

NORTHERN RAILWAY MECHANICAL WORKSHOP,
AMRITSAR WORKSHOP

Hydraulic Press, Cap.- 200T

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IMPORTANT FEATURES OF THE TENDER

1. INSTRUCTIONS TO TENDERERS FOR FILLING TECHNICAL BID

- 1.1 Unless otherwise stated, latest alterations/ revisions of specifications/ standards/ drawings shall be applicable. In respect of safety standards and environmental standards relevant to the machine, the machine manufacturers shall ensure compliance with International (CE/ISO/DIN/JIS)/National standards (IS) (wherever applicable).
- 1.2 Tenderers should offer and quote for all the specified concomitant accessories, as these are considered essential for commissioning and utilization of the machine. Even if bidder does not recommend the purchase of any of these accessories, the price must be quoted for comparison purposes and their recommendation/suggestion to be indicated in the offer. Tenderers should also quote for optional accessories, spares and consumable spares as asked in the specifications.
- 1.3 In case, any item is required in sets, please specify nos. /pieces per set. This is essential for proper technical evaluation of the offer. Offers received without this may be considered as incomplete and liable to be rejected.
- 1.4 The bidder should quote only for the specified make of sub-assemblies and equipment wherever specified. Makes of sub-systems other than the specified ones will normally not be acceptable. In case, some other make is quoted, specific reasons for the same including its features/advantages over specified makes must be brought out in the offer.
- 1.5 In case there is a contradiction in any information provided (some parametric values given in the specification and those given in the brochure or some other document enclosed by the tenderer), unless specifically mentioned in the deviation cum confirmation statement under Annexure A of Section VI, the values as given in the specification shall be taken as confirmed by the tenderer and offer evaluated accordingly.
- 1.6 Bidder or his authorized agent, in their own interest, should visit the consignees listed in clause 3 Section-IV with prior appointment with Controlling Officer of the consignee and acquaint themselves with existing process of manufacturing/remanufacturing, site conditions, availability of material handling facilities etc.
- 1.7 The Purchaser may accept internationally accepted alternative specifications which ensure equal or higher quality than the specifications mentioned in the Technical Specification. However, the decision of the Purchaser in this regard shall be final. A copy of the alternative specifications offered should be sent along with the offer. The Tenderer should also furnish "Statement of Deviations" from tender specifications (as per Annexure A, Section-VI) along with the offer.

2.	DESCRIPTION: Hydraulic Presse as per Specification No. ASRW/HP-200T/2025 -26 given in Schedule-1A of section IV.
2.1	The press shall be capable of:
2.1.1	(a) Bending, straightening, forming, pressing-in and pressing-out operations and various operations for the consignees on various components as required by Indian Railways mentioned in Annexure-F .
2.1.2	It shall be possible to preset the ram stroke with an accuracy of at least ± 0.5 mm
2.1.3	The press shall be rigid and of robust design to withstand the normal workshop environment of Indian Railway's repair workshops with ambient temperature ranging from -4°C to 50°C and relative humidity up to 98%. The press shall be designed for continuous working for two 8-hour shifts per day.
2.1.4	Press structure shall be able to support a work piece weight upto rated capacity.
2.1.5	Operating in semi-automatic mode with quick approach, slow down just before pressing, pressing for a pre-determined period of time, slow release and quick return. It shall also be possible to execute each of these operations individually.
2.1.6	The press shall be easy to operate and operator friendly.
2.1.7	The hydraulic press shall be foolproof and fail-proof, absolutely safe to operate.

Schedule-1A		
Applicable for 200T Down-stroke C- Frame Vertical Type Hydraulic press for Consignee – CWM/ASRW		
2.2	Leading parameters	
2.2.1	Major parameters: (Note: No deviation in major parameter shall be accepted.)	
1.1	Type of press	Open front "C" frame vertical type
1.2	Pressing force	200 T (minimum) (in down ward direction)
2.2.2	Other parameters	
1.1	Stroke (adjustable)	600mm (minimum)
1.2	Daylight	800 mm approx.
1.3	Working table size (LXB)	2000X 900 mm (min)
1.4	Ram Block Size (LXB)	660x660 mm
1.5	Working height	700-750mm
1.6	Parallelism between top and bottom heads:	0.05mm per 300mm
1.7	Flatness of surfaces	0.03mm per 300mm
1.8	Ram speeds (max. permissible variation: $\pm 10\%$)	
	Approach speed:	40mm/sec.
	Pressing speed:	5mm/sec.
	Return speed:	60mm/sec.
1.9	Geometrical accuracies of the press	As per IS: 14877 (Pt. I) : 2000 Grade 2

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1.10	Motor Power	20 HP
1.11	Power supply	415V+/-10%, 50Hz.+/-3%
1.12	Hydraulic oil tank capacity	450 Liters (minimum)
1.13	Two nos. separate earth pits will be provided and connected.	
Note:- (i) This press is preferred with heat resistant ram bottom to prevent heat transmission to piston oil seals during welding of draft gear rear plate in pressed condition.		

2.3 Performance Standards.

The machine should have geometrical accuracies as per Indian Standard Specifications IS: 14877(Pt.1):2000 Grade 2 or equivalent International Standards which shall be mentioned in the offer.

2.4 Productivity: Not Applicable

2.5 Prove out at firm's premises.

- A load test shall be carried out at the manufacturer's works. Rigidity of the machine shall be demonstrated to the satisfaction of the appointed Inspector of Inspecting Agency. The major parameters including ram speeds and accuracies specified should be proved out during inspection of the machine.
- Geometric and performance tests as per clause 2.3.

2.6 Prove out at consignee's works:

- The machine performance shall be demonstrated by the supplier or his agent for proving out successful commissioning at the consignee's works for a period of two shifts of eight-hour each. The requirement operations of all the components listed in Annexure-F for Schedule-1A, shall be proved out at the consignee's premises as the part of commissioning process.

Note: Tools & Equipment required for installation of the machine and Set of Test Mandrels/Special Gauges for checking & alignment of machine should be brought by the bidder. The bidder can take back these items after installation & commissioning of the machine, which are in not in the scope of supply. The bidder shall also be responsible for any deviation/rejection in prove out of the components due to wrong tooling, die, punches or malfunctioning of the machine during prove out and also for the delay in bending due to improper recommended tooling etc. Any changes in tooling during prove out shall be at the responsibility and cost of the bidder. The bidder shall supply the changed toolings at prove out stage as per requirement. In case prove out of components is delayed beyond three months, the supplier to submit the detailed action plan completing prove out in a time bound manner in next one month. In case the prove out is further delayed on account of supplier, the supplier will be required to submit bank guarantee for the cost of the machine already paid to the firm, which shall be valid for 06 months. Indian Railway can encash bank guarantee in case prove out is not satisfactorily completed as per the milestone given by the supplier.

3. QUANTITY & CONSIGNEE

S. No.	CONSIGNEE/ Code	Qty	Schedule	Specification No.
1	CWM/ASRW	01	1A	ASRW/HP- 200T/2025-26


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4. SCOPE OF SUPPLY

- 4.1 The scope of supply shall include design, supply, installation, testing, commissioning and proving of machine on turnkey basis inclusive of foundation related civil work. It includes all the concomitant accessories/ equipments as detailed in the specification and other concomitant accessories/ equipment, which the manufacturer considers essential to make the machine fully operational, when installed and commissioned. It shall also include installation and commissioning of related equipment, training of personnel in operation and maintenance of machine and supply of technical documentation.

4.2 CONCOMITANT ACCESSORIES

- 4.2.1 The machine should be accompanied with the following concomitant accessories:
(Quantity of each item shall be indicated in the bid)

Schedule-1A		
i.	First fill of oils and lubricants- (Quantity of each item shall be indicated in the bid).	
ii.	Maintenance tools (List of tools indicating make, description & quantity shall be furnished in the bid)	1 set
iii.	Compatible Servo controlled voltage stabilizer (Ref. Cl.2.13.2 of Sec. V)	1 no.
iv.	Compatible ultra-isolation transformer (Ref. Cl.2.13.3 of Sec. V)	1 no.
v.	Electrical cables to connect electrical control cabinet, press terminal box and control desk	15 metre
vi.	Necessary tools and fixtures capable of carrying out the required operations for the components mentioned in Annexure-F	1 set
vii.	Any other accessory/ equipment, which the manufacturer considers essential to make the machine fully operational, when installed and commissioned connected to power source and give the specified output/productivity	

4.3 OPTIONAL ACCESSORIES

Any other accessory which can improve the productivity, performance, reliability, efficiency, or enhance the capability of the machine as a whole or part thereof, should be quoted as optional accessory. Cost of optional accessories shall be quoted separately and shall not be included in the basic price of the machine. Cost of optional accessories will not be taken for commercial evaluation of the firms.

5.1 EVALUATION CRITERIA

Total value of the offer will be calculated based on

- The cost of the basic machine.
- Cost of the concomitant accessories according to tender specifications.
- Cost of any other accessory which in the opinion of supplier is essentially required for making the machine fully functional.
- Cost of Turnkey Charges viz. foundation, installation & commissioning etc.
- Cost of comprehensive AMC for five years after the warranty as per clause 17.
- Cost of Preventive Maintenance during 1st & 2nd year of Warranty Period.
- Duties and taxes as quoted by the bidder, insurance and freight.

6.1 OTHER ITEMS TO BE QUOTED

The following items will need to be quoted additionally though will not be part of commercial evaluation:

- Optional Accessories with break-up of individual items as specified in clause 4.3 of section IV.
- Spares for two years' normal operation and maintenance as per clause 5 of Section V.
- Consumables as per clause 6 of Section V with breakup of individual items as applicable.

7.1 DELIVERY SCHEDULE CHART

In the event of acceptance of the offer, the machine(s) shall be supplied as per the following Milestone Chart:

Name of machine: **HYDRAULIC PRESS**

Specification No.: **ASRW/HP-200T/2025-26**

S.No.	Activity	Activity Code	Outer Limit of Time Schedule expected by ASRW
1.	Issue of LOA	D1	-
2.	Submission of PBG By Successful Bidder	D2	D1+30 days
3.	Issue of AT(LOA) / Contract By ASRW (after verification of PBG)	D3	D2+30 days
4.	Submission of GA drawings to consignee by Successful Bidder/Supplier along with information on power and other utilities required for machine	D4	D3 + 45 days
5.	Approval of GA drawings by consignee (to be governed by clause 11.2 of section-V)	D5	D4+ 45 days
6.	Confirmation of availability of clear site by consignee	D6	By D5 (i.e. at the time of approval of GA drg.
7.	Completion of foundation	D7	D6+150 days or latest by D 8
8.	Supply/ Delivery of machine	D8	<u>For First machine:</u> D5 + 180 days. <u>Subsequent machines: @</u> <u>one machine per month</u>
9.	Power connection for the machine and	D9	D8 + 7 days

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	other on site requirement to be provided by railways		
10	Railway to give call to supplier for the commissioning of machine	D10	D8+ 7 days
11	Installation, commissioning and proving out of machine by supplier	D11	D9 + 120 days or D10+ 120 days (whichever is later)
12	Issue of PTC by consignee	D12	D11 + 30 days
13	Warranty by supplier	D13	D11 + 2 years
14	AMC	D14	D13 + 5 years

Notwithstanding the delivery period indicated elsewhere in the tender document, the delivery indicated in this schedule shall be taken as overriding and final.

Section V

TECHNICAL SPECIFICATION**ABBREVIATIONS**

A-1,A-2, A-3, A-4	Standard paper sizes
AC	Alternating Current
AMC	Annual Maintenance Contract
ASRW	Amritsar Workshop
AT	Acceptance of Tender
BG	Bank Guarantee
CME	Chief Mechanical Engineer
CME/PCM	Chief Mechanical Engineer/Post Contract Management
CNC	Computer Numeric Control
COS	Controller of Stores
Db	Decibel
DC	Direct Current
FA&CAO	Financial Advisor & Chief Accounts Officer
GA (Drawing)	General Arrangement (Drawing)
HRC	Hardness Rockwell 'C' Scale (value)
Hz	Hertz
IEC-Pub	International Electro technical Commission – Publication
JCN	Joint Commissioning Note
JRI	Joint Receipt Inspection
KW	Kilo Watt
LC	Letter of Credit
LD	Liquidated Damages
LOA	Letter of Acceptance
NC	Numeric Control
NIT	Notice Inviting Tenders
PBG	Performance Bank Guarantee
PDF	Portable Document Format
PLC	Programmable Logic Controller
PTC	Proving Test Certificate
PU	Production Unit (Any of the six Railway Production Units e.g. RCF, ICF etc.)
RDSO	Research Design & Standards Organisation
SS	Solid state/ Stainless steel
WBG	Warranty Bank Guarantee

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Specification No.: ASRW/HP-200T/2025 Rev 0

1. BASIC DESIGN FEATURES:

1.1 Safety features:

- 1.1.1 The machine shall be suitably protected by necessary safety features against any accidental operation, overload, power fluctuations, power failure etc. Suitable interlocks, alarms and warning lights must be provided.
- 1.1.2 The press and its accessories must ensure safety of the operator and the system at all times. **Details of the safety features shall be furnished in the bid.**
- 1.1.3 Emergency stop push buttons shall be provided at convenient locations to switch off the machine in case of emergency.
- 1.1.4 Clearly visible indication lamp showing status of working of press to be provided near the machine, for all the workers to see, who are working near the machine.

1.2 Specific characteristics shall be as indicated below:

1.2.1 "C-Frame" down-stroking type hydraulic press

The leading parameters for "C-Frame" down-stroking type hydraulic press have been indicated in **Schedule-1A**

1.2.1.1 Press Frame:

The press frame shall be a weld fabricated structure using IS 2062 Grade 2 plates and by welding them as per standard welding procedures designed to withstand a force of 1.5 times the normal developed force. The plates should be as per BIS specifications & Material Test Certificate (MTC) of the plates issued by steel plant should be submitted to inspecting officials. All welds shall be checked for weld defects. The method of checking weld defects and the method of stress relieving shall be explained in the bid. The records of stress relieving should be furnished during the inspection of the machine. The detailed design calculations for the suitability of the critical sections or the FEM analysis should be furnished in the bid. The design of the press frame shall be such that there is minimum deflection in the press frame under full load **Value of deflection at full rated capacity shall be indicated in the bid along with calculations. A cross-sectional drawing shall be submitted clearly showing the various stiffeners provided for structural strength.**

1.2.1.2 Working Table

- i. The weld fabricated, stress relieved and accurately machined working table shall be of robust design to withstand full working load. Press shall accommodate tool bolster for which 4 nos. T-slots shall be provided. Extra ribbing shall be provided to avoid any deflection during operation.
- ii. The head face and all sliding surfaces should be ground smooth. All moving surface should be blue machined to 0.3 micron or better. The table and ram block should be also machined to 0.3 micron or better.
- iii. The ram end shall carry ram block ram block/moving platen/ slide forged out of highly wear resistant alloy steel and tenderers shall indicate the material to be used. The ram block/bottom plate of slide shall be provided with T-slot as per IS-2013 as approved in GA drawings by consignee. **The method of coupling the moving platen to the ram end shall be explained with the help of drawings in the offer.**

1.2.2.1 **Fixed Crown /Top Head**

- i. The fixed crown shall be a sturdy, rigid and robust fabricated structure, duly stress relieved. The **hydraulic power pack unit** shall be available on the floor level for easy accessibility for maintenance as indicated in CI 1.2.5.
- ii. The structure should be designed to take the full load at any time and no deformation/weld crack should appear in the full life of the machine from date of commissioning of machine.

