**Bid No: 6300035635**

**SCOPE OF WORK**

Axle Box Housing Machining for MEMU TC CAR.

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| Axle Box Housing (Rough Machined) | Axle Box Housing (Finish Machined) |
| Dwg. No. CC02120. | Dwg No. CC02101. |

* Re-bore 279.5 Dia. thru, Surface Bore finish 290 H11 Dia X 62 mmdeep with 6R and 3R, Chamfer 3X45 Deg and Form “V” Grooves 1mm deep X 3 mm from edge as shown in Section A-A.
* Face to maintain height 216 ±0.1 mm as shown in Section D-D
* Step bore finish 290H X 62 deep with 6R and 3R Bearing Bore.
* BORE 120DIA (±1 mm) Through & Maintain dimension 285±0.5 mm from center line and Face Spring seats area to 254 Dia (+0.5/- 0mm) X 3R Radius X 12 mm deep at both sides as shown in Section A-A.
* Drill 21.5 mm Dia H-12 Through Holes at four places on 324 PCD as shown in Section C-C.
* Mill crown maintaining dimension 160 +3/-0 mm
* Deburr Holes & Milled portion.
* Grind finish the main bearing bore to maintain 280H7 (+0.052/+0.030 mm)
* Apply rust preventive oil on Machined Surface, Punch Serial number, Year and Month.
* All machining dimensions to be maintained as per Axle Box Housing (Finish Machined) Drawing. CC02101 with latest alteration.

Note:

* Axle Box Housing shall meet all requirements of Spec. RDSO/2007/CG-08.
* Axle box Housing shall be protected as per RCF Procedure No. WI-100140.
* All other Specifications/Instructions as per Drawing CC02101.

**SCOPE OF SUPPLY OF MATERIALS:**

**1. BEML Scope:**

BEML shall provide only Axle Box Housing (Rough Machined) and Technical Documents below:

1. 1. Inspection Check Sheets.
2. 2. Drawings (CC02120&CC02101).

BEML Shall assist in carrying out machining of first 3-4 Nos of Axle boxes and provide necessary on job knowledge transfer pertaining to machining of axle box housing.

**Machine Centers:**

* Layout Bench-1 Nos.
* Alfing Boring Machine-2 Nos.
* VTL (Vertical Turret Lathe)-3 Nos.
* Internal Grinding Machine-1 Nos.
* Milling Machine-1 Nos.
* Radial Drilling Machine-1 Nos.
* Jigs/Fixtures.
* Hardwares.

**Consumables:** Coolants, Machine Consumables, Tooling, Cotton waste etc.

**2. Vendor Scope:** Skilled manpower and PPE's.

**General Notes to Comply**

1. 1. Proper Fixture should be used for clamping & ensure proper seating, bed during Machining operation.
2. 2. Before taking up machining activity, Self-Inspect the M/s BEML supplied component for damages, dents, distortions etc in detail and inform for any defects.
3. 3. In case of any defects or blow holes observed during Machining, same has to be informed to BEML.
4. 4. First finish machined axle box housing to be offered for BEML inspection, series production can be taken up on acceptance of first sample clearance only.
5. 5. Ensure components supplied are stored properly and damages due to poor & improper storage, workmanship etc. should be the responsibility of Vendor being carried out.
6. 6. Scraps to be started at designated place.

**Inspection & Clearance:**

1. 1. Any minor scope changes/Modifications if any, to be taken up by vendor.
2. 2. Offer the Machined Axle Box Housing to BEML inspection. Associate with BEML quality team for final inspection & clearance from end user and should carry out any modifications suggested by inspection/quality team.

3. The Vendor should maintain & provide Reports & Check sheets to BEML.