

48201PA001

INSTALLATION OF PLATFORM, MUDGUARD ASSY AND CLEARANCE

1. SCOPE OF WORK FOR INSTALLATION OF PLATFORM AND MUDGUARD ASSY OF BEML TATRA RR 6X6 VEHICLE AND CLEARANCE BY VENDOR.

- a) Installation of Platform assembly and Mud guard assembly of BEML Tatra RR 6x6 on chassis as per scope given in the SI No 4. of this document.
- b) Offering of Platform Sub assy / Aggregates to BEML Quality Department & CQA and obtain clearance as per the scope given in SI No 5 of this document.

2. GENERAL CONDITIONS.

- a) No freight is involved as the firm has to execute the work at BEML KGF Complex.
- b) STATUTORY REQUIREMENT: Workmen compensation, Insurance, ESI, PF etc., if any should be fully covered for workmen assigned to carry out the job. All applicable safety appliances should be used by the workmen on duty and the same should be provided by the Vendor.
- c) BEML Ltd has the right to increase or decrease the order quantity at the same terms and conditions.
- d) Delivery schedule: Platform Installation, Mud guard installation should be completed as per BEML schedule / requirements.
- e) Drawings: The drawings given to you are the property of BEML and shall be treated as "CONFIDENTIAL DOCUMENTS". The contents of the drawings shall not be parted to any outside firms, either in part or in full. In case these Drawings are used for any other purpose other than for which it is intended, vendors are liable for punitive action as per BEML rules.
- f) Any loss of items or damages caused by vendor to the parts / equipment issued from BEML, will be subjected to deduction of equivalent cost from the vendor.

3. TERMS AND CONDITIONS

MATERIALS AND FACILITIES PROVIDED BY BEML LTD

The following materials are provided by BEML at the time of carrying out of the job.

- a) Platform and Installation parts.
- b) Crane facility required for positioning and installation of platform.
- c) Electrical power for carrying out the job.
- d) Place for keeping machines, tools and accessories.
- e) Welding machine and welding rod / coil.
- f) Red oxide and green / black paint for any touch up.

MANPOWER AND FACILITY TO BE ORGANISED BY THE VENDOR.

The following manpower and facilities are to be organized by the vendor at their cost.

- a) Necessary tools like Hand tools, Pneumatic Gun, Spanners, Mallet / Hammer, slings, D-Shackles, Screw / Hydraulic jacks, clamps etc for installation of the platform.
- b) Required number of Skilled manpower, Supervisor to be positioned to execute the assigned work catering to work in 2 shifts and 3rd shift on the basis of requirement.
- c) Accommodation & Transportation required for workmen.

4. SCOPE OF WORK FOR INSTALLATION OF PLATFORM ASSEMBLY (510BD01007) AND MUDGUARD ASSEMBLY OF BEML TATRA RR 6x6 ON CHASSIS.

I. Platform assembly (Refer Fig No: 1) – Qty per equipment 1.

- a) Position the platform assembly on the vehicle chassis using crane locating the dowels provided on the frame while ensuring no fouling of parts at front side of platform.
Check for matching of platform locating holes with dowels on chassis. If Locating holes of platform are not matching dowel on frame, lift the platform, remove the dowel by grinding the tack weld, set the dowel with platform & full weld the dowel.
Touch up paint on welded portion with red oxide and then with black paint.
- b) Position 8 Nos Platform pad (SI 1&2) on to stools of Platform & secure with tape.
Position the platform on chassis with crane.
Fasten the platform on to chassis using 8 Nos U-bolt (SI No 3), 8 Nos Yoke pad (SI No 4), 16 nos M16 Nuts (SI no 5). Apply torque & tighten check nuts – 16 Nos of M16 Nuts.