Note However, if any consignee desires to have hydraulic power pack mounted on the fixed crown he may decide so and indicate his preference for same at the time of approval of General lay out diagram as per clause 11 of Sec V and successful bidder has to agree for the same.

1.2.2.2 **Moving Head**

- i. The moving head shall be a rigid, fabricated structure duly stress relieved, with arrangement for fitment of ram on top. T-slots shall be provided on the ram for fitment of die bolster.
- ii. Suitable liners shall be provided on the pillars for guiding the smooth movement of the head without stick-slip effects. **Material specification and surface finish of the liners shall be indicated in the bid.**

1.2.2.3 **Bottom Head**

- i. **The bottom head shall be a robust and rigid fabricated single structure duly stressed relieved capable of withstanding the full working load at maximum pressing force.**
- ii. The bottom head shall be provided with T- slots for fitment of bottom dies. Both faces of the moving (top) and bottom (fixed) heads shall be horizontal and parallel to each other. The faces and all sliding surfaces shall be ground smooth
- iii. The Accuracies of Press like perpendicularity, parallelism & Flatness should be as per relevant JIS/DIN/BIS standards. The accuracies should be demonstrated to inspecting officials during inspection of machine.

1.2.2.4 **Press Frame:**

- i. The major components of press frame like Bed, Top Head, Slide, Uprights shall be fabricated using IS 2062 Grade 2 plates and by welding them as per standard welding procedures designed to withstand a force of 1.5 times the normal developed force. The plates should be as per BIS specifications & Material Test Certificate (MTC) of the plates issued by steel plant should be submitted to inspecting officials. All welds shall be checked for weld defects. The method of checking weld defects and the method of stress relieving shall be explained in the bid. The records of stress relieving should be furnished during the inspection of the machine. **The detailed design calculations for the suitability of the critical sections or the FEM analysis should be furnished in the bid.** The design of the press frame shall be such that there is minimum deflection in the press frame under full load (not exceeding 0.17 mm/meter) **Value of deflection at full rated capacity shall be indicated in the bid along with calculations. A cross-sectional drawing shall be**


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submitted clearly showing the various stiffeners provided for structural strength.

- ii. In case of Link Frame constructions of Press, the top and bottom structures with columns of the frame shall be held together by Tie Rods as per design & complete structure shall be pre-stressed to 150% the press full capacity. Material specification of the tie-rods shall be indicated in the bid
- iii. The machining of fabricated components shall be carried out in a single set up preferably on CNC Horizontal boring machine to get proper accuracy.

1.2.2.5 Working Table

- i. The weld fabricated and stress relieved working table shall be of robust design to withstand full working load.
- ii. Press shall accommodate tool bolster for which T-slots shall be provided on the working table as per IS-2013. Extra ribbing shall be provided to avoid any deflection during operation. **A dimensioned cross sectional drawing of the tool bolster shall be submitted with the bid**
- iii. The T-slots shall be as per consignee's requirement and shall get approved in GA drawing before manufacturing of the press.

1.2.4 Ram-Cylinder Assembly

- 1.2.4.1 The press shall have one fixed main cylinder for Schedule-1A machine. The cylinder shall be machined from carbon steel forgings, accurately bored, ultrasonically tested and honed to 0.3 microns or better. The Design philosophy of Main Ram & parameter selected such as material, type of construction & wall thickness etc should be explained in the bid. **Relevant certificates of the cylinder shall be provided during inspection. Ultrasonic Testing of complete cylinder shall be done in presence of Inspection authority in case cylinder is supplied by Indian Manufacturer.**
- 1.2.4.2 The cylinder shall be of double acting with proper rear guiding arrangement for the ram. The piston cylinder assembly shall be effectively pressure sealed at both ends to prevent oil leakage and metal to metal contact between the piston and cylinder. The cylinder gland packing shall be designed for almost dry rod operation. **Arrangement provided for relieving the piston seals of any lateral loading shall be explained in the bid. The offer shall explain the sealing arrangement provided in the ram-cylinder-assembly with the help of a labeled sectional drawing.**
- 1.2.4.3 Hydraulic seals, 'O' rings and packing under compression shall have high compressive performance and shall be made from material such as nitrile rubber/neoprene/Teflon/PTFE. **The average life of the proposed material shall be indicated in the offer.**
- 1.2.4.4 The piston head shall carry non-metallic piston seals, slide rings and gland packing liners of suitable material such as Tufite-Turcon/ bronze impregnated PTFE, to avoid metal to metal contact between cylinder and piston assembly. Adequate number of sealing and rider rings shall be provided on the piston head and gland packings to ensure pressure sealing.
- 1.2.4.5 The ram cylinder shall be forged out of medium carbon steel, machined, ground and hard chrome plated and ground. The surface hardness shall be HRC-60 or better. Thickness of chrome plating shall not be less than 20 microns. These shall be ultrasonically tested for cracks. **Material specification, actual hardness, surface finish and thickness of chrome plating of the ram cylinder shall be indicated in the bid. Test report for as stated above shall be provided during inspection.**
- 1.2.4.6 The ram shall be able to generate an effective force of rated capacity. The

design calculations, taking into consideration frictional losses in the hydraulic circuit as well as in the ram-cylinder assemblies shall be explained in the offer. The bidder shall submit dimensioned assembly drawings showing cylinder bore and ram/ram head dimensions (with tolerances). Design calculation for motor horse power, speed, pump capacity and motor power shall also be explained in the offer.

- 1.2.4.7 The ram end shall carry ram block/moving platen forged out of highly wear resistant alloy steel, and tenderers shall indicate the material to be used. The ram block shall be provided with T-slots as per IS-2013 as approved in GA drawings by consignee. **The method of coupling the moving platen to the ram end shall be explained with the help of drawings in the offer.**

The ram end shall carry ram block/moving platen/Slide forged out of highly wear resistant alloy steel, and tenderers shall indicate the material to be used. The ram block/Bottom plate of slide shall be provided with T-slots as per IS-2013 as approved in GA drawings by consignee. **The method of coupling the moving platen to the ram end shall be explained with the help of drawings in the offer.**

- 1.2.4.8 The ram-cylinder assemblies shall be provided with suitable arrangement such as slide rods to prevent ram rotation during ram working. **The arrangement shall be explained in the offer.**

1.2.5 Hydraulic System

- 1.2.5.1 The hydraulic system shall be of modular construction (with logic control valves/ solenoid valves). The drive of the press shall be through hydraulic pumps. **Details of which shall be given in the offer.**

- 1.2.5.2 The hydraulic power pack unit shall be available on the floor level for easy accessibility for maintenance. It shall be mounted on suitable anti-vibration mountings. The tank of hydraulic system shall be as per the latest applicable standard. It shall be provided with an air breather(s), suitable baffle plates, filler breather, temperature indicator gauge, inspection cover(s), provisions for addition of lines in future, over flow and drainage connections.

The design of tank should be such that no oil should spill on the floor. Suitable mechanism for collection of Oil around the wall of Tank should be provided by means of Oil tray etc. Suitable Expansion joints should be used in high pressure lines to avoid transmission of vibrations to other systems.

The tenderer shall indicate the location of hydraulic power pack in the overall press layout drawings. The location shall be such as not to infringe the machine operation and material handling. Accuracy of pressure for main ram shall be within $\pm 1\%$ of full scale display.

Note However, if any consignee desires to have hydraulic power pack mounted on the fixed crown he may decide so and indicate his preference for same at the time of approval of General lay out diagram as per clause 11 of Section V and successful bidder has to agree for the same.

- 1.2.5.3 The hydraulic fluids used shall be non-corrosive, stable and safe. It shall be available indigenously in India. **Particulars of the hydraulic fluid used shall be indicated in the offer. The successful bidder shall be required to indicate reputed Indian source of supply for the hydraulic fluid. The first fill of the hydraulic fluid shall form a part of the supply as concomitant accessory.**
- 1.2.5.4 The hydraulic system shall be sealed for protection against contamination.
- 1.2.5.5 Adequate number of filters (for full capacity of pressurized oil) shall be placed

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in between the circuit and the pump, having filtering capacity of 25 microns or better. The filters shall be replaceable type. The type, make and model no. of each filter element shall be clearly indicated in the offer. A return line filter of 25 microns or better shall be provided. **The type, make and model no. of each filter element shall be indicated in the bid.**

There should be interlocked alarm in PLC when the filters are clogged and machine should not work to avoid damage to other critical hydraulic parts such as pumps/valves etc.

- 1.2.5.6 The filtering system shall be provided with a by-pass valve which shall operate in case of clogged filters. The filters shall have a clogging indicator. **Details of the clogging indicator shall be furnished in the bid.**
- 1.2.5.7 A temperature sensor shall be provided to indicate hydraulic oil temperature on the control panel. The temperature of oil in hydraulic circuit shall not exceed 60°C in any case. The press shall stop functioning if oil temperature exceeds nearly 60°C and interlocking of same should be provided in press controls. A suitable cooling system complete with air-cooled heat exchanger and all accessories shall be provided to ensure that oil is not overheated under local weather conditions at continuous normal working of the machine. **Arrangement shall be explained in the bid. Heat load calculations and the details of heat exchanger system should be furnished.**
- 1.2.5.8 Oil level sight gauge, or any other equipment showing maximum and minimum oil levels, shall be provided on the oil tank.
- 1.2.5.9 A suitable system shall be incorporated in the press to indicate low oil level in hydraulic oil tank and the press shall stop in case of low oil level with audio and visual warning. **The Hydraulic Pipe joints should be TIG welded with all joints RT tested to ensure no failure of same during operation at site over the life of machine.**
- 1.2.5.10 A drain plug at the lowest portion of the tank shall be provided so that oil can be drained out without disconnecting any pipe or pipe connection.
- 1.2.5.11 Cold drawn seamless steel pipes capable of withstanding high hydraulic pressure (**150% of the maximum hydraulic pressure**) conforming to DIN 2391/C shall be used in the hydraulic circuit. Pipe fittings shall be Ermeto type, vibration proof. The steel tubes shall be suitably coated for corrosion prevention. **The arrangement provided shall be explained in the offer.**
- The Hydraulic Pipe joints should be TIG welded with all joints RT tested to ensure no failure of same during operation at site over the life of machine.
- 1.2.5.12 The successful tenderer shall provide the first filling of hydraulic oil, the cost of which shall form part of the basic price of the press. **Tenderers shall indicate the exact grade of oil used and equivalent oils available in India that are suitable for use.**
- 1.2.5.13 The tenderer shall submit with the offer a diagram of the hydraulic circuit incorporated in the press giving full details such as size of lines, cut-off pressure, type, model number and make of:
- i. hydraulic elements
 - ii. hydraulic motor
 - iii. pumps, etc

The logic diagram for sequence of operations must be supplied. Each element in the diagram shall be suitably numbered. The elements on the press shall be correspondingly labeled prominently for the convenience of the operating and maintenance staff. The machine hydraulics should be as per IS/DIN standard. **The relevant standard used as reference shall be**

indicated in the bid". All hydraulic pipeline actual routing diagrams to be furnished along with hydraulic circuit.

- 1.2.5.14 The working pressure of the hydraulic shall not exceed 250 kg./sq.cm. The system, along with all the hydraulic elements, shall be designed to withstand a pressure of 1.5 times the working pressure.
- 1.2.5.15 It shall be possible to limit the pressure through relief valves.
- 1.2.5.16 The hydraulic system shall be provided with double safety pressure relief valves. The first setting shall be at the maximum working pressure, while the second setting shall be at a pressure 4 to 5% higher than the maximum working pressure. In the eventuality of failure of the first system, the second system shall take over immediately, disconnect the pump output to the cylinder and allow discharge to the hydraulic tank. **The system so designed shall be explained in the offer with a line diagram of the hydraulic circuit. The names of individual hydraulic element shall be indicated in the bid.**
- 1.2.5.17 The hydraulic circuit shall be designed for minimum wastage of energy and shall not generate avoidable heat. **The offer shall clearly explain how this efficiency would be achieved.**
- 1.2.5.18 The valves in the circuit shall be matched for adequate capacity to ensure a smooth flow.
- 1.2.5.19 To avoid damage, there shall not be any pressure build-up at any time in the drain line or in the drain ports of hydraulic elements.
- 1.2.5.20 Restrictions in the pressure line shall be avoided.
- 1.2.5.21 The ram speeds shall be adjustable and the control shall have a graduated scale to indicate ram speed in mm/min. **The ram displacement will be through LVDT (Linear variable differential transducer) and displayed in PLC - MMI. Arrangement provided shall be explained in the bid.**
- 1.2.5.22 Decompression arrangement shall be provided to release pressure on top position and prevent downward creep. **The device shall be explained in the offer.**
- 1.2.5.23 A safety device shall be provided to retain the moving head in the top position and prevent downward creep. **The device shall be explained in the bid.**
- 1.2.5.24 Turbulence in the tank shall be minimized by providing suitable baffle plates. The offer shall explain how this will be done.
- 1.2.5.25 Suitable breathers and strainers of adequate capacity shall be provided in the tank to avoid cavitation.
- 1.2.5.26 A safety catcher arrangement shall be provided to retain or hold moving head in any position like press operation to be carried out at lower position, extreme top position, changing of tool, power failure etc. it should also prevent downward creep. The safety catcher arrangement actuation to be programmed and interlocked with operation of press. **The arrangement provided to be explained in bid with sketch.**
- 1.2.5.27 Oil leakage collecting tank shall be provided and suitably located for accumulation of leaked oil with pump to transport the leaked oil to a container for disposal.
- 1.2.6 **Controls and Operation**
- 1.2.6.1 Operation of the press shall be through PLC-MMI controls provided with suitable safety features of interlocking against faulty sequence of operation. Necessary input devices like electric push buttons and selector switches shall be provided on an ergonomically designed control desk which shall allow a full view of the working area. The selector switches shall select the mode of

