

4978072/2026/O/o AWM/LMS/DMW/PTA **PATIALA LOCOMOTIVE WORKS**  
**PATIALA**

DOC. NO. PLW/HITACHI-MF/Stripping, REV. -01		DATE OF ISSUE: 25/04/2026
DESCRIPTION	STRIPPED STATOR OF HITACHI HS-15250A TM, ALONG WITH CUTTING OF LUGS AND RAPAIR OF PE & CE SIDE. SCOPE OF SUPPLY AS PER PLW DOC. NO. PLW/HITACHI MF/ Stripping, REV.-01	
SPEC. No.	.....	
UNIT : Nos.		QPP: 01 No.
<p><b>1.0 Preamble:</b> This document covers the scope of supply including work to be carried out on Unstripped Stator of Hitachi Traction Motor Type HS-15250A supplied by PLW along with items mentioned in Ann-Y.</p> <p><b>2.0 Infrastructure required:</b></p> <p>The bidder must possess following infrastructure, required for stripping of Stator of Hitachi TM-15250A:</p> <p>2.1 DA-O2 Plant for de-brazing of joints.</p> <p>2.2 Radial Drill Machine</p> <p>2.3 MIG Welding set</p> <p>2.4 Covered shed of adequate size and EOT crane of capacity 2 Ton minimum.</p> <p><b>3.0 Quality Assurance:</b></p> <p>The firm must have a valid ISO: 9001 certification covering relevant work activities.</p> <p><b>4.0 SCOPE OF SUPPLY:</b></p>		
<b>S No.</b>	<b>Description of Work</b>	
<b>4.1</b>	Firm shall be responsible for lifting of unstripped Hitachi Stator from PLW after thorough visual inspection to ensure healthiness of the stator for stripping work. Prior to delivery of Stators from PLW, the quantity of shorted/burnt/damaged poles, leads, strips and all other material assembled in the stator, to be recorded in check list provided at "Ann-Y" of this document (To be signed jointly by the firm's and PLW's representative)	
<b>4.2</b>	Ready Stator frames shall be dispatched to PLW suitably packed to avoid any damage to the Stator frames during transit. Firm shall be held responsible for any damage during transit from PLW to firm's premises, handling at firm's premises and returning back.	
<b>4.3</b>	All dismantled components are required to be returned by the supplier along with the Stripped stator. List of these components is provided as <b>Ann-Y</b> of this document.	
<b>4.4</b>	<p><b>STRIPPING WORK</b></p> <p>4.4.1 Removal of tapes from Main Poles and Cable joints (05 strips + 02 leads).</p> <p>4.4.2 Removal of tapes from Inter Poles and Cable joints (07 leads + 01 neutral lead).</p> <p>4.4.3 Compound removal from MP/CP bolts.</p> <p>4.4.4. De-brazing of all joints carefully, not to damage any of the coils during the process.</p>	