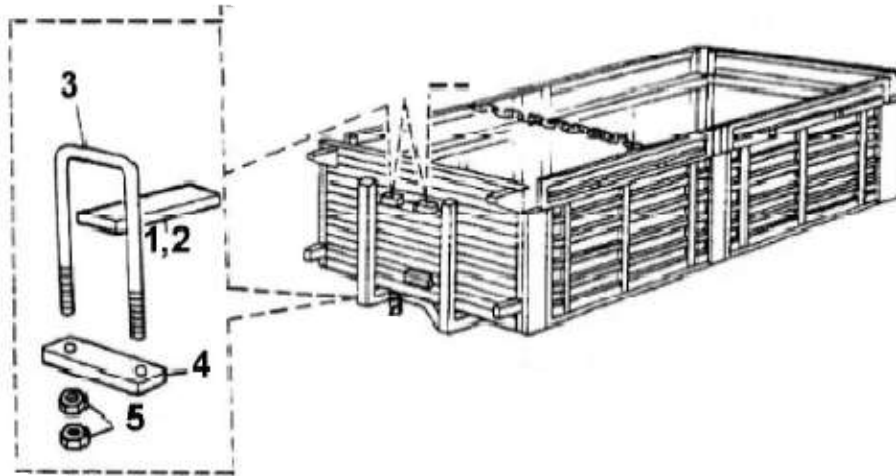


FIG – 1

- c) Fitment of 1No Spare wheel / Tyre (SI No 2 - in Fig No 2) using 3 Nos M20 Nuts on the bracket provided at Front board of platform.
- d) Fitment of Jib crane (SI No 1 in Fig No 2) using 6 nos M16x30 screw with washer.

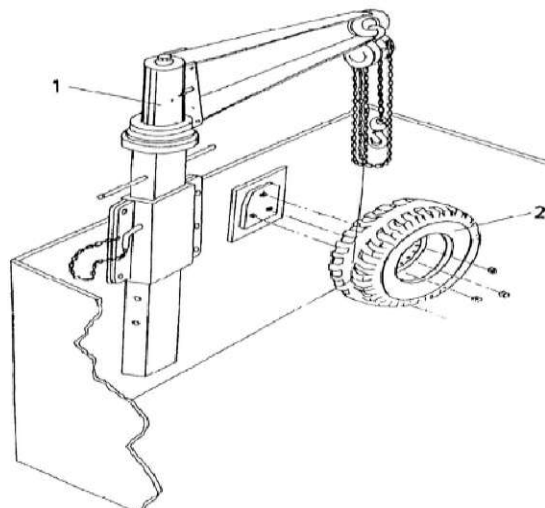
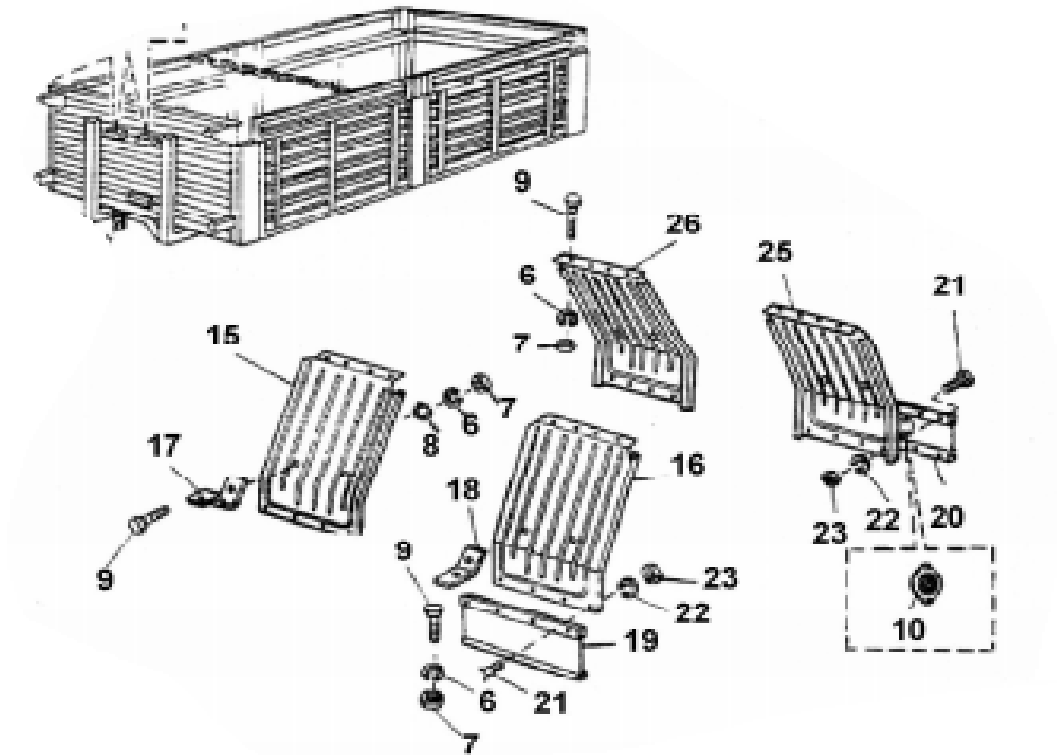