- operation. Besides PLC-MMI display and relevant control buttons, light indicators for safety features like high oil temperature, low oil level, clogged filter, heat exchanger not working etc shall be displayed in the control panel. The panel should also have provision for display of Current and voltage readings, Pressure and Force readings and push buttons for emergency stop, main motor ON/OFF etc. **The drawing of control panel indicating location of various controls provided therein shall be furnished in the bid.**
- 1.2.6.2 Hydraulic control system shall provide for rapid forward and return motion under no load conditions. It shall be possible to hold the ram under pressure without keeping the control button pressed continuously.
- 1.2.6.3 It shall be possible to preset the ram force from a minimum of 10% of rated capacity upto a maximum. For this purpose, a hand wheel controlled pressure regulator valve shall be provided with tonnage marking on the indicator plate. **The precise range and steps of control shall be indicated by the bidder.**
- 1.2.6.4 Pressure gauge calibrated to indicate working pressure as well as total ram force being applied when the press is working, shall be provided for the ram at a suitable location so that it is easily visible to the operator. **Least count for force and pressure on the gauge shall also be indicated in the offer.** The gauge shall have a range of minimum 25% beyond the rated capacity.
- 1.2.6.5 Pilot lamps to indicate the status of various press functions shall be provided at a suitable and easily visible location on the press. The functions for which pilot lamps are required shall include, but need not be limited to, the following:
- i. Power 'ON'
 - ii. Pump 'ON'
 - iii. Pressure 'ON'
 - iv. Oil level low in hydraulic tank
 - v. Oil temperature high
 - vi. Oil filters clogged
- 1.2.6.6 A large mushroom type emergency switch shall be provided on the press which shall enable the operator to instantly stop the ram motion. Emergency stop shall override the control push buttons.
- 1.2.6.7 In case of power failure, the ram shall stop immediately and shall move neither downward nor upward automatically when the power supply comes 'ON' again. Subsequently, the press shall operate only after the ram is retracted to its starting position in manual mode.
- 1.2.7 **Lubrication**
- 1.2.7.1 The press shall be provided with an automatic adjustable centralised pressure oil lubrication system to supply a measured quantity of lubricant to each lubrication point. The lubricating oil pump shall be independently driven and interlocked with the main drive so as to ensure pre-lubrication of the press. **The lubrication system shall be explained in the bid with a lubrication circuit diagram. The make of the components in the circuit shall also be indicated in the bid.**

2. GENERAL ELECTRIC SPECIFICATION

- 2.1 The provision of this General Specification shall apply, where ever relevant.
- 2.2 All equipments and material shall comply with appropriate Indian Standards (latest), International Standards or National Standards of the country of origin provided the latter are equivalent to or better than the former. The tenderer shall indicate the Standards applicable. The following standards are applicable in particular.
(Corresponding International Standards like ASA, NEMA, BSS, DIN etc. may also be quoted).
- | | | |
|------|--------------------|--|
| IS : | 325-1979 (latest) | - Three phase induction motors (corresponding to IEC pub-34-1) (Latest). |
| IS : | 1248 (Latest) | - Direct acting indicating analogue electrical measuring instruments and their accessories (corresponding to IEC Pub-51) (Latest). |
| IS : | 1231-1974 (Latest) | - Dimensions of three phase induction motors (corresponding to IEC Pub-72-1) (Latest). |
| IS : | 1271-1985 (Latest) | - Classification of insulation material for electrical machinery & apparatus in relation to their thermal stability in service (corresponding to IEC-Pub-85) (Latest). |
| IS : | 6875 (Latest) | - Push Buttons and related control switches corresponding to IEC Pub/73) (Latest). |
| IS : | 375-1963 (Latest) | - Marking and arrangement of switch gear, bus bars, main connection & auxiliary wiring. |
| IS : | 996-1979 (Latest) | - Single phase small AC and universal electrical motors. |
| IS : | 1356 (Latest) | - Electrical equipment of machine tools. |
| IS : | 2516 (Latest) | - Circuit breakers (corresponding to IEC Pub-56) (Latest) |
- 2.3 Unless specified in the main specification, the AC motors and starters shall be of the following type. Tenderer is, however, free to give alternative proposal along with justification, if in his view alternative proposal in warranted by site conditions. Type of motor type of starter.


TYPE OF MOTOR

TYPE OF STARTER

- 2.3.1 Any type of AC motor starting current of which does not exceed 75 amps.

Direct on line.


W. A. R. W.


(SSE/Elec.)


(SSE/BSS)

- 2.3.2 AC squirrel cage, introduction motors, starting current of which is above 75 amps. if started direct on line. Star delta or Auto transformer type.
- 2.3.3 AC slipring type motor Resistance type air/fan Cooled
- 2.3.4 AC synchronous or synchronous induction motor. Suitable makers standard.
- 2.3.5 DC motor Resistance type/Thyristor type.
- 2.4 The control gear for AC/DC motors shall incorporate the following protection devices as concomitant accessories.
- 2.4.1 **No Voltage Protection** - No voltage protection shall be provided so that machine will not start up again by itself when, following an interruption the supply is restored.
- 2.4.2 **Short Circuit Protection** - To protect against short circuits due to insulation failure of faulty connections HRC fuses shall be provided for each motor. The rating of the fuse shall be such as to take care of the over current due to motor starting.
- 2.4.3 **Over Load Protection** - To prevent motors from overloading, overload protection shall be provided separately for each motor. Three phase motors shall be protected by overload tripping devices on each phase.
- 2.4.4 **Single Phasing Protection** - A separate current sensitive delayed action single phasing preventor shall be provided for each motor separately. Overload protection shall not be treated as single phasing preventor.
- 2.5 Control equipment shall be mounted in separate drip proof enclosures. Control enclosures and compartments are to be so designed as to give adequate protection against ingress of dust, oil, coolant or chips. All control devices like contractors etc. shall be front mounted on a rigidly fabricated metal panel for ease of operation. All other electrics shall be installed that they are readily accessible when the doors and covers are opened. Hinged covers shall be interlocked with the machine tool control to prevent operation of the machine when cover is open.
- 2.6 The motor shall be totally enclosed with or without fan cooled frame. Screen protected drip proof type motor may be provided if it is mounted inside protective enclosures.
- 2.7 The electrical equipments shall comply with the requirement of Indian Electricity Act and Rules (latest).
- 2.8 All instruments shall be of the Industrial Grade "A" (IS-1248) switch board type the range of the instrument shall be such that the maximum load expected in the circuit shall produce a deflection of 60% to 80% of the full scale.
- 2.9 The supplier shall furnish 3 sets of complete electrical and electronic wiring diagrams in full details to enable the maintenance staff to locate faults in the circuits, 3 sets of part catalogues, maintenance manuals operating instructions with details of coils and windings, used in the equipment to facilitate repairs and maintenance should also be supplied.

2.10 For main motor class minimum "B" Class insulation shall be provided. If any other class of insulation is proposed, detailed justification for providing different class of insulation shall be given.

2.11 Motors shall be designed to withstand frequent starts, stops and reversals as demanded in the operation of the machine.

2.12 Two earthing terminals shall be provided on all electric motors including the control gear.

2.13 POWER SUPPLY

2.13.1 The machine shall be suitable for operation on 415 volts 3 phase 50 cycles AC 3 wire or 4 wire system with neutral solidly earthed. The supply voltage may vary up to +10% -20%. The frequency may vary up to $\pm 3\%$. However, full rated power of the motor shall be available at the lower voltage. Firm should confirm satisfactory performance of the machine at incoming power supply in the range 415V+10%-20% and 50HZ $\pm 3\%$ frequency or should provide voltage stabilizer as specified against clause 2.13.2 below of required capacity.

2.13.2 The voltage stabilizer, if required, shall conform to :

i)	Input Voltage	-	320 to 460 volts 3 phase 4 wire supply.
ii)	Output Voltage	-	415 volts
iii)	Regulation	-	$\pm 1\%$ from No load to Full load.
iv)	Rate of correction	-	20 volts per second per phase.
v)	Wave from distortion	-	NIL
vi)	Efficiency	-	Not less than 97%.
vii)	Winding and class of insulation	-	Copper wire wound with "B" class of insulation or better.

2.13.3 In case of machines equipped with NC, SS, CNC, Thyristor controlled devices and other sophisticated electronic gadgets including microprocessors etc. which are susceptible to power line spikes and surges, a suitable voltage stabilizer and ultra isolation transformer to cover for the entire electrical load of the machine shall be offered as a concomitant accessory, conforming to Specification for voltage stabilizer as mentioned in clause 2.13.2 above and isolation transformer to the parameters mentioned below.

i)	Transformer ratio	-	1:1
ii)	Winding	-	Copper wire wound with "F" class insulation or better.
iii)	Protection	-	To arrest spikes and surges to the order of 3 KV for 200-400 micro seconds duration.
iv)	Common mode rejection ratio	-	120 dB
v)	Isolation	-	Capacitance 0.005 Pf; resistance greater than 1000 Mega Ohms.

2.13.4 Voltage stabilizer shall be equipped with a protective relay to trip the AC power supply to the machine instantaneously with audio and visual indication to the operator. Settings of the protective relay for low and high voltage shall be 320 volts and 460 volts respectively.


WM/ASRW


(SSE/Elm)


(SSE/BSS)

2.14 ATMOSPHERIC CONDITIONS

- 2.14.1 The ambient temperature at the site at which the machine will be installed may vary from -4°C to $+50^{\circ}\text{C}$ over the year. The relative humidity may be as high as 98%. The atmosphere is expected to be dusty. The machines offered shall be suitably tropicalised to work under these atmospheric conditions without any adverse effect on their performance.
- 2.15 The temperature rise shall not reach such a value that there is a risk of injury to any insulating material or adjacent parts.
- 2.16 The drive shall be capable of operating at any one of the speed required independent of the load in accordance with the requirements of the machine.
- 2.17 Information/data shall be furnished as per the format of submission of technical bid Annexure-A.

3. GENERAL CHARACTERISTIC

3.1 RIGIDITY AND STABILITY

- 3.1.1 The machine shall be robust, rigid and of sturdy construction. It shall be designed to meet heavy duty demands of various operations on the machine under normal Workshop environment for such machines. It shall be free for vibrations even when working at full capacity.
- 3.1.2 All machine castings shall be made of close grained high grade cast iron like Mehanite or equivalent materials meeting IS-210 Standards to ensure durability and rigidity. The casting shall be thermal stress relieved to ensure stability and continued accuracy.
- 3.1.3 All machine fabrications of critical load bearing assemblies like beds, columns etc. shall be adequately strengthened and stress relieved.
- 3.1.4 Change in ambient temperature shall not affect the performance of the machine.
- 3.1.5 There shall be no change in the performance of the machine either on switching on the machine or after continuous running.
- 3.1.6 There shall be no resonant vibrations throughout the working range of the machine at all load levels.

3.2 SAFETY CONTROLS

- 3.2.1 The machine shall incorporate safety devices to provide protection to the operator and machine against all possible operational and machinery failures.
- 3.2.2 Suitable interlock shall be provided to prevent machine operations in the event of:
- 3.2.2.1 Faulty sequence of operation.
- 3.2.2.2 Fluctuation in supply voltage.
- 3.2.2.3 Resumption of power supply after power failure.
- 3.2.2.4 Non-positioning of safety guards.
- 3.2.2.5 Failure of hydraulic system (where applicable)
- 3.2.2.6 Failure of lubricating system (In case of automatic including drop in pressure lubrication)

- 3.2.3 A fault or damage in the control circuit or interruption re-establishment after an interruption of fluctuation in whatever manner in the power supply to the machinery must not lead to dangerous situations in particular.
 - 3.2.3.1 The machinery must not start unexpectedly.
 - 3.2.3.2 The machinery must not be prevented from stopping if command has already been given.
 - 3.2.3.3 No moving part of the machinery or piece held by the machinery shall fall or be ejected.
 - 3.2.3.4 The protection devices must remain effective.
- 3.2.4 The machine shall be fitted with an emergency stop device to enable actual or impending danger to be averted. This device must be:-
 - 3.2.4.1 Conveniently located.
 - 3.2.4.2 Clearly identifiable.
 - 3.2.4.3 Stop the machine as quickly as possible without causing additional hazards.
 - 3.2.4.4 The emergency stop must remain engaged. It should be possible to disengage it only by appropriate operation. Disengaging the control must not restart the machinery but only permit restarting.
- 3.2.5 Safety features shall also include.
 - 3.2.5.1 Safety device against overload for all mechanical and electric items to the extent possible.
 - 3.2.5.2 Safety stops against over-running of slides.
- 3.2.6 Guard and protection devices shall protect exposed persons against risks related to moving transmission parts (such as pulleys, belts, gears, rack and pinion, shafts etc.) and moving parts directly involved in the process to the extent possible. This shall meet the following requirements:-
 - 3.2.6.1 Be of robust construction
 - 3.2.6.2 Not give rise to any additional risk
 - 3.2.6.3 Not be easy to by pass or render non-operational
 - 3.2.6.4 Be located at an adequate distance from danger zone
 - 3.2.6.5 Cause minimum obstruction to the view of the production process.
 - 3.2.6.6 Rigidly connected and not prone to rattling
 - 3.2.6.7 Enable essential work to be carried out without the guard or protection device having to be dismantled
- 3.2.7 A load meter shall be provided to indicate the load on the machine. The meter shall have a suitable mark to indicate the maximum load the machine can take. Full details of the above and other safety features indicating how each one functions must be explained in the offer.

3.3 OPERATIONAL CONTROLS

- 3.3.1 The operation of the machine shall be by push buttons or levers. The basic rules for the direction of operation of controls and the corresponding direction of movements of the machine tools shall be as per IS:2987-1985.
- 3.3.2 The control devices shall be
 - 3.3.2.1 Clearly visible and identifiable.
 - 3.3.2.2 Ergonomically positioned for safe operation without hesitating or loss of time, and without ambiguity.


WM/ASRW


(SSE/BS)


(SSE/FLC)


(SSE/BS)

- 3.3.3 CNC Controls (where applicable) - The general requirements of CNC controls are given at Schedule-IV.

3.4 LIGHTING

- 3.4.1 Integral lighting suitable for the operations concerned where its lack is likely to cause a risk despite ambient lighting of normal intensity shall be provided.
- 3.4.2 The manufacturer must ensure that there is no area of shadow likely to cause nuisance, that there is no irritating dazzle and that there are no dangerous stroboscopic effects due to lighting provided by the manufacturer.
- 3.4.3 Integral parts requiring frequent inspection and adjustment and maintenance areas must be provided with appropriate lighting.
- 3.4.4 The machine lighting should be of low voltage so as to prevent any hazard to the operator.

3.5 MACHINE MAINTAINABILITY

- 3.5.1 The machine shall be so designed as to require minimum possible maintenance and to give trouble free service.
- 3.5.2 All assemblies/parts of the machine shall be easily accessible for maintenance.
- 3.5.3 The machine shall not require major dis-assembly for checking and replacement of a particular part, especially for parts requiring periodical check up and replacement.
- 3.5.4 The manufacturer must provide means of access e.g. stairs, ladders, cat walks etc. to allow access safely to all areas used for production, adjustments and maintenance operations.

