ROAD WHEEL ASSY Drg. No. 172.50.001CB-BCB	INSPECTION 2	MATERIAL TESTING			MATERIAL TESTING FACILITY FOR RAW MATERIAL SPECTO METER RADIOGRAPHY / ULTRA SONIC TESTING ETC		
	INSPECTION -III	RUBBER TESTING			THE FIRM/SUB VENDOR MUST HAVE THE FOLLOWING FACILITIES AT THEIR PREMISES I) RUBBER TENSILE TESTING – UTM II) HARDNESS TESTER III) DENSITY TESTING APPRATUS. IV) REOMETRY FOR ANALYSIS OF RUBBER COMPOUND THE FIRM SHOULD HAVE TIE- UP / IN-HOUSE FACILITY FOR I) POLYMER IDENTIFICATION AND TGA ANALYSIS FOR QUALITATIVE AND QUANTITATIVE ANALYSIS OF RUBBER COMPOUND.		

** Self-declaration to be submitted for outsourcing.