

ANNEXURE FOR TIE ROD & END PLATE ASSEMBLY

Item 1: Tie rod assembly

Each tie rod assembly comprises the following

Sl No.	Description	Document Req. for approval
1	Stain less steel Tie rod \varnothing 12 X 270 Long to be finished as per drg.	Material PO
2	Machined Washer as per drawing. Material 40dia x 14.5 Lg Brt Steel Bar cold drawn	
3	Hex Nut M12 Class 8.8 DIN 934	
4	Stain less Steel washer M12	
5	PTFE Tube \varnothing 15 X 1 thk X 150 Long	

Item 2: End plate assembly as per drawing loaded to 7 tons using fixtures

Each assembly comprising following components

Sl No.	Description	Document Req. for approval
1	Stain less steel (Non-magnetic) End Plate 18X200X200 as per drawing	Material PO
2	Disk spring Chrome Vanadium spring steel 50 Cr V4 with phosphated & Oiled finish as per drawing Spring force at 75%, Deflection 138000 \pm 6900N	Material PO
3	Guide assy as per the drawing	Material PO
4	Tester as per the drawing	
5	Zinc plated machined washer M21 DIN 125	
6	Zinc plated M20 Hex Nut Class 8.8 DIN 934	
7	Guide as per drawing	Material PO

NOTES TO THE SUPPLIER :

- Various specifications have been called for the material to be used in different components, the supplier should provide either material test certificate/ purchase copies/ compliance certificates for the same. Material is liable for rejection at any stage of testing if not found suitable.

- Various standards are called in the drawings for processes & manufacturing. Compliance certificates/ test certificates as applicable shall be submitted by the supplier.
- The above items will be inspected at supplier's works prior to dispatch. Ten day advance intimation shall be given to BHEL for deputation of representative.
- Two copies of test certificates shall be furnished along with the consignment