3.6 WEAR COMPENSATION ADJUSTMENT

- 3.6.1 The original built in accuracy of the machine shall be capable of being maintained conveniently and economically by suitable adjustments for taking up wear on slides, bearings and load screws. The system of adjustments incorporated shall be explained in the offer.

3.7 COOLANT SYSTEM (WHERE APPLICABLE)

- 3.7.1 Suitable coolant system with pump, motor, tank, filter etc. shall be provided. The coolant pump shall be as per IS:2161-1962. The filter shall be of reusable type and indigenously available. If reusable filter cannot be offered the filter cartridge shall be readily available in India. Source of supply shall be indicated. Adequate no. of filters for 2 years working on double shift basis shall be offered as spare. Details of the coolant system shall be indicated in the offer.
- 3.7.2 The supply of coolant shall be in ample volume. Provision to re-circulate the coolant shall be available. A chip and coolant tray shall be provided. The volume of coolant flow shall be indicated. It shall be adjustable.
- 3.7.3 An enclosure shall be provided to prevent the coolant from splashing outside the machining zone. Details of enclosure shall be provided. Specific requirements of coolant system for grinding machines etc. shall be clearly indicated.

3.8 LUBRICATION SYSTEM (WHERE APPLICABLE)

- 3.8.1 The machine shall be provided with an automatic lubricating system for ensuring delivery of adequate quantity of lubricant to areas requiring continuous lubrication. Suitable arrangements must be provided for indication of failure of the lubricating system.
- 3.8.2 The system shall be provided with interlock to prevent machine operating/starting in the event of the failure lubrication system.

3.8.3 Reusable filters capable of filtering chips, dust particles etc. shall be provided. Indicators for showing clogged condition of filters shall be available. The filters shall be indigenously available. If reusable filter cannot be offered the filter cartridge shall be readily available in India. Source of supply shall be indicated. Adequate no. of filters for 2 years working on double shift basis shall be offered as spare.

3.8.4 Lubrication and filter cleaning chart shall be displayed on a metal plate at a conspicuous location on the machine indicating :-

- Specific location of points on the machine to be oiled lubricated/greased.
- Periodicity of lubrication of these points.
- Filter to be cleaned.
- Periodicity of cleaning filters.
- Periodicity of replenishing lubricating oil for the centralized system.
- Any other similar relevant information.

3.8.5 Points where manual lubrication is needed shall be separately indicated. Frequency of lubrication shall be also clearly mentioned.

3.8.6 Lubricating oils used in the machine shall be available in India. Successful tenderer will be required to indicate brand names of approved oils manufactured by various Indian Oil Companies.

3.8.7 First fill of lubricating oils used in the machine shall be provided with the machine.

Details of lubricating system provided shall be indicated.

3.9 PNEUMATIC SYSTEM (WHERE APPLICABLE)

3.9.1 The compressed air supply will be provided by the customer at the machine within pressure range of 4.5-7.5 kg/cm² and a moisture content or 1000 ppm. The pneumatic system of the machine should be designed accordingly. An alarm shall be provided for low air pressure.

3.9.2 Suitable filter/moisture trap shall be provided by the contractor in the system of pneumatic air intake. The filter shall be reusable type and indigenously available. If reusable filter cannot be offered, the filter cartridge shall be easily available in India. Source of supply shall be indicated. Adequate no. of filters for 2 years working on double shift basis shall be offered as spare.

3.9.3 Air pressure regulator, if necessary, shall be provided by the tenderer.

3.9.4 The make of pneumatic control equipment shall be of reputed make. The makes shall be indicated.

3.10 HYDRAULIC SYSTEM (WHERE APPLICABLE)

3.10.1 Hydraulic circuit must be equipped with the following safety and inspection equipments:

- Pressure gauges at all places, where pressure has to be set up or inspected.
- Safety valves for hydraulic circuit if relief valve does not fulfill this function.
- Equipment for checking of temperature in the circuit or in the pump wherever necessary.
- Arrangement to show if the filters (including those in the pump set) are choked and need cleaning. The filters shall be of reusable type and indigenously available. If reusable filter cannot be offered, the filter cartridge shall be readily available in India. Source of supply shall be indicated. Adequate no. of filters for

2 years working on double shift basis shall be offered as spare.

(e) Alarm for low oil level.

3.10.2 The sump aggregate shall have the following:

(a) Oil level sight gauges or any other equipment showing the minimum and maximum oil levels in sump.

(b) A drain plug at the lowest portion of the tank.

(c) It shall be possible to drain the oil from the tank without disconnecting any pipes or other fittings.

3.10.3 The temperature of oil in hydraulic circuits shall not exceed 60 degrees C in any case. Suitable arrangement shall be incorporated to ensure that the oil is not overheated under local weather conditions at continuous normal working of the machine.

3.10.4 Facilities for bleeding of air in case of air lock shall be provided.

3.10.5 The hydraulic reservoir, pump and allied equipment shall be suitably segregated from the machine in order to remove major source of heat.

3.10.6 Hydraulic oils used on the machine shall be available in India. Successful tenderer will be required to indicate brand names of approved oils supplied by various Indian Oil Companies.

3.10.7 First fill of hydraulic oils used on the machine shall be provided with the machine.

4.0 TECHNICAL LITERATURE:

4.1 One copy of the printed illustrative catalogue showing features of the machine and its elements must be enclosed with the bid.

4.2 The technical literature shall be provided for the complete machine, including imported and indigenously purchased components / sub-assemblies. The successful tenderer will have to furnish 4 (four) copies each of the following manuals directly to the consignee along with the machine. Out of these 04 sets, the bidder shall be required to submit one set of all documents in best available condition one month prior to the training for the machine. One set of technical literature should cover the following details:

- (i). Operational & Maintenance manual of the machine.
- (ii). Operational & Maintenance manual of the servo controlled voltage stabilizer.
- (iii). Operational & Maintenance manual of the ultra-isolation transformer.
- (iv). Instruction & Maintenance manual for Hydraulic Oil Cooling Unit.
- (v). User manual for Tool changer system (if provided).
- (vi). Technical & Maintenance manual for Hydraulic System
- (vii). Technical & Maintenance manual for Lubrication System.
- (viii). Operator Guide for CNC Control System (if provided).
- (ix). Programming Guide for CNC Control System (if provided).
- (x). Diagnostic & Trouble shooting Guide for CNC Control System (if provided).
- (xi). Start-up Guide for CNC Control System (if provided).
- (xii). Machine Software Listing (if provided).
- (xiii). Soft and hard copies of PLC Program in ladder form with cross reference listing and PLC project file.

- (xiv). Drawings of tooling & fixtures, hard copies in A-2 size as well as soft copy in PDF format.
- (xv). Wiring diagram, in which length of wires must be mentioned, hard copies in A-3 size as well as soft copy in PDF format.
- (xvi). Mechanical drawings (spindle assembly, table assembly, column assembly), hard copies in A-1 size as well as soft copy in PDF format.
- (xvii). Spare part manual including part lists no., hard copies in A-4 size as well as in PDF format.
- (xviii). Lay out drawings in A-1 size, which clearly shows the position of all type of electrical components in machine.

Note: All manual and literature should be in English/Hindi.

5.1 Spares

- 5.1.1 Since the machine will be under comprehensive preventive maintenance during warranty period of two (02) years and under AMC for five (05) years after the warranty period, it is the sole responsibility of bidders to stock such spares as required for smoother execution of PMC during warranty and AMC in order to achieve response time in compliance to machine availability as per stipulated requirements.

6.0 CONSUMABLES (If applicable)

- 6.1 The list of consumable spares shall be furnished and quoted along with their unit rate.
- 6.2 Consumables shall be supplied along with the machine or as per agreed time table, if ordered.

7.0 SPECIAL FEATURES:

- 7.1 Special features incorporated in the machine, if any, shall be indicated separately in the bid clearly indicating the advantages.

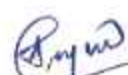
8.0 DEVIATIONS:

- 8.1 The tenderer shall certify that the offered machine fully meets the specification. Various design features incorporated in the machine to fulfill different technical performance requirements shall be fully explained in the offer. However, minor deviations from these specifications which do not affect or in any way interfere with the stipulated performance standards or would result in improved safety/reliability or would reduce recurring maintenance/operating cost of the machine, can be considered for acceptance. The tenderer in such eventuality shall clearly indicate the details of these deviations and their implications as per the following format:
- 8.2 All Deviations shall be clearly indicated in the deviation statement as per the format of submission of technical bid Annexure-A.

9.0 INSPECTION AND TESTING AT MANUFACTURER'S WORKS:

- 9.1 The machine shall be inspected and tested during different stages of its manufacture starting from raw material till the completion of machine, by the purchaser or his authorized representative at the supplier's or his sub-supplier's works. The Quality Assurance Programme as per Annexure-I shall be submitted along with the bid. The bidder must submit the exhaustive QAP incorporating


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(SSE(Elec))


(SSE(BSS))

- the tests as given in Annexure-I along with other tests /stage inspection as followed by them.
- 9.2 A load and functional test like no load test and maximum Horse Power test must be carried out at the manufacturer's works. Rigidity of the machine shall be demonstrated to the satisfaction of appointed inspector or inspecting agency.
 - 9.3 Manufacturers must have suitable facilities at their works for carrying out various performance tests on the sub-assembly/assembly/machine. The tenderer shall clearly confirm that all facilities exist and shall be made available to the inspecting authority.
 - 9.4 A Sample Inspection Chart for inspecting the equipment shall be supplied along with the bid. The inspection chart should indicate all the tests that are carried out during the machine manufacture and also the tests to be offered to inspecting agency. The standard to which this inspection chart conforms should be clearly indicated. Against each test, acceptable limit/ range of values shall be indicated.
 - 9.5 The complete machine shall be inspected at manufacturer's premises as per approved GA drawing. Inspecting authority shall not carry out the final inspection in case GA Drawing is not approved by the consignee.
 10. **TRAINING:**
 - 10.1 Free training by the firm shall be imparted in operation and maintenance of the machine. The training to be imparted shall cover operation, troubleshooting and repair of all mechanical, hydraulic, electrical & electronics equipments (CNC Control & AC Drives) and CNC/PLC part programming. This training shall be provided to 4 per consignee nominated by the consignee, for a period of 1 week free of cost at the manufacturer's premises. One weeks training will also be provided to one person free of cost from ASRW in design and construction of the machine. All charges pertaining to travel, boarding and lodging shall be borne by Indian Railways. } firm.
 - 10.2 Subsequently, technical experts from the manufacturer will fully and adequately provide training to operators and maintenance staff nominated by the consignee at the time of commissioning of the machine.
 - 10.3 The supplier will be responsible for co-coordinating with the consignee the travel plans of trainees to ensure that the training is imparted on the machine at its assembly and testing stage. The bidder shall also submit training schedule along with the offer.

Note: All training should be imparted in English/Hindi only.

11. FOUNDATION & RELATED DRAWINGS

- 11.1 **SUBMISSION OF GA, FOUNDATION & RELATED DRAWINGS FOR APPROVAL:**
 - 11.1.1 For each machine, the supplier shall first submit 01 copy of foundation drawings with details of construction of foundations, complete layout of machine elements like bed, hydraulic tank, coolant tank, electrical panel, Servo Controlled Voltage Stabilizer etc. and other related diagrams (Mechanical, Hydraulic, Electrical & Electronics) along with machine weight, overall dimensions, electrical load with length of 3 phase, 415 V AC electric power cable for approval as per time schedule specified in Section-IV to each consignee for approval and to enable the consignee for making necessary arrangements for Installation & Commissioning of Machine on receipt. After getting approval from consignee, the supplier shall supply directly to each consignee 6 copies of approved GA

foundation drawings and related diagrams for each machine as per time schedule specified in Section-IV from the date of approval of GA drawing for information only. This information should be furnished on the pattern indicated in detail in the following IS Specifications (Latest) or relevant international standards


- i) IS: 2974 (Pt.I Para 4.1) for reciprocating type machine.
- ii) IS: 2974 (Pt.III Para 3.1) for rotary type machine (medium & high frequency).
- iii) IS: 2974 (Pt.IV para 4.1) for rotary type machines of low frequency.
- iv) IS: 2974 (Pt.V para 3.1) for impact type machines other than hammers

11.2 APPROVAL OF GA DRAWING

To be governed by Time Schedule in clause 7 of section-IV and following stipulations.

- 11.2.1 General Arrangement Drawings will be sent by the 'Contractor' to the Consignee as per Time Schedule annexed in LOA/AT. Consignee will download the copy of AT from ASRW website and take necessary action for approval of GA drawings. The 'Contractor' should ensure that drawings sent to consignee are complete in all respects as specified in technical specification. The GA drawings shall be approved by the consignee and given back to the contractor, under advice to ASRW, as per the Time Schedule in the LOA/AT.
- 11.2.2 **Delays in submission of drawings by Contractor will be added to the delay in supply of machine** in case submission of GA drawing is delayed beyond stipulated time as per time schedule and LD will be levied **as per bid document Part-I**. Thus the number of days delay in submission of GA drawing plus the number of days delay in supply of machine together will be taken as the delay in supply of machine, for the purpose of calculations of LD as per clause 1002 of section II of bid document part-I. However, if the contractor supplies the machine before original delivery period as per AT the number of days by which machine has been supplied earlier than original delivery period that many days will be subtracted from the delay in submission of GA drawings and LD will be levied accordingly. Delays in approval of the drawings by consignee will not be on account of Contractor, except as detailed below.
- 11.2.3 In case Consignee finds some deficiencies in the Drawings and returns the same for rectification to the 'Contractor', the contractor must return the rectified drawings within 30 days from the date of issue of letter by Consignee. This period will not be counted towards LD calculation. The consignee shall ensure that all deficiencies in the Drawings shall be pointed for clarifications to the firm together at one time only instead of piecemeal multiple reference.
- 11.2.4 A repeat back reference(s) by Consignee to Contractor pointing out further defects/deficiencies in the Drawings, will be considered a delay on account of the contractor, except for special circumstances like change in location, review of arrangement etc. Thus, Contractors must take utmost care in ensuring completeness as per requirements of the Consignee.
- 11.2.5 Where GA Drawing cannot be approved by consignee due to clear site not being available etc., the Consignee must inform Contractor and ASRW, explaining the exact delay. However, initiative must be taken by Contractor to obtain such a certificate from Consignee. Contractor must bring any difficulty/dispute to the notice of ASRW immediately.
- 11.2.6 In their own interest, contractor must maintain a log of events in this respect with clear dates and regularly inform consignee and ASRW to avoid wrong levy of LD. Consignees must cooperate with Contractors by providing all assistance.


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including clear information about any expected delays in site availability, promptly and in writing.

- 11.2.7 If an order has been placed on the firm, the firm will have to advise the consignee well in advance regarding requirement of road permit and assistance required from the consignee, if any, so that delay on this account is avoided. Firm should also visit the site before dispatch of machine to assess the condition of path to be used for movement of trailer.