FIG – 2

II. FITMENT OF MUDGUARDS, MUDDLAPS – Refer Fig No 3.

- a. Install mud flaps Qty 4 Nos (SI No 19 & 20) on to Mud guards 4 Nos (SI No 15,16,25,26), using M6x16 Hex head screw, Spring washer B6 & Hex nut M6 Qty: 20 Nos each.
- b. Mount the Mud Guards with flap Qty 4 nos on to the platform assy and mudguard pipe with brackets (SI no 17, 18) using Hex head screw M8x20 (SI no 9),spring washer 8 (SI 6), Nut M8 (SI 7) Qty 24Nos each.
- c. Full weld the mudguard pipes if it is in Tack Weld condition by ensuring no fouling of Mudguards with adjacent assys. Paint touch the welded area with Red oxide & black paint.



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III. STAGE INSPECTION BY BEML INSTEPECTION DEPARTMENT

- d. All Assemblies/ Sub-assemblies will be certified by BEML quality inspector after assembly (at sub assembly& assembly level).
- e. BEML reserves the right to ask the vendor to reverse the assembly activity and carry out the same operation afresh if the subject sub assembly was done wrongly. In that case the vendor cannot claim any charges for subsequent disassembly and assemblies.
- f. Any rework carried out based on inspection feedback should be as per rework procedure mutually agreed between vendor, BEML Quality and BEML R&D.

5. SCOPE OF WORK FOR OFFERING OF PLATFORM SUB ASSY / AGGREGATES TO BEML Inspection & CQA, OBTAIN CLEARANCE.

Following sub-assemblies and aggregates are to be checked for proper fitment / functioning by the vendor first. Minor adjustment or rework to be carried out for any misalignment or malfunctioning of the same.

After ensuring proper functioning, same to be offered to BEML Inspection first and then to CQA during their inspection and clearance to be obtained.

- a. Cover assembly 2 Nos (Winch and gear box inspection cover): SI No 59 in Fig 4.
Inspection requires Lifting of Cover plate after removal of 4 Nos M12x45 bolts (SI No 58).
Fastening back after inspection.

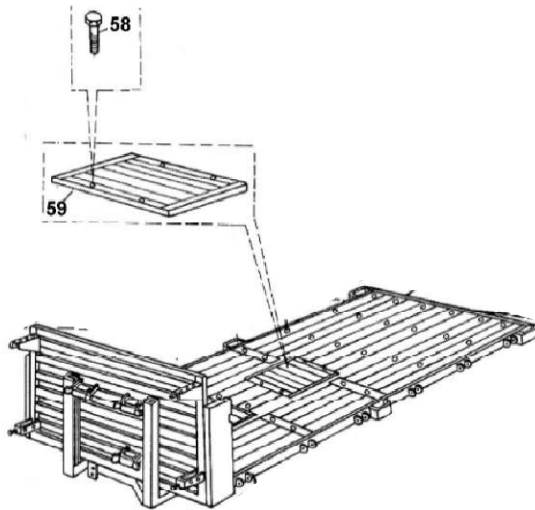


FIG - 4

- b. Functioning of Latches of Side & Rear boards. Inspection requires checking proper locking and unlocking of side board latches. Qty 10Nos. As shown in photo below.