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	<p>4.4.5. Dismounting of Main Poles from Stator (06 nos. poles &amp; 18 nos. M24 bolts).</p> <p>4.4.6. Dismounting of Inter Poles and Liner strips from Stator (06 nos. poles &amp; 18 Nos. M20 bolts).</p> <p>4.4.7. 04 nos. bearing removal from BHHR.</p> <p>4.4.8. Cover plate removal, 02 nos.</p> <p>4.4.9. Insulator removal, 04 nos.</p> <p>4.4.10. Speedometer removal, 01 no (if attached).</p> <p>4.4.11. Removal of 04 nos. Connection Cleat/Bracket with M20 bolts (where applicable).</p> <p>4.4.12. Cleaning of all stripped components along with stator, with suitable cleaner.</p> <p>4.4.13. All 06 nos. main pole &amp; 06 nos. inter pole and its terminal and strip to be cleaned, grinded and varnished as per spec no. A0209 or RDSO/2008/EL/SPEC/0081(Rev-0).</p> <p>4.4.14. Connecting Cable to be repaired with provision of fibre glass tape as per spec. 4TMS.095.016 Rev-1 or 4/DCW/SPEC/TM-042 and silicon rubber tape as per spec. no. 10W 701-128</p>
<b>4.5</b>	<p><b>MACHINING WORK</b></p> <p>Enlarging of various holes by drilling:</p> <p>4.5.1 M20 -06 holes to be enlarged with 1" drill.</p> <p>4.5.2 M24 -06 holes to be enlarged with 1-1/16" drill.</p> <p>4.5.3 M36 -08 holes to be enlarged with 1-7/8" drill.</p> <p>4.5.4 10mm dia. -04 holes to be enlarged with ¾" drill.</p>
<b>4.6</b>	<p><b>FITTING WORK</b></p> <p>4.6.1. MS Plug IS 2062, Gr-E 250A pressing in above enlarged holes having sizes of 1", 1-1/16", 1-7/8" and ¾" respectively.</p> <p>4.6.2. Preparation of surface for welding after cutting of various lugs.</p>
<b>4.7</b>	<p><b>CUTTING AND WELDING WORK</b></p> <p>4.7.1 Cutting of various lugs:</p> <p>(i) Top and bottom lugs (02 nos).</p> <p>(ii) Lifting lugs (02 nos).</p> <p>(iii) Top nose lug (01 no).</p> <p>(iv) Bottom nose lug (01 no).</p> <p>4.7.2. Welding of PE main face with copper coated CO2 welding wire of dia. 1.2 mm (MIG welding) and weld bead of appx. 03 mm thickness.</p> <p>4.7.3. Welding of PE &amp; CE bore with copper coated CO2 welding wire of dia. 1.2 mm (MIG welding) and weld bead of appx. 03 mm thickness.</p> <p>4.7.4. All pressed plugs to be welded up to face.</p>
<b>4.8</b>	<p>Stator frame to be packed in wooden box before returning to PLW. Items indicated in Ann-Y of this document, to be returned in packed condition as mentioned in the Note at Ann-Y.</p>
<b>4.9</b>	<p>During subsequent machining of Stator Frames in PLW, if any portion is observed with incomplete weld penetration or other welding defects, then firm shall have to attend it in PLW at its own cost.</p>

The special terms and condition of contract will be as per Ann-X attached with this document.

**SPECIAL CONDITIONS OF CONTRACT**  
**Ref: DOC. No. PLW/HITACHI-MF/Stripping, REV. -1**

1.	<p><b>Security against Material:</b></p> <p>PLW shall take necessary security deposit for the safe custody and proper handling of material issued to successful tenderers. Security amount shall be calculated @ Rs. 6,46,779/-per Hitachi TM Stator Frame. This security deposit is normally accepted in form of bank guarantee or DD. However, at the discretion of purchaser, such security can also be taken in the form of indemnity bond with comprehensive insurance cover at Rs. Rs. 6,46,779/- per Hitachi TM stator, from regular order supplier with proven past credentials in similar contracts with PLW.</p>
2.	<p><b>Transportation and Insurance:</b></p> <p>The firm shall collect at its own expenses the Hitachi TM stator from PLW Patiala and will return it after satisfactory completion of work. Cost of to and fro transportation, packing, transit insurance and other incidental charges etc. shall be borne by the firm and supplier shall be fully responsible for this activity.</p>
3.	<p><b>Inspection:</b></p> <p>Final Inspection of the unstrapped Hitachi TM Stators will be conducted by Inspection Agency authorized by PLW at firm's premises. However, firm to get two samples approved from PLW before starting bulk supplies. PLW reserves the right to Inspect the firm premises/works for progress reviews and stage inspection of the wok during the currency of contract, for which the supplier shall make the relevant arrangement at his work.</p>
4.	<p><b>Warranty:</b></p> <p>Warranty period of repaired Hitachi TM stator frame shall be 12 months from date of receipt. Supplier shall warrant that repaired Hitachi TM stator will be free from all defects and faults in material, workmanship and shall be of the highest grade and consistent with the established and generally accepted standards for material of all type ordered and in full conformity with the contract specification, drawings or samples, if any.</p> <p>The firm's liability in respect of any complaint shall be to rectify the Hitachi TM stator free of cost, to the extent that such defects are brought to the firms notice within three months from date of expiry of warranty period. The firm shall rectify the Hitachi TM stator free of cost either in PLW or at ultimate destination as per purchaser's option. In case of failure to repair by firm, supplier shall pay to the purchaser cost of old Hitachi TM Stator plus cost of repairing Hitachi TM stator as per purchase order price and any other expenditure and damages as may arise by reason of beach of condition there in specified. All repairs that purchaser shall call upon the supplier to deliver or perform under this warranty shall delivered and performed by the supplier promptly and satisfactorily, within three months.</p> <p>Firm shall have to submit warrantee guarantee @10% of order value in form of Bank guarantee or DD as a guarantee for warrantee obligation. The Bank guarantee shall be valid for at least three month in excess of warrantee period and shall be executed on non judicial stamp paper of proper value duly notarized by notary Public.</p>