11.3 DISPATCH OF THE MACHINE FROM MANUFACTURER WORKS:

- 11.3.1 The supplier should normally dispatch the machine only after the foundation is ready for installation and commissioning of the machine on arrival.

- 11.3.2 In case of delay on part of consignee in providing the clear site for construction of foundation or any other facility as specified in the contract to the supplier, the supplier will report the matter to ASRW and consignee. In case of delay in readiness of site on part of consignee, ASRW shall take up the matter with concerned Railway/ PU, and advise supplier accordingly.

- 11.3.3 In case proving of component at manufacturer works, the supplier should request for the same as soon as possible after receiving contract keeping allowance of transit time etc. and approximately 60 days for consignee to handover the parts after receipt of the request accompanied by appropriate and valid bid guarantee. In the event of consignee certifying the non-availability of prove out components, such components will be deemed to be proved out at manufacturer works. However, the firm will prove out these components at consignee subject to the availability.

12.1 INSTALLATION, COMMISSIONING AND PROVING TESTS: (ON TURNKEY BASIS)

- 12.2 **Joint Check** – The contractor or his agent would be required to carry out a joint check at consignee's end, along with the consignee, before unpacking is done, to avoid subsequent complaints regarding short shipment/transit damages. It is necessary that this joint receipt inspection be done immediately on receipt of the machine by consignee & bidder's representative to avoid commissioning delays due to shortages/transit damages. After receipt of the machine as above a Joint Receipt Inspection note (JRI) as per Annexure-C of Section-VI shall be prepared by the consignee and the firms representative indicating the tentative time schedule for various activities of installation and commissioning. For Indian manufacturers, JRI note shall accompany the bill for 80% payment.

12.3 RESPONSIBILITIES OF CONSIGNEE AND BIDDER

- 12.3.1 The consignee shall be responsible for-

- i. Provision of a clear covered (except where shed is in the scope of contract) site for construction of foundation as per the schedule to ensure its readiness before arrival of machine at site.
- ii. In case where construction of shed is also in the scope of contractor the consignee shall ensure site is encroachment and encumbrance free.
- iii. Electricity, water and compressed air for installation and commissioning of machine shall be provided free of cost within one week of arrival of machine at site.
- iv. Wherever a road mobile crane has to be arranged by the supplier for material handling, a clear approach for it up to the site has to be provided.

- v. Clear covered space for storage of material/equipment required for working/ construction of foundation and installation of the machine etc.
- vi. The consignee shall arrange the raw material for prove out at their end within 15 days of the dry run of the machine (installation, power connection, auxiliary connection like air, water connection) failing which such components will be deemed to have been proved out. The components supplied by the consignee in time will be required to be proved out as per time schedule chart.
- vii. The inspection of foundation, structures etc. and installation of the machine shall be done by authorized representative of consignee.

12.3.2 The bidder shall be responsible for-

- i. Design & Construction of foundation, flooring of sufficient thickness, civil works (in line with scope of supply) suiting local soil conditions at the site in compliance with clause 3700 (3701 to 3704) of Bid Document Part-I.
- ii. Advise consignee in time regarding schedule for requirement of clear site for construction of foundation and other infrastructure, resources & facilities required.
- iii. Construction of foundation as well as flooring (if required) of sufficient thickness suiting local soil conditions, for machine shall be completed by the bidder at the site provided by the consignee before receipt of the machine at their premises.
- iv. Provision of all tools and equipment, technical and unskilled manpower, material handling accessories/ equipment and material for installation and commissioning.
- v. Unloading of the machine on receipt (both imported and indigenous machine) and its movement to the site of installation including provision of road mobile crane.
- vi. The bidder should ensure the proper earthing for the machine and its peripherals/accessories.
- vii. The bidder shall be responsible for meeting all the criteria set by State Pollution Control Board and Central Pollution Control Board, wherever applicable, with respect to air, water, noise, land etc. The bidder shall be responsible for obtaining clearance/certificate for installation/commissioning /operation of the machine/system supplied. The consignee will provide the administrative help for establishment of communication with the Pollution Control Board.

12.3 Consignee will provide only 415 V+10%/-20%, 3 phase 50 Hz+3% AC supply at a single point (mains). All types of cables, connections, circuit breakers etc. required for connecting power supply point to different parts of the machine/control cabinets, shall be the responsibility of the bidder. Requirement of grounding/earthing with required material shall also be incorporated by the bidder during construction of foundation.

Electrical work like laying of power/electrical cables & earthing wires from mains to machine control panel (upto 20 meters) as well as within the machine, with supply of all materials shall also be carried out by the supplier.

12.4 The supplier shall demonstrate machine performance and prove out the claimed capability for successful commissioning at the consignee's works as per clause 2.4 of Section-IV. The M&P shall be deemed to be "commissioned" at consignee premises on the date when it is tested and meets with the specified capabilities/functions according to the technical specifications. In addition to above, in case of tooled-up M&P, the M&P shall be deemed to be "Commissioned" at consignee premises on the date when "prove out"


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components specified as per the relevant clause of technical specification have been successfully proved out meeting the productivity requirements of Technical specification. The consignee shall arrange the raw material for prove out at their end within 15 days of dry run of the machine (installation, power connection, auxiliary connections like air, water etc.) failing which such components will be deemed proved out. The components supplied by consignee in time will be required to be proved out as per time schedule chart. Any delay in providing the "raw material or any other input" for proving out shall not be logged on supplier's account.

A Joint Commissioning Note (JCN) to this effect shall be made as per the format at Annexure-D of Section-VI. After issue of JCN the performance shall be watched for a period of one month, after which the PTC shall be issued. The issue of PTC cannot be delayed by more than 60 days from the issue of JCN. If some minor breakdowns are noticed after the issue of JCN, these shall be attended as per warranty obligations and suitable extension of the warranty period, under intimation to ASRW. If no intimation is given to ASRW and the PTC is not issued till the expiry of 60 days from the issue of JCN, then the issue will be discussed in a meeting between CME/PCM and the consignee. Based on this, decision to issue PTC will be taken by CME/PCM, the concerned technical officer and CME.

- 12.5 If an assembly/sub-assembly requires to be taken back to the manufacturer's premises for repair/replacement either before commissioning or during warranty, the manufacturer or his agent would be required to submit BG of suitable amount. In case the entire machine has to be taken back, a Bank Guarantee for the cost of the machine would have to be submitted. The bank guarantee should be of adequate value so as to cover the cost of the assembly/sub-assembly/paid up cost of the machine.

13.0 SERVICE FACILITY IN INDIA AND TECHNICAL SUPPORT

- 13.1 The tenderer will clearly spell out in the offer the facilities available with him or his agent for providing adequate after-sales service in India during warranty period in the appropriate section of Annexure 'A' of Bid Document Part-II. The complete details such as organization for after sales service, availability of technically competent engineers and warehousing facilities for spares should be clearly indicated. Bidders not offering complete servicing/repair facilities in India to ensure quick response to maintenance/ servicing calls are not likely to be considered.
- 13.2 After the warranty period and AMC period, if any, the manufacturer or his agent shall agree to provide service supports for trouble shooting and obtaining spare parts. The manufacturer shall be obliged to provide spare parts required by the Purchasers for a period of 12 years from the date of delivery of the machine at the ultimate destination to safeguard against obsolescence.
- 13.3 Tenderer who are OEM, shall undertake to supply spare parts for a period of expected life of machine. Other tenderers shall submit undertaking from OEM for supply of spare parts for a period of expected life of the machine.
- 13.4 During warranty period, the supplier or his authorized agent shall attend for break down as soon as possible, but in no case later than 72 hours of receipt of intimation of the breakdown.

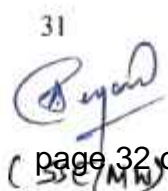
14.0 BOUGHT OUT ITEMS

- 14.1 The bidder shall furnish along with the offer a list of all critical items/ sub-assemblies which are bought out by the bidder and proposed to be used, along with the manufacturer's name, brand model etc. The successful bidder may be required to produce invoices to ensure genuineness of such products / verification by the Inspecting agency.
- 14.2 The bidder should clearly indicate that in case of components/sub-assemblies taken from reputed companies such as Vickers, Rexroth, RITTAL, THK, and Shenburger etc., the parent company has already entered into contract with their Indian units/affiliates for undertakings repairs/after sales service during warranty and post warranty.

S.No.	Sub-assembly	Make
1.	Hydraulic system	Rexroth/Vickers/Yuken/Atos/Parker
2.	Air conditioner for Control cabinet	RITTAL/Warner Finley/Kelvin
3.	Lubrication System	Cenlub/Dropco/Vogel/ Rexroth
4.	Electrical Control Cabinet	RITTAL/ Siemens or of other reputed make with IP55 Protection level
5.	Servo Controlled Voltage Stabilizer	Neel/Unity /Servomax/Consul/ Aplab/ Neelkanth
6.	Ultra Isolation Transformer	Neel/Unity /Servomax/Consul/Aplab/ Neelkanth
7.	A.C. Motors	NGEF/BBL/ABB/KEC/Crompton/ Siemens/ Allen Bradley
8.	Proximity Switch	Elap/Schneider/Omron/Scanner
9.	Contactors	Siemens/BCH/ABB/Schneider/L&T
10.	Limit switches	BCH/Siemens/L&T/Teknic/Euchener/ Honeywell,USA
11.	Push button	Teknic/Siemens/ Schneider/BCH
12.	'O' Rings & rubber seals	Merlin/Parker/Busak/Hunger/Merkel/Soloseal/ Walkersolo/Halite
13.	Cable/wire	Siemens/Indramat/Hubershner/ Finolex/Havells/KEI
14.	PLC	Siemens/Fanuc/Mitsubishi/ Messung/Hitachi/ ABB/ Allenbradley/Schneider
15.	Air circuit breaker	Siemens/L&T
16.	Connectors	Harting/Kontakt/L&T/Omron
17.	Hydraulic seamless tubes	Parker/Maharashtra seamless/ Indian seamless
18.	MCCB	Schneider/ABB/ Siemens/L&T/C&S

- 15.0 COLOUR: The machine and its accessories shall be painted in Apple Green Colour No.281 to IS:5-1978,(if any specific colour code standardized by BIS is available, the same be given). The machine can also be painted in equivalent RAL/DIN/other International Standards. If there is a standard color scheme of the manufacturer, the same can also be considered and may be specified.


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16.0 WARRANTY OBLIGATION –The following conditions regarding Maintenance and reliability shall also apply: -

- 16.1 The machine shall be designed for a life of 15 years with regular maintenance and all the structural members of the machine and the foundation shall be guaranteed for 15 years against cracks breakages and etc. during the course of normal operations. Tenderer would submit suitable undertaking.
- 16.2 Foreign suppliers who do not have registered office / maintenance facilities in India may authorize an Indian agent, who shall be responsible for maintenance and break down support. In such case, Indian agent should have experience of maintaining at least 5 machines during past 5 years preceding the tender opening date. The tenderer should submit documentary evidence towards the experience of the Indian agent, along with the offer.
- 16.3 In addition to warranty obligations prescribed under clause 3400 and 3500 of the Bid Document Pt-I, the warranty period would also cover comprehensive preventive maintenance, which will be inclusive of all spares, material and labour cost. All maintenance consumables like lubricants and grease except hydraulic oil / machine coolants shall form part of the scope of the preventive maintenance during the warranty. The cost of preventive maintenance to be carried out during warranty period should be quoted separately.
- 16.4 The payment of preventive maintenance schedule carried out during warranty period shall be made by ASRW annually at the end of each year after completion of the work and issue of certificate by the consignee as per Annexure-E of section-VI.
- 16.5 The machine shall at all times give contractual out-put and accuracy. Any deficiency or break down for a total of 02 hr. or more for a day would be treated as failure for the day, for the purpose of extending warranty period in terms of clause 3405 of Bid Documents Part-I.
- 16.6 The tenderer shall ensure that in case a failure is reported by a consignee, qualified service engineer shall visit the site within two days from the date of complaint on calendar day's basis. The period of three days (excluding date of complaint) after the failure reported shall be treated as grace period, which will not count towards breakdown time for up to one failure per month and a maximum of 3 failures per quarter. In case the number of failure exceeds one failure per month or three during any quarter of warranty, grace period of only 1 day will be permissible for such additional failure. Complaints shall be lodged by consignee by fax phone, e-mail or per bearer at address given by the tenderer.
- 16.7 The details of preventive maintenance to be provided during warranty period shall be indicated by the tenderer giving details of type of preventive schedule, periodicity on items to be checked, items to be replaced and expected plant down time in the following format:

S.No	TYPE OF PREVENTIVE SCHEDULE	PERIODICITY	ITEMS TO BE CHECKED	ITEMS OF REPLACEMENT	EXPECTED PL DOWN TIME

Preventive maintenance schedules shall be conducted on weekends as far as possible or any other day through mutual agreement with consignees. Total breakdown hours shall be calculated after discounting grace period and preventive maintenance period.

- 16.8 Maximum permissible down time till it is restored back to the contractual output and accuracy levels, in any quarter of the year during the warranty period, shall be 150 hrs. in case the total breakdown period in any one of year during warranty period, exceeds 500 hrs., the consignee shall inform the same to ASRW To ensure this a record of breakdown (duly signed by shop in charge) in hours on quarterly basis should be maintained by the consignee and joint report with the contractor shall be made for each breakdown attention. At the end of first and second year of warranty, these details of breakdown hours during warranty period should be advised to ASRW as per performance appraisal report given in Annexure – E of section –VI. The firm will then request ASRW for release of WBG annexing the performance appraisal report as per Annexure-E of Section-VI and the breakdown details mentioned above.

Penalty will be levied on the bidder for breakdown period on working days basis (excluding holidays) after discounting for the grace period. Penalty will be calculated as percentage of annual preventive maintenance charges and will be deducted from the respective annual payments as under

Breakdown period	Applicable penalty
Up to 150 hours in each quarter and not exceeding 500 hours annually	Nil
Exceeding 150 hours - up to 200 hours in any quarter and not exceeding 500 hours annually	5 % of annual preventive maintenance charges
Exceeding 500 hours - up to 750 hours annually	10% of annual preventive maintenance charges
Exceeding 750 hours - up to 1000 hours annually	25% of annual preventive maintenance charges
Exceeding 1000 hours annually	50% of annual preventive maintenance charges and Encashment of Warranty Bank Guarantee besides other action like noting adverse performance of the bidder and/or agent for future tenders and their offer in the subsequent tenders will not be considered for placement of any order.


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17.0 COMPREHENSIVE ANNUAL MAINTENANCE CONTRACT

17.1 Tenderers are required to quote for a comprehensive Annual Maintenance Contract for the machine supplied against this specification for a period of five years on yearly basis giving the rates for each year i.e. first year, second year... so on., which will be inclusive of all spares, material and labour costs. The duties and taxes as applicable should be indicated separately. All consumables, spares and materials shall form a part of the scope of comprehensive AMC except as follows.