FIG - 5



FIG - 6

- c. Side board- 4Nos and Rear boards -1No of Platform (swinging board –assisted with torsion spring at bottom): Ref Fig No: 5 above.

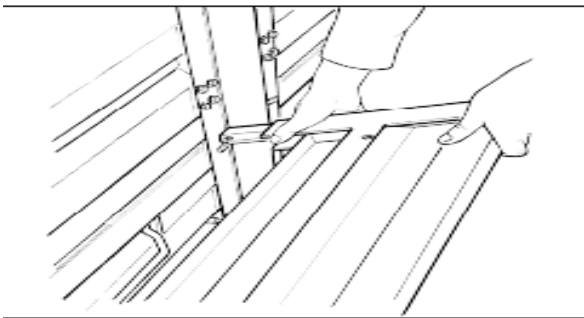
Inspection requires Swing opening of side boards after Un-latching and checking for Spring action.

Latching of Side boards -4 Nos at 180° position (horizontal) using M16 x 25 bolt provided on the stay bracket provided at bottom side of platform.

- d. Functioning of foldable benches with legs Qty 4 Nos(fitted in side boards),Refer Fig No: 6

Inspection requires removal 4 Nos of benches from Side boards by removing Lock screw 8 Nos and fitment of the same inside platform as shown in Fig 7 by releasing the legs attached to it. The same to be fitted back after inspection.

Vendor should check and ensure for proper fitment of benches and carryout any minor corrections or rework as required before offering to BEML Inspection and CQA.



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- e. Jib Crane (SI No 1 in Fig No: 2). Inspection requires lifting / lowering of a Spare Tyre using jib crane.

- f. Hoop Structure, Hoop Rods (Refer Fig No -8.)

Platform comes stored with 3 Nos Hoop structure and 28 pieces of Hoop rod at front side of platform in the holding bracket. Refer Fig- 8.

Inspection requires removing Hoop structure (SI 3&4) in Fig 10 by loosening holding bolt and fitment of the same in platform as shown in Fig 10 using 4 Nos Hex bolt M12x65 & Hoop pin 2 Nos (SI No 15,16).

Hoop rods (SI 6,7,8,9,10,11 in Fig-10)to be removed from storage (Fig 8) and to be screwed together as shown in Fig 10 and mounted on Hoop structure (by press fitment).After assembly it will look like in Fig -9.

After inspection same to be fitted / stored back as in earlier condition.

- g. Ladder and platform chain (SI 12 & 14) in Fig 10.
Inspection required Chain (4 Nos) to be fitted and shown and ladder to be opened and shown.