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	Submission of performance guarantee can be waived at discretion of purchaser for regular order supplier with proven past credentials in similar contracts with PLW.
<b>5.</b>	<b>Condition assessment before collection:</b>  Firm should take delivery of unstripped old Hitachi TM stator from PLW, duly satisfying itself of condition of old TM stator being in conformity with tendered specification. However, during the stripping stage, in case the firm finds any of the old TM stator unacceptable for repair/stripping, it should be immediately brought to the notice of PLW and jointly verified by the firm representative and PLW nominated official. If accepted by PLW, the firm will return the faulty TM stator to PLW free of cost in its existing state and firm will not be paid any charges for the same. In case of Hitachi TM stator being rendered unserviceable due to the firm's fault, firm shall be liable for paying Rs. 6,46,779/- for each such TM stator rendered unserviceable and shall also return such unserviceable TM stator.
<b>6.</b>	<b>LD for delays:</b> Delay in lifting of old Hitachi TM stator beyond 15 days from the date of intimation by consignee or delay in return of rehabilitated Hitachi TM stator beyond one month from date of issue of old Hitachi TM stator by consignee will attract 0.5% L.D. per week or part thereof.
<b>7.</b>	<b>Return of material:</b>  Firm shall responsible for returning of stripped Hitachi HS-15250A stators along with all the material to PLW including waste material as per Ann-Y.
<b>8.</b>	<b>Capacity:</b>  Firm shall have capacity to strip and other work (as per specification DOC NO. <b>PLW/HITACHI-MF/Stripping, REV. -01</b> ) at least 30 Stators/month.

CHANDR  
A MOHAN

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CHANDRA MOHAN  
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**AWM/LMS-II**

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SHARMA

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by ANIL KUMAR  
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**DY.CME/LMS**

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**SSE/LMS (HS)**

**Ref.DOC.NO.:** PLW/HITACHI-MF/Stripping, REV.- 01

**TITLE:** Items issued with unstripped stator frame for stripping to vendors and items received back from vendors with stripped stator frames

**Hitachi Stator Frame Sr. No./Shed:** \_\_\_\_\_

**Date:** \_ / \_ /20

Sr. No.	Item Description	Dispatch Qty ( in Nos.)	Received Qty ( in Nos.)	Remarks
1	Main Poles (06 nos.) + Liner (if any)			
2	Strips (05 nos.)			
3	Leads (02 nos.)			
4	Inter Poles (06 nos.) with Liner (06			
5	Leads (07 nos.)			
6	Neutral leads (01 no)			
7	Connection cleat (04 nos.)			
8	Main Pole Bolts, M24 (18 nos.)			
9	Main Pole Washer, M24 (18 nos.)			
10	Inter Pole Bolts, M20 (18 nos.)			
11	Inter Pole Washer, M20 (18 nos.)			
12	Bearing (BHHR) (04 nos.)			
13	Cover Plate (02 nos.)			
14	M12 Bolts for Cover Plate with washers (16+16 nos.)			
15	Insulators (04 nos.)			
16	Speedometer (01 no) if attached			
17	Bolts (M10) with washer for speedometer (03+03 nos.)			
18	M12 Bolts (For TM cleat) (08 nos.)			
19	M18 Bolts (02 nos.)			
20	Spl. Bolts (Assembly Sheet) M20 (01 no)			
21	Cutting Lugs (06 nos.)			

**Sign of Shop Rep.** \_\_\_\_\_

**Sign of Firm Rep.** \_\_\_\_\_

**Sign of Shop Officer.** \_\_\_\_\_

**Note:-**

Items at Sr. no. 1 to 6, to be packed in one wooden box, whereas items at Sr. no. 7 to 21 to be packed in another wooden box, in a manner that these are not damaged during handling & transit. Packing slip must be pasted on each box indicating description & qty. The supplier has to put his identification on the wooden case, comprising of Firm's name, PO No. and PO date.