- a. Diesel/Fuel, lubricating oils or coolant
 - b. Major machines elements/structural members which are under guarantee for a period specified in clause 16.1 as stipulated in 'warranty obligations' requirement.
- 17.2 AMC shall be operated, managed and paid by the consignees indicated under clause 3 of Section IV. The consignee shall indicate the bill payment authority & custodian of the AMC BG. No further agreement is required for operating AMC at consignee end.
- 17.3 AMC is a part of scope of supply, in case of concomitant requirement and included in commercial evaluation criteria vide clause 5 of Section-IV.
- The detailed terms and conditions of AMC shall be as given in following clauses:
- 17.3.1 The duration of AMC shall be 5 years from the date of expiry of warranty. Rates for AMC shall be quoted by the tenderer on yearly basis, which will remain applicable during the duration of AMC and not subject to any variation except any statutory changes in taxes and duties as compared to quoted rates.
- 17.3.2 The tenderer must provide AMC services at the consignee location without any precondition. The AMC should include complete responsibility for the bought out sub-assemblies and components like CNC system, diesel engine, AC unit etc.
- 17.3.3 The details of preventive maintenance services including cleaning of machine to be provided under AMC shall be provided by the tenderer in the following format.

S.no	Type of preventive schedule	Periodicity	Items to be checked	Items of Replacement	Expected plant down time
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- 17.3.4 Preventive maintenance shall preferably be conducted on weekends through mutual agreement with the consignee. Each preventive maintenance schedule normally shall not exceed one day. The total shutdown time for preventive maintenance should be kept as low as possible but not more than 60 hours/month (averaged over the quarter) including time for cleaning, weekly, fortnightly, monthly, quarterly schedules etc. The preventive maintenance regime offered must be aimed at achieving minimum 90% uptime of the plant excluding the plant down time for preventive maintenance schedules.
- 17.3.5 The tenderer shall ensure that in case a failure is reported by a consignee, qualified service engineers visit the site within 3 days from the date of complaint on calendar days' basis. This period of 3 days (excluding date of complaint) after the failure report shall be treated as grace period, which will not count towards plant down time for upto one failure per quarter and a maximum of 4 failures per annum. In case, the number of failures exceed one during any quarter or four during any year of AMC, grace period of only 2 days will be permissible for such additional failures. Complaints shall be lodged by consignee by fax, e-mail or per bearer at address given by the tenderer. The


responsibility to keep the failure reporting address details current will rest with the tenderer.

- 17.3.6 In case preventive maintenance is carried out along with breakdown maintenance schedule, preventive maintenance time will be deducted from breakdown time of the plant.
- 17.3.7 **Penalty Clause:** Penalty shall be levied on the tenderer for maintaining plant up time below the limit of 90% calculated on working day basis, after discounting for grace period and preventive maintenance period. Penalty shall be calculated as %age of quarterly payment and will be deducted from the respective quarterly payments. Penalty calculation will be done over quarterly payment period.

S.No	Availability Slab	Applicable Penalty
1	90% to 80%	0.5% for every 1% (or part thereof) reduction in availability of plant below 90%.
2	Below 80%	1% for every 1% (or part thereof) reduction in availability of plant below 80%.

- 17.3.8 A Bank Guarantee equal to $\frac{1}{4}$ of annual value (highest of the annual values if the rates offered for various years are different) of AMC subject to a minimum value of 1.25% of the quoted cost of machine including concomitant accessory (in case the annual AMC rate quoted is less than 5% of the cost of machine), will be submitted by the tenderer to the consignee 90 days before the expiry of warranty. AMC will have the validity of 5 years 6 months. The bidder can submit multiple BG for lesser duration to cover the period of 5 year 6 months ensuring the uninterrupted validity of the AMC BG for 5 year 6 months. The confirmation for the submission of this BG shall be submitted to ASRW for release of WBG. The AMC BG will be returned on completion of AMC period. In case, the tenderer fails to provide AMC services successfully, the AMC BG will be forfeited. This will be in addition to penalty as per clause 17.3.7 above. This provision would not be applicable where the advance payment is made.
- 17.3.9 Plant up time of less than 60% for two consecutive quarters will constitute complete failure of tenderer to provide the AMC services successfully and will result in forfeiture of AMC BG, besides other action like noting adverse performance of the bidder and/or agent for future tenders and their offer in the subsequent tenders will not be considered for placement of any order. This will be in addition to penalty clause 17.3.7 above for the period of actual performance.
- 17.3.10 As per clause 5.1.1 of bid document Part-II, Section V, where AMC is part of evaluation of offer, it is the sole responsibility of bidders to stock all spares and materials as required for smoother execution of AMC in order to achieve response time in compliance to machine availability as per stipulated requirements.
- 17.3.10.1 In all cases of plant failure except as mentioned in clause 17.3.10.2, any other spare part or material necessary to restore the plant to proper working order will be arranged by the tenderer as a part of AMC.
- 17.3.10.2 In case of damage to the machine on account of any external factor, viz., floods, earthquake, fire, arson or sabotage, entire cost of spare parts and material necessary for repair of the plant shall be borne by the railways. However, the tenderer shall provide services of their engineers free of cost as a part of AMC to restore the plant to working order.


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- 17.3.10.3. In case of damage to the plant as mentioned in para 17.3.10.2, any spare parts and material necessary to restore the plant to proper working order shall be arranged by the tenderer and charged on actual basis duly certified by authorized railway official in the next quarterly bills. The rates charged for such spare parts shall be based upon the spare part rate list provided by tenderer in compliance of clause 5.2 or any other valid document. The tenderer shall furnish documents to support the rates charged for spares used for repair under para 17.3.11(a).
- 17.3.11. Normally quarterly payment (@ 1/4th of the annual quoted rates) under AMC will be made to the tenderer within 30 days from the end of that quarter subject to submission of the following documents by the tenderer to the paying authority assigned by the consignee:
- Consignee's certificate for work done as per **Annexure-G of Section-VI** with calculation of down time and penalty applicable.
 - A certificate by consignee that no spare part is due with the tenderer as per clause 17.3.10 above.
 - Bills submitted by the tenderer & accepted by consignee.
 - Attested photocopy of the AMC BG.
- 17.3.12 The AMC contract can be terminated in following ways:
- Consignee may terminate the AMC in the event of failure of tenderer to provide AMC services of the AMC agreement in addition to encashing of AMC BG as per clause 17.3.8.
- 17.3.13 Other General Conditions shall be governed by Bid Document Part-I (Section-I, II and III) as applicable to respective ASRW PO.

SECTION VI

ANNEXURE-A

FORMAT FOR SUBMISSION OF TECHNICAL BID

1. a) We, M/s.----- offer our ----- machine, model no. ----- as per the description given in Schedule of Requirements.
- b) We state that, except for the following, for which clause wise brief description and justification for deviation has been indicated, our machine fully complies with all the clauses as given in technical specification Section-V.
- c) We also confirm all the schedules given in the Delivery Schedule at para 7 of Section-IV.

S.No.	Clause/Item	Brief description of Deviation	Justification for deviation

Note 1: In case there is a contradiction in any information provided (some parametric values given in the specification and those given in the brochure or some other document enclosed by the tenderer), unless specifically mentioned in the deviation cum confirmation statement under Annexure A of Section VI, the values as given in the specification shall be taken as confirmed by the tenderer and offer evaluated accordingly.

Note 2: In case tenderer offers internationally accepted alternative specifications as per clause 1.7, complete details of alternative specification, apart from filling above deviation statement, may be enclosed

2. We further certify that we are meeting the reference clause as:
- (A) We are the regular manufacturer of this type of machine.
- (B) We have made the following past supplies of similar machines as per clause 3 of special conditions during last 5 years: -

S. No.	Name of the Purchaser with Address	Purchaser's Phone, Email Address, Name of the contact person	Purchase/ Supply Order number and date (along with a copy of the PO)	Quantity Supplied (with proof of supply) @	Date of Supply @	Date of Installation and/or Commissioning @	Leading Parameter(s) of the Machine i.e. Hydraulic Press 200 T Capacity or more.
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@ (along with copies of relevant documents to establish linkages of documents/ entities as detailed in clause 5 of Qualifying Requirements)

- (C) We are submitting following performance certificate from past users as per clause 4 of Special Conditions :-

S. No.	Name of the Purchaser with Address	Purchase/ Supply Order number and date (along with a copy of the PO) (It should be the one(s) which are enlisted at clause 2 B above)	Quantity Supplied	Date of Supply	Date of Installation and/ or Commissioning	Date of issue of Performance Certificate	Performance as per Annexure-A1
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3. We are having following facilities available with us or our agent for providing adequate after-sales service in India during warranty period. Complete details of after sales service, availability of technically competent engineers and warehousing facilities for spares is indicated below:
- After sales service centers;
 - Availability of technically competent engineers;
 - Warehousing facilities for spares;
4. We have quoted for the following optional accessories as indicated under clause 4.3 of section IV

S No.	Description of the optional accessory	Quantity (in Nos.)	Rate (in Rest.)	Indigenous	Shelf Life (in Months)
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5. We have quoted for following recommended perishable and non-perishable spares required for normal maintenance to cover complete range of mechanical, hydraulic and electrical equipments including controls on double shift working basis;

Perishable Spares

S No.	Description of the spares	Part number	Quantity (In Nos.)	Rate (In Rs.)	Shelf Life (in Months)
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Non-perishable spares

S.No.	Description of the spares	Part number	Quantity (In Nos.)	Rate (In Rs.)
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6. *We hereby confirm that we are the OEM and undertake to supply spare parts for a period of expected life of machine.

OR

*We hereby confirm that we are not the OEM, but are submitting undertaking from OEM for supply of spare parts for a period of expected life of the machine to provide maintenance spares (as and when ordered) after the expiry of the Warranty/AMC for 5 years (life of machine - 15yrs) including the maintenance spares required for the bought out sub-assemblies and parts.

(*Strike out whichever is not applicable)

7. We have quoted consumables required as per clause 6.1 of Section V of Bid Document Pt-II, in the format give below

S No.	Description of the consumable spares	Qty	Unit	Rate

- 8 It is certified that we are having suitable facilities at our works for carrying out various performance tests on the sub-assembly/assembly/machine and these shall be made available to the inspecting authority.

9. **BOUGHT OUT ITEMS:** We hereby furnish a list of all critical items/ sub-assemblies which are bought out by us and proposed to be used, along with the manufacturer's name, brand model etc.

Sr No.	Description	Item no.1	Item no. 2	Item no. 3
1.	Brief description of item			
2.	Model no.			
3.	Make			
4.	Quantity/machine			
5.	Manufacturer's name and complete address			
6.	Whether imported or indigenous			
7.	Country of origin			

10. The details of Preventive Maintenance during warranty and comprehensive Annual Maintenance Contract as per clause 16.7 & clause 17 of Section-V respectively. The Preventive Maintenance during warranty and comprehensive Annual Maintenance Contract is in the scope of this tender. Details of preventive maintenance services including cleaning of machine to be provided under PMC during warranty and AMC is given in the following format.

S.No	Type of preventive schedule	Periodicity	Items to Be checked	Items of Replacement	Expected plant own time

11. We further submit the following information about the offered machine as per the technical specification section VI and Important Features of the tender section IV. We understand that any omission of any of the below mentioned information will render our offer incomplete to that extent.


WM/ASRW


(SSE/Elco.)


(SSE/BSS)

1.

Schedule-1A

Applicable for 200T Down-stroke C- Frame Vertical Type Hydraulic press for Consignee – CWM/ASRW

2.2	Leading parameters			
2.2.1	Major parameters: (Note: No deviation in major parameter shall be accepted.)			
Clause no. of Section-IV	Item Description	As specified	Value/ Write up/ Brochure (As offered)	
1.1	Type of press	Open front "C" frame vertical type		
1.2	Pressing force	200 T (minimum) (in down ward direction)		
2.2.2	Other parameters			
Clause no. of Section-IV	Item Description	As specified	Value/ Write up/ Brochure (As offered)	Justification for deviation offered (if any)
1.1	Stroke (adjustable)	600mm (minimum)		
1.2	Daylight	800 mm approx.		
1.3	Working table size (LXB)	2000X 900 mm (min)		
1.4	Ram Block Size (LXB)	660x660 mm		
1.5	Working height	700-750mm		
1.6	Parallelism between top and bottom heads:	0.05mm per 300mm		
1.7	Flatness of surfaces	0.03mm per 300mm		
1.8	Ram speeds (max. permissible variation: + 10%)			
	Approach speed:	40mm/sec.		
	Pressing speed:	5mm/sec.		
	Return speed:	60mm/sec.		
1.9	Geometrical accuracies of the press	As per IS: 14877 (Pt. I) : 2000 Grade 2		
1.10	Motor Power	20 HP		
1.11	Power supply	415V+/-10%, 50Hz.+/- 3%		
1.12	Hydraulic oil tank capacity	450 Liters (minimum)		
1.13	Two nos. separate earth pits will be provided and connected.			
Note:- (i) This press is preferred with heat resistant ram bottom to prevent heat transmission to piston oil seals during welding of draft gear rear plate in pressed condition.				

S.No.	Information required	As per Clause No.	Value /Write up/ Brochure
2.	Technical Details/Particulars of Motors, Control Gears, Transformer	Voltage Stabilizer & Isolation	
2.1	<p>A.C. Motors and Control Gears</p> <p>AC MOTOR</p> <ul style="list-style-type: none"> • Manufacturer's Name • Type of enclosure • Type of duty (Ref. IS: 325) (Latest) • Rating-Continuous/intermittent • Output (KW/BHP) • AC voltage across phases, number of phases & frequency. • Speed in RPM • Class of insulation • Normal full load current • Starting current • Maximum current at the time of change over from lower speed to higher speed • Type of motor-Squirrel cage/slipring (wound rotor) • Temperature rise of windings and other parts allowed above an ambient temperature of 50 degree C. • Frame size of motor • End use of motor <p>CONTROL GEARS</p> <ul style="list-style-type: none"> ▪ Manufacturer's Name ▪ Type of control gear (Direct on line/Star Delta/Auto-transformer etc.) ▪ Rating of starting gear in KW & amps. ▪ Short circuit protection (y/n) ▪ No volt trip (y/n) ▪ Overload trip (y/n) ▪ Delayed action current sensitive single phasing preventor (y/n) ▪ Standard specifications to which the motor control gear and its ancillary offered conform to 		
2.2	<p>D.C. Motors and Control Gears</p> <p>DC MOTOR</p> <ul style="list-style-type: none"> • Manufacturer's Name • Type of enclosure • Type of duty (Ref. IS: 4722) (Latest) • Rating-Continuous/intermittent • Output (KW/BHP) • DC voltage across phases, number of phases & frequency • Method of excitation whether shunt, series, compound or separately 		

	<p>excited, if separately excited state excitation voltage.</p> <ul style="list-style-type: none"> • Speed in RPM • Class of insulation • Normal full load current in amps. • Starting current • Temperature rise of windings and other parts allowed above an ambient temperature of 50 degree C. • Frame size of motor • End use of motor <p>CONTROL GEARS</p> <ul style="list-style-type: none"> • Manufacturer's Name • Type of control gear (Direct on line/Resistance type/Thyristor type) • Rating of starting gear in KW & amps. • Short circuit protection (Y/N) • No volt trip (y/n) • Overload trip (y/n) • Standard specifications to which the motor control gear and its ancillary offered conform to • Standard specification to which control gear conforms to 		
2.3	<p>Voltage Stabiliser & Ultra Isolation Transformer</p> <p>VOLTAGE STABILISER</p> <ul style="list-style-type: none"> • Manufacturer's Name • Type of voltage stabilizer : <ul style="list-style-type: none"> a) DC servo motor type b) AC servo motor type c) Solid state • Rated capacity in KVA • Nos. of phases & frequency • Type of input supply unbalanced • Input voltage • Output voltage • Rate of correction • Class of insulation & winding (only copper wound is acceptable) • Type of control circuitry • Class of duty • Type of cooling • Indicating instruments and their ranges • Safety features <p>ULTRA ISOLATION TRANSFORMER</p> <ul style="list-style-type: none"> • Manufacturer's Name • Rated capacity • Ratio of input/output voltage • Class of insulation 		

WM/ASRW

(SSE/Elec.)