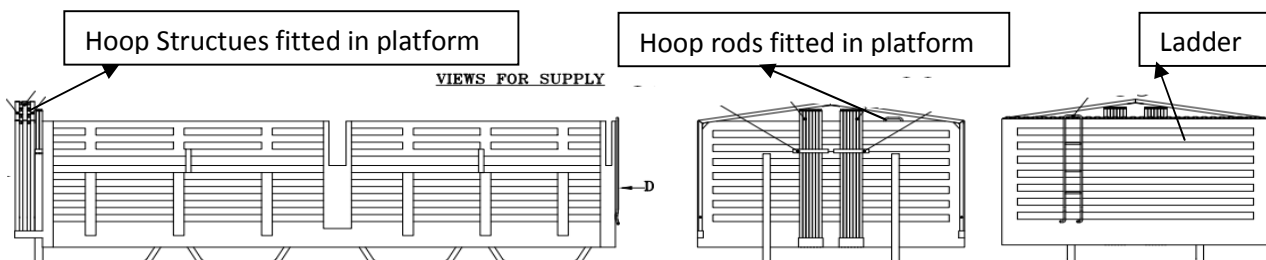


FIG – 8

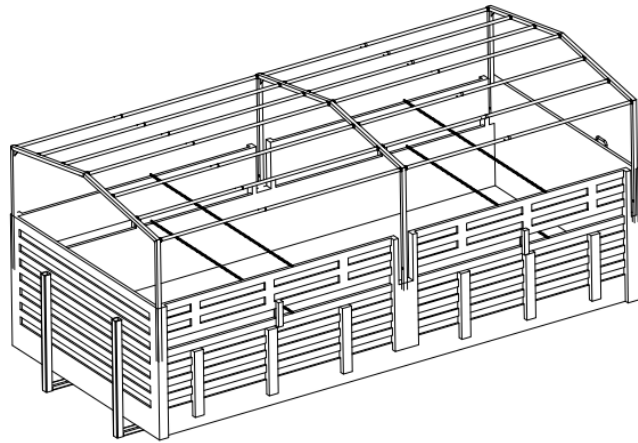


FIG - 9

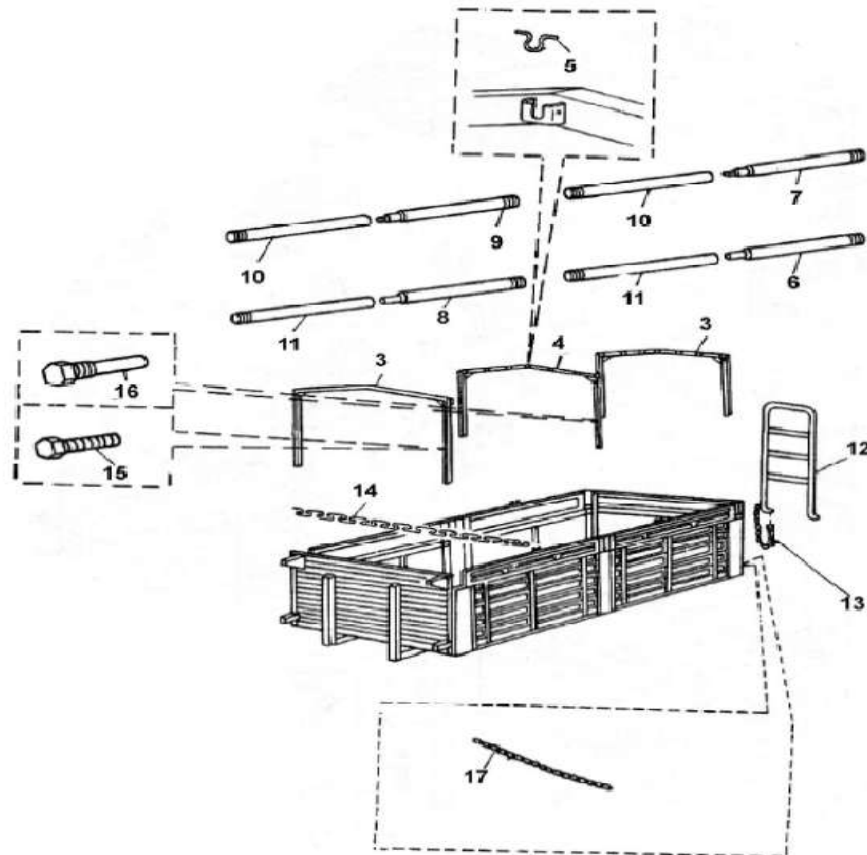


FIG - 10

Production Rate:

- 1.** One 6x6 equipment requires one platform assy and Clearance.
- 2.** Vendor should ensure that he assembles and clears the platform at the rate of 2 equipments per day.

Indicative Man Power apart from One Supervisor:

- **1st Shift – 4 Fitters**
- **2nd Shift – 4 Fitters**