AT (SSE/BSS)

	<ul style="list-style-type: none"> Arrangement for suppression of power line surges, spikes, transients and noises Type for cooling. 		
3.	Any special features facilitating ease of maintenance shall be explained in the offer.	2.3(ii) of Section IV	
4.	First fill of oils and lubricants- (Quantity of each item shall be indicated in the bid).	4.2.1(i) of Section IV	
5.	Maintenance tools (Make, description & Qty. to be furnished)	4.2.1 (ii) of Section IV	
6.	The details of the toolings required for different components mentioned in Annexure - F for the consignee shall be provided in the offer	4.2.1 (vi) of Section IV	
7.	Details of the safety features shall be furnished in the bid.	1.1.2 of Section V	
8.	The method of checking weld defects and the method of stress relieving shall be explained in the bid. The detailed design calculations for the suitability of the critical sections or the FEM analysis should be furnished in the bid. Value of deflection at full rated capacity shall be indicated in the bid along with calculations. A cross-sectional drawing shall be submitted clearly showing the various stiffeners provided for structural strength.	1.2.1.1 & 1.2.2.5 (i) of Section V	
9.	The method of coupling the moving platen to the ram end shall be explained with the help of drawings in the offer.	1.2.1.2 (iii) of Section V	
10.	A dimensioned cross sectional drawing of the tool bolster shall be submitted with the bid.	1.2.2.6 (ii) of Section V	
11.	Material specification and surface finish of the liners shall be indicated in the bid.	1.2.2.3 (ii) of Section V	
12.	Material specification of the tie-rods shall be indicated in the bid.	1.2.2.5 (ii) of section V	
13.	The Design philosophy of Main Ram & parameter selected such as material, type of construction & wall thickness etc should be explained in the bid.	1.2.4.1 of Section V	
14.	Arrangement provided for relieving the piston seals of any lateral loading shall be explained in the bid. The offer shall explain the sealing arrangement provided in the ram-cylinder-assembly with the help of a labeled sectional drawing.	1.2.4.2 of Section V	
15.	The average life of the proposed material shall be indicated in the offer.	1.2.4.3 of Section V	
16.	Material specification, actual hardness, surface finish and thickness of chrome plating of the ram cylinder shall be indicated in the bid.	1.2.4.5 of Section V	
17.	The design calculations, taking into consideration frictional losses in the hydraulic circuit as well as in the ram-cylinder assemblies shall be explained in the offer. The bidder shall submit dimensioned assembly drawings showing cylinder bore and ram/ram head dimensions (with tolerances). Design calculation for motor horse power, speed, pump capacity and motor power shall also be explained in the offer.	1.2.4.6 of Section V	

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 (SSE/MW)

18.	The ram end shall carry ram block/moving platen forged out of highly wear resistant alloy steel, and tenderers shall indicate the material to be used. The method of coupling the moving platen to the ram end shall be explained with the help of drawings in the offer.	1.2.4.7 of Section V	
19.	The ram-cylinder assemblies shall be provided with suitable arrangement such as slide rods to prevent ram rotation during ram working. The arrangement shall be explained in the offer.	1.2.4.8 of Section V	
20.	The hydraulic system shall be of modular construction (with logic control valves/ solenoid valves). The drive of the press shall be through hydraulic pumps. details of which shall be given in the offer.	1.2.5.1 of Section V	
21.	Particulars of the hydraulic fluid used shall be indicated in the offer. The successful bidder shall be required to indicate reputed Indian source of supply for the hydraulic fluid. The first fill of the hydraulic fluid shall form a part of the supply as concomitant accessory.	1.2.5.3 of Section V	
22.	The type, make and model no. of each filter element shall be indicated in the bid.	1.2.5.5 of Section V	
23.	Details of the clogging indicator shall be furnished in the bid.	1.2.5.6 of Section V	
24.	Arrangement shall be explained in the bid. Heat load calculations and the details of heat exchanger system should be furnished.	1.2.5.7 of Section V	
25.	The arrangement provided shall be explained in the offer.	1.2.5.11 of Section V	
26.	The successful tenderer shall provide the first filling of hydraulic oil, the cost of which shall form part of the basic price of the press. Tenderers shall indicate the exact grade of oil used and equivalent oils available in India that are suitable for use.	1.2.5.12 of Section V	
27.	The tenderer shall submit with the offer a diagram of the hydraulic circuit incorporated in the press giving full details such as size of lines, cut-off pressure, type, model number and make of: i. hydraulic elements ii. hydraulic motor iii. pumps, etc. The logic diagram for sequence of operations must be supplied. Each element in the diagram shall be suitably numbered. The elements on the press shall be correspondingly labeled prominently for the convenience of the operating and maintenance staff.	1.2.5.13 of Section V	
28.	The system so designed shall be explained in the offer with a line diagram of the hydraulic circuit. The names of individual hydraulic element shall be indicated in the bid.	1.2.5.16 of Section V	
29.	The offer shall clearly explain how this efficiency would be achieved.	1.2.5.17 of Section V	

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WM/ACRW

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(SSE/45)

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(SSE/Elec.)

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(SSE/BSS)

30.	The ram speeds shall be adjustable and the control shall have a graduated scale to indicate ram speed in mm/min. The ram displacement will be through LVDT (Linear variable differential transducer and displayed in PLC - MMI. Arrangement provided shall be explained in the bid.	1.2.5.21 of Section V	
31.	The device shall be explained in the offer.	1.2.5.22 of Section V	
32.	The device shall be explained in the bid.	1.2.5.23 of Section V	
33.	The arrangement provided to be explained in bid with sketch.	1.2.5.26 of Section V	
34.	The drawing of control panel indicating location of various controls provided therein shall be furnished in the bid	1.2.6.1 of Section V	
35.	The precise range and steps of control shall be indicated by the bidder.	1.2.6.3 of Section V	
36.	Least count for force and pressure on the gauge shall also be indicated in the offer.	1.2.6.4 of Section V	
37.	The lubrication system shall be explained in the bid with a lubrication circuit diagram. The make of the components in the circuit shall also be indicated in the bid.	1.2.7 of Section V	
38.	One copy of the printed illustrative catalogue showing features of the machine and its elements must be enclosed with each copy of the bid.	4.1 of Section V	
39.	Quality Assurance Plan being followed at the manufacturer's works for ensuring quality of the products offered shall be furnished.	9.1 of Section V	
40.	A Sample Inspection Chart for inspecting the equipment shall be supplied along with the bid.	9.4 of Section V	
41.	Misc. 1 Maximum working pressure kg./sq. cm. 2 Oil tank capacity ltrs. 3 Capacity of each pump lit./min. 4 Motor power kW 5 Overall dimensions of the equipment... mm x mm x mm 6 Approximate weight of press kg 7 Following drawings should be submitted alongwith the bid: a) General arrangement drawing b) Cylinder-ram assembly cross sectional drawings c) Hydraulic circuit & piping diagram		

Signature of the authorized representative of the bidder
with company stamp

ANNEXURE-B

FORMAT FOR INDEMNITY BOND

This deed of Indemnity executed by M/s. _____ hereinafter referred to as Indemnifier' which expression shall, unless repugnant to the context or meaning thereof, include its successors, administrators, representative and assignees in favour of Central Organisation for Modernisation of Workshops, Railway offices Complex, Tilak Bridge, New Delhi - 110 002, India, hereinafter referred to as the 'Indemnified' which expression shall unless repugnant to the context or meaning thereof, include its successors and assignees witnesses as to.

Whereas the Indemnifier herein had participated in a global tender for the supply of _____ (machine name) which is opened on _____ (date) on terms and conditions set out interalia in the Tender Document.

And whereas, clause of the above mentioned tender document described that the machine shall be designed for a life of 15 years with regular maintenance and all the structural members of the machine should be guaranteed for 15 years against cracks, breakages etc. during the course of normal operations from the date of commissioning whichever is earlier of the stores supplied by the Indemnifier to the indemnified.

The indemnifier hereby irrevocably agrees to indemnify the indemnified that in the event of the said machine not achieving the life guarantee, the indemnifier shall as may be deemed necessary repair the defective machine at site, free of cost, within a reasonable time specified by the indemnified or reimburse the pro-rata cost of the machine to the extent a life not achieved as per the guarantee, or supply a spare stores for the defective portion only free of cost at site.

Bidder's authorized signatory
With seal

Station:

Date:

Witness: 1. _____

(Signature with Name, Designation & Address)

2. _____

(Signature with Name, Designation & Address)


WM/ASRW


SSE/Elec.)


(SSE/BSS)

ANNEXURE-C

JOINT RECEIPT INSPECTION NOTE

Date.....

Sub: Receipt of consignment for machine.....
Ref: ASRW Contract No.....

1.	Name of consignee/Railway	
2.	Machine name	
3.	Quantity	
4.	Name of supplier	
5.	Consignment of the machine received on	
6.	The foundation & associated works essential for "Safe Installation of Machine" are ready (for turnkey contracts only) *	Yes/No

* If there are Delays on account of Consignee such as clear site is not given, then the condition 6 will not be a valid ground for holding JRI.

It is certified that the consignment of the machine has been received complete and in good condition as per specification shown in the contract.

Tentative plan for installation and commissioning of the machine is as under:

1.	Date of clear site provided	
2.	Contract	Turnkey/Non-turnkey
3.	Status of readiness of foundation:	
3(a)	Already constructed on	
3(b)	Under construction & likely date of its completion	
3(c)	Construction yet to be started from and likely date of its completion	
4.	Status of availability of electrical power, water and compressed air etc.	Available/Not-available
5.	Number of components to be proved out on the machine	
6.	Likely date for start of erection/installation	
7.	Likely date for switch-on the machine	
8.	Likely date of completion of commissioning of the machine	

Representative of firm

Representative of consignee

Designation

Designation
(Minimum Gazetted level)

ANNEXURE -D

JOINT COMMISSIONING NOTE

Date:.....

Sub: Commissioning of (name of machine)

Ref: ASRW PO No.....

1.	Name of consignee/Railway	
2.	Machine name	
3.	Quantity	
4.	Name of supplier	
5.	Machine received on	

6. All the parameters of the machine are found okay. The proving test on the machine was conducted from to and machine is working satisfactorily.
7. Machine has finally been commissioned on..... The machine has been handed over for regular use and kept under one-month observation to watch its performance.
8. Following minor deficiencies (if any) found during joint observation trials are to be attended/rectified by the firm during one-month observation and before issuing the PTC for the machine:

- a.
b.
c.

Representative of firm
Designation

Representative of consignee
Designation
(Minimum Gazetted level)


WMM/ASRW


(SSE/ELC)


(SSE/BSS)

ANNEXURE -E

PERFORMANCE APPRAISAL FORM
APPRAISAL ON COMPLETION OF _____ YEAR of WARRANTY PERIOD

To, M/s.

Dated

1.	ASRW PO No.	
2.	Consignee/Railway	
3.	Name of supplier	
4.	Machine Name	
5.	Machine received on	
6.	Machine commissioned on	
7.	PTC issued on	
8.	Warranty period expired on	
9.	Performance during warranty period:	
9(a)	Total number of breakdowns	
9(b)	Total downtime in number of days	
10(a)	Any warranty complaint pending on date	Yes/No
10(b)	If yes, then the date and nature of defect(s)	

11. In case, of the machine with mandatory PMC during warranty period, following details of breakdown hours for preceding eight quarters must also be furnished.

Quarter	Period From -----To----- --	Breakdown hours
1		
to		
8		

Signature-----

Name-----

Designation: DY.CME/Sr.DME/Dy.CEE/Sr.DEE

Office Stamp

- i.) This appraisal may please be sent immediately on completion of first and second year of warranty period. If any extension of warranty period required, may please also be mentioned with details.
- ii) Sr. Scale Officer having independent charge is also authorised to sign.

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ANNEXURE-F

Components to be processed for Prove Out

ASRW (Schedule-1A)			
S.No	Name of Component	Drawing No.	Operations to be carried out
1.	RF-361 Draft Gear	Sketch of components	Dismantling, assembly and Pre-shortening

WM/ASRW

(SSE/Elec)

(SSE/BSS)

ANNEXURE-G

Consignee's Certificate for Quarterly Work Done Under AMC

1. Name of Plant:
2. Consignee
3. ASRW AT/PO No.
4. Name of Contractor
5. Quarterly charges for AMC(Standard): Rs.
 As per ASRW AT/PO no. dt.
6. Quarter for which bills are preferred:
 From. To.
7. No. of Breakdowns during the quarter:
8. **Calculation of Penalty and Net AMC charges payable to Contractor for the quarter:**
 - i. Total Plant Down Time (in days):
 - ii. Standard down days for preventive maintenance (in days/quarter):
 - iii. Total grace period for break down:
 - iv. Net down time for the plant [= (i)-{(ii)+(iii)}]:
 - v. 100% Availability for the quarter (in days):
 - vi. Actual availability [= (v)-(iv)]:
 Actual availability in %age [= {(vi) / (v)} x 100]:
 - vii. Calculation of penalty:
 - a. %age availability below 90% to 80%:
 - b. %age availability below 80%:
 - c. Penalty [= {(vii a) x (5) x 0.005 + (vii b) x (5) x 0.01}]:
 - viii. Net amount payable as AMC charges to [= (5)-(vii c)]

It is certified that all spares borrowed by the contractor for the previous quarter have been returned in good condition.

Signature of authorized representative of consignee

ANNEXURE- II

ASRW
Report on Capability Assessment of New Vendors

M/s(Name of Vendor).....

Machine/Product Class

Contents:

Para - 1 :	General Information
Para - 2 :	General Information (Technical)
Para - 3 :	Design Capability
Para - 4 :	Manufacturing Process
Para - 5 :	Quality Assurance
Para - 6 :	After-Sales Service
Para - 7 :	Past Performance
Para - 8 :	Commercial Information
Para - 9 :	Conclusions
Para - 10 :	Recommendations

List of Annexures :

A :	List of Managerial Staff
B :	Plan of Works to be assessed
C :	List of Machinery & Plant
D :	List of Raw Materials in Stock
E :	Q.A.P. of the Firm.
F :	List of QC equipments, Measuring equipments and Gauges
G :	List of Important Customers & Orders
H :	List of pending orders
I :	Performance of Machines supplied
J :	Proof of Ownership
K :	Factory License, NSIC/ SSI
L :	Copy of Latest Electricity Bill
M :	Certified copies of Balance Sheet and Profit & Loss accounts
N :	Income Tax Clearance Certificate

Other Annexure (if any)

Report on Capability -Assessment of New Vendors

- i) **Name of Vendor**
- ii) **Purpose:** (Assessing officers should detail the purpose of assessment, manufacturer, name of the machine and the tender number which necessitated assessment or otherwise.)
- iii) **Scope:** (The scope should define scope of capability assessment carried out detailing the machine/system or range of machines/systems.)
- iv) **Details of Stores/Items/Parts/components** for which assessment is carried out. (Indicate complete description. Vendor should submit a request to include more similar items in the assessment if required)
- v) **Assessment done on**

1.0 General Information

1.1. Background of vendor in Brief

1.1.2 Location

1.2 Postal Address

i. Head Office :

ii. Works/Factory (as per Factory License) :

1.3. Telephone No. (with STD code and Mobile)

i. Head Office :

ii. Works/Factory :

iii. Authorized Person who can be contacted telephonically:

1.4. E-mail IDs

i. Head Office :

ii. Works/Factory :

iii. Authorized Person :

1.5 Description of Factory/Works.

i. Total land area :
(in Sq. metres)

ii. Total covered area
(in sq. metres)

iii. Different sub-units
(with details of covered/
uncovered area, etc.)

iv. Special features, if any

1.6. No. of personnel employed (category-wise).

i. Managerial
(List to be attached as **Annexure-A**)

ii. Supervisory : Permanent _ Temporary _

iii. Skilled artisans : Permanent _ Temporary _

iv. Unskilled : Permanent _ Temporary _

1.7 Hours of working :

1.8 Is this first inspection for assessment?
If it is a re-inspection, details of earlier capability assessment(s) to be recorded and attached.

2.0 General Information--Technical

2.1 Description of different departments in the Factory/Works and function of each department.

2.1.1 The break-up of different work areas given below

Unit - I

Administrative Block :
Fabrication and assembly :
Machine Shop :
Store :
Laboratory :

Unit - II, Unit - III

Administrative Block :
Fabrication and assembly :
Machine Shop :
Store :
Laboratory :

2.1.2 A plan of the works, as described above, to be attached (**Annexure-B**).

- 2.2 Detailed description of Machinery and Plant in each department Unit wise (make and year of procurement/commissioning to be provided. For special type of equipment copy of pamphlets/write ups to be furnished so as to supplement the description).
The list of machinery & plant available to be attached (**Annexure-C**).
- 2.2.1 It was observed that (Comments of Assessing Officer(s), on machines and infrastructure)
- 2.3 Plans for future expansion, if any.....
- 2.4 Details of raw-materials held in stock (state whether imported/indigenous).
(list enclosed as **Annexure-D**)
- 2.5 Production Capacity.
- i. Per month :
- ii. Per year :
- 2.5.1 Whether Production capacity has been certified by external agencies? If yes, then details/certificates to be attached.
(Comments of Assessing Officer(s))
- 2.6 Enumerate Type of Stores/Items, which the firm is capable of manufacturing.
(Comments of Assessing Officer(s))
- 3.0 Design Capability**
- 3.1 Availability of Qualified Personnel.
(Comments of Assessing Officer(s))
- 3.2 Assessment of Expertise and Facilities.
(Comments of Assessing Officer(s))
- 4.0 Manufacturing Process**
- 4.1 In-house Manufacturing Facilities for the item(s) being assessed.
(Comments of Assessing Officer(s))
- 4.2 Details of manufacturing process relevant to the items for which assessment is carried out.
(Comments of Assessing Officer(s))
- 4.3 Important Items/processes Outsourced by the Vendors

(Comments of Assessing Officer(s))

- 4.4 What is the system of traceability of the components/sub-assemblies manufactured in-house and outsourced.
(Assessment team to comment on the traceability records maintained by the vendor for the range of machines manufactured, from the stage of drawings to dispatch of material/machine.)

5.0 Quality Assurance

- 5.1 Does the factory have an established Quality Assurance Programme. If yes, please enclose a copy of the write-up? If not, what plans are there if any for setting it up? (QAP attached as **Annexure-E**)

(Comments of Assessing Officer(s))

- 5.2 Details of Quality Assurance Organisation.
Names of key personnel, their qualifications, designations and position in overall management structure (Data in tabular form, explain with organisation chart, if necessary).

- 5.2.1 The QC organisation is headed by Shri, who is designated as, with responsibility for (Comments of Assessing Officer(s))

- 5.3 Enlist Quality Control Testing Facilities and Laboratory equipment available.

- 5.3.1 In-house facilities available for inspection and QC include the following:

- i
- ii
- iii

(list enclosed as **Annexure-F**)

- 5.4 Availability of gauges

- 5.4.1 The following important items of gauging and other related equipment are available: (**Annexure F**)

- 5.5 Calibration of Laboratory/test equipment/gauges, indicated in para 5.3 and 5.4 above:

- i. How is the calibration done? :
- ii. Frequency of calibration. :
- iii. System to ensure that calibration of above equipments :
does not fall overdue.
- iv. Action taken if such calibration has fallen overdue :

(Comments of Assessing Officer(s))

- 5.6 Source of procurement of raw-materials, important bought-outs, and steps taken to ensure their quality.

(Comments of Assessing Officer(s))

- 5.7 Details of inspection/checks done on material during various stages of the above manufacturing process.

(Comments of Assessing Officer(s))

- 5.8 Have acceptable values for the parameters inspected during above stage checks been laid down? If yes, the action taken if value of the parameter inspected does not meet the desired laid-down value.

(Comments of Assessing Officer(s))

- 5.9 System for documentation of the results of the above stage checks.

(Comments of Assessing Officer(s))

6.0 After-Sales Service

- 6.1 After-Sales Service Facilities Available at Works and Branch Offices.

- 6.2 What is the system of recording customer complaints and action taken there upon.
(Comments of Assessing Officer(s))

- 6.3 Assessment of Quality of Service Including Response times.

(Comments of Assessing Officer(s))

7.0 Past Performance

- 7.1 List of important customers of the firm (as relevant to the works for which assessment being done)

This is attached at **Annexure-G**.

- 7.2 Details of important orders executed/supplies in the past.

Also included in **Annexure-G**.

- 7.3 Details of Pending orders in hand (**Annexure-H**)

- 7.4 Whether another unit/factory of the firm is already approved by ASRW for supply of stores/components.
(Comments of Assessing Officer(s))

7.5 Performance of machines manufactured and supplied in the past to different consignees.
(Comments of Assessing Officer(s))

7.5.1 Machines at M/s. (Name of consignee)

7.5.2 Conclusions on performance (Attach performance certificates from at least 5 consignees where machines are working for more than one year since commissioning as **Annexure-I**).
(Comments of Assessing Officer(s))

8.0 Commercial Information

8.1 Copies of following documents obtained and attached as Annexures.

- i. Proof of Ownership. : **Annexure-J.**
- ii. Factory License, NSIC/ SSI : **Annexure-K.**
- iii. Latest Electricity Bill. : **Annexure-L.**
- iv. CA/CS certified copies of Balance sheets and Profit & Loss accounts : **Annexure-M**

8.2 Whether the firm is registered under Indian Factories Act.

(Comments of Assessing Officer(s))

8.3 Whether the firm comes under the scope of Industries (Development & Regulations) Act, 1951.

(Comments of Assessing Officer(s))

8.4 Income Tax Clearance Certificate Copy attached at **Annexure-N**.

9.0 Conclusions

(Comments of Assessing Officer(s))

10 Recommendations

(Should detail the findings in line with the scope of the assessment)

(Signatures of the Assessing Officer(s)
Name & Designation

Place:

Date:

ANNEXURE - A
LIST OF MANAGERIAL STAFF
AS ON-----

S.No.	Name	Designation	Qualification	Working since
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ANNEXURE -C
LIST OF MACHINERY AND PLANT

S.No.	Description of Items	Make	Qty.	Year of procurement
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ANNEXURE - F
LIST OF QC EQUIPMENT, MEASURING EQUIPMENT AND GAUGES

S.No.	Description	Range Least count where applicable	Qty.	Year of procurement
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ANNEXURE - G
LIST OF IMPORATANT CUSTOMER & ORDERS EXECUTED W.E.F.....(DATE)

S.No.	Purchaser Order No.	Description/ value	Delivery dt.	Date recd.	Date Comm.	REMARKS
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ANNEXURE - H
LIST OF PENDING ORDERS AS ON----- (DATE)

S.No.	Purchaser	Order No. and date	Value
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ANNEXURE-I

QUALITY ASSURANCE PLAN

MACHINE DESCRIPTION:

Category	S. No	Component / Process	Sample Size	Type Of Check	Quality record	TYPE OF CHECK	REMARKS
Bought Out Raw Material		Steels	1 Sample / Size	Chemical & Mech.	TC & INV.	CHP	
Bought Out Components		Bearings	100%	Visual	Inv	CHP	
		Electric Motors	100%	Review of TC	TC & INV	V	
		Hydraulic Pumps & Elements	100%	Review of TC	TC & INV	V	
		Rubber Seals, O Rings & Seals	100%	Visual	TC & INV	V	
		Controllers	100%	Review of TC	TC & INV	V	
		Ball Screw	100%	Visual	IIR	V	
Bought out sub assemblies		Weld joints					
		Load Bearings	100 %	RT	IR	CHP	
		Others	5 %	DPT	IIR	V	
		Hardness and	100%	Hardness	IIR	V	
In process Inspection stage							
		Heat Treatment	100%	Review of Inv.	IIR	V	
		Castings	100%	Visual	IIR	V	
		Spindles	100%		IIR	V	
		surface finish of components	Random	Surface	IIR	V	
		Noise level	100 %	Sound	IIR	CHP	
		Temperature rise	100 %	Measurement	IIR	V	
		Structures Geometry alignment, Guideways	100%	Relevant ISO/DIN/IS/JIS standard	IR	CHP	

INV – Invoice TC – Test Certificate

V – Verification CHP – Customer Hold Point

IIR – Internal Inspection Report IR – Inspection Report

Annexure-A1 (Certificate of Performance)

Important Note: i) The certificate shall not be older than one year from the original date of closing of tender. The performance certificate issued after original date of closing of tender (in cases where tender closing date has been extended) are also acceptable however the machine must have completed one year of satisfactory working after date of commissioning as on original date of closing of tender.

ii) Performance certificate shall contain following information.

Letter Head of issuing authority

(See Important Note above) Date of issuance:

CWM/ASRW Or
TO WHOMSOEVER IT MAY CONCERN

SN	Head	Details
1	Name of the Supplier	
2	Name of End User	
3	Name of the machine/description of machine	
4	Purchase/Supply Order Number	
5	Date of Purchase/Supply Order	
6	Date of Supply of machine(s)	
7	Quantity supplied	
8	Manufacturer's Serial Number(s) of machine(s) or Plant/system etc. number (or some mode to identify the machine) (Optional)	
9	Date of Commissioning (Give individual date for each machine)	
10	Performance of the machine	Satisfactory/unsatisfactory
11	Any other information which user intends to append, for example a) aspects bringing out similar nature of machine, b) major/leading parameters of the machine.	

Name & Designation
Contact Number
Signature of the issuing authority
Email id
(Seal of the Organisation)



SPECIAL CONDITIONS

The following conditions are applicable in addition to those contained in Bid Documents Part-I & Bid Document Part-II (technical specification/requirement). In case, any of the conditions mentioned hereunder are contrary to those mentioned elsewhere, conditions mentioned in this document (Special conditions of Tender) will supersede the corresponding conditions given in Bid Documents Part-I & Bid Documents Part-II.

- 1 The tenderer shall provide satisfactory evidence, acceptable to the purchaser to show that he is a regular manufacturer and has adequate machine and manufacturing capacity and a "Quality Assurance Programm". The information as per Annexure-2 under Bid Document Part-I may please be furnished. The manufacturer must have a valid ISO 9001:2015 certificate (or latest) on the original date of closing of bid and a copy of same should be submitted along with the bid. Manufacturing of Hydraulic Press shall be in the scope of ISO certificate.
- 2 The tenderer must have manufactured & supplied at least 02 nos. of same/similar machines in last 05 years to be reckoned from the original date of closing of bid. The list of past supplies made in 05 years of the same/similar machine asked for shall be attached along with the offer specifying Purchaser's name and address, phone no. and e-mail of contract person, purchase order number and date, quantity supplied, date of supply and commissioning. Copy of such purchase order(s) mentioned in the list of past supplies indicating the parameter/specification shall also be attached with the offer to establish equivalence/similarity aspect of machine as mentioned in para 3. below.
- 3 For the purpose of similarity, similar machine required under clause 2 means

Schedule	Type
Schedule-1A	Hydraulic Press Capacity 200T or More
- 4 Performance certificate of at least 1 no. of such machines for each schedule which is counted for the purpose of meeting qualifying criteria, supplied in the last Five years (to be reckoned from the original date of closing of bid) and working satisfactorily for at least one year shall be enclosed with clear signature and address of the user in whose premises the machine is installed and commissioned. The certificate shall not be older than one year from the original date of closing of bid.
- 5 All necessary information/documents required for establishing reference requirement as per para 2 to 4 should be submitted by the bidder along with the original offer itself. No clarification/correspondence will be sought/entertained in this regard. In case no information or incomplete information is furnished by the bidder, their offer will be summarily rejected.


WMY/ASRW

 (SSE/Elec.)  (SSE/BSS)

High Capacity Draft Gear RF-361

1. Wedge 30°	STL. Forging Carburized	555-683 BHN	1
2. Shoes 30°	--do-- --do--	444-495 BHN	3
3. Top Follower	Drop Forged Heat Treated		1
4. Elastomer units (Rubber pads)	Class RF-8		6
5. Housing (cylinder)	Cast Steel Quenched		1
6. Rear Wall plate	ASTM A572 Grade 50		1
7. Bore Inserts	Non Ferrous		6
No. Item	Matl. Specn.	Hardness No.	Qty. set

DRAFT GEAR ASSEMBLY (SKETCH - 1)

