

ANNEXURE TO TENDER NO. DPS/MRPU/4/1/1741

S. N.	Particulars	Specifications	Specifications to be confirmed by the vendor and deviation if any, to be marked																											
1.	Application	The subject crane is meant for handling radioactive packages & casks. The crane will be put to use for continuous duty with CT, LT and Hoist movements, which may occur simultaneously. The environment will be open out door, coastal area having salty atmosphere and ambient temperature going up to 45 deg C. Hoist shall be equipped with load measuring device with display at local control panel. Load cell rating shall be at least 25% higher than rated capacity of the crane.																												
2.	Scope of Supply	<p>a) Detailed design, submission of design calculations, drawings & manufacture of 20 Ton main & 5 Ton auxiliary capacity gantry girder crane of 20,050 mm span with double girder, Class M7 for all mechanism and Class A5 as a whole confirming to IS-3177/ 1999 & IS - 807/ 2006 and as per Tender Specification.</p> <p>b) Complete assembly and testing before dispatch.</p> <p>c) Supply in modules/ sub-assemblies, unloading of all crane parts & materials at the erection site i.e. Centralised Waste Management Facility, BARCF at Kalpakkam, Kancheepuram Tamilnadu, PIN: 603102.</p> <p>d) Cable drag chain system for CT travel with accessories.</p> <p>e) Erection /installation, wiring /cabling for the crane at site, Commissioning, Performance Prove-Out and load testing.</p> <p>f) Submission of three copies of all relevant documents including operating & service manual.</p> <p>g) Performance Guarantee for 12 months, from the date of commissioning.</p>																												
2.1	Spares to be Supplied along with the Crane	<p>Supply of following spares for the crane is also included in supplier's scope:-</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">S. N.</th> <th style="text-align: center;">Description</th> <th style="text-align: center;">Quantity</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td>LT wheel Bearing</td> <td style="text-align: center;">1 Set</td> </tr> <tr> <td style="text-align: center;">2</td> <td>CT couplings</td> <td style="text-align: center;">1 Set</td> </tr> <tr> <td style="text-align: center;">3</td> <td>Main Hoist gear box input shaft</td> <td style="text-align: center;">1 No.</td> </tr> <tr> <td style="text-align: center;">4</td> <td>Auxiliary Hoist gear box input shaft</td> <td style="text-align: center;">1 No.</td> </tr> <tr> <td style="text-align: center;">5</td> <td>CT gear box input shaft</td> <td style="text-align: center;">1 No.</td> </tr> <tr> <td style="text-align: center;">8</td> <td>LT gear box input shaft</td> <td style="text-align: center;">1 No.</td> </tr> <tr> <td style="text-align: center;">9</td> <td>Bearing for Main Hoist gear box</td> <td style="text-align: center;">1 Set</td> </tr> <tr> <td style="text-align: center;">10</td> <td>Bearing for Auxiliary Hoist gear box</td> <td style="text-align: center;">1 Set</td> </tr> </tbody> </table>	S. N.	Description	Quantity	1	LT wheel Bearing	1 Set	2	CT couplings	1 Set	3	Main Hoist gear box input shaft	1 No.	4	Auxiliary Hoist gear box input shaft	1 No.	5	CT gear box input shaft	1 No.	8	LT gear box input shaft	1 No.	9	Bearing for Main Hoist gear box	1 Set	10	Bearing for Auxiliary Hoist gear box	1 Set	
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		11	Bearing for CT gear box	1 Set	
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		12	Bearing for LT gear box	1 Set	
		13	Oil seals for Main and Auxiliary Hoist	1 Set	
		14	Oil seal for CT	1 Set	
		15	Oil seal for LT	1 Set	
		16	Main and Auxiliary Hoist couplings	1 Set	
		17	CT rail clamps	10 Sets	
		18	Wire ropes with end clamps for main hoist	1 Set	
		19	Wire ropes with end clamps for auxiliary hoist	1 Set	
		20	DC EM Brake assembly for main Hoist	1Nos.	
		21	DC EM Brake assembly for auxiliary Hoist	1Nos	
		22	Electro hydraulic Thruster brake assembly for main Hoist	1Nos.	
		23	Electro hydraulic Thruster brake assembly for auxiliary hoist	1Nos.	
		24	Electro hydraulic Thruster brake assembly for LT	2Nos.	
		25	Electro hydraulic Thruster brake assembly for CT	1Nos.	
		26	Full wave bridge rectifier unit for DC EM brake	1Nos.	
		27	Brake shoe for LT	1 Set	
		28	Brake shoe for CT	1 Set	
		29	Brake shoe for main hoist	1 Set	
		30	Brake shoe for auxiliary hoist	1 Set	
		31	Rotary geared limit switches for main hoist	1 Set	
		32	Rotary geared limit switches for auxiliary hoist	1 Set	
		33	Gravity limit switches for main hoist	1 Set	
		34	Gravity limit switches for auxiliary hoist	1 Set	
		35	Limit switches for LT	1 Set	
		36	Limit switches for CT	1 Set	
		37	VFD for main hoist	1 Set	
		38	VFD for auxiliary hoist	1 Set	
		39	VFD for LT	1 Set	
		40	VFD for CT	1 Set	
		41	Semiconductor Fuse for Hoist VFD	20 Nos.	
2.2	Items not covered in The Scope of Supplier	The crane is to be installed on a runway girder which is already in use for another gantry crane and therefore following items are not covered in the scope of supplier:- a) Supply/erection of runway girder (LT girder) and LT rails. b) Construction of concrete foundations for runway girder (LT girder)			
3.0	Design Requirements	• Design Load:			

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		<p>Design load will include Dead Load, Imposed Load (Live Loads), Wind loads & Earthquake Load. The design life span of all structures shall be taken as 40 years.</p> <ul style="list-style-type: none"> • Seismic data: Structure to be designed for site specific response spectra of Kalpakkam, corresponding to Design basis Earthquake. • Wind load:- The crane is meant for installation in open yard where high wind velocity up to 180 km/hr is expected and the atmosphere is corrosive. • In the design of components on the basis of strength, a factor of safety not less than 5, based on ultimate strength may be used. Impact load fatigue, wear and stress concentration factors, Fatigue shall be taken into account for all mechanisms and components etc. 	
3.1	Main Hoist Safe Working Load	20 Metric Ton	
	Auxiliary Hoist Safe Working Load	05 Metric Ton	
3.2	Span	Wheel center to wheel center dimension :- 20050 mm	
3.3	Mechanism Class	Class M7 for all mechanism and A5 as a whole crane confirming to IS-3177	
3.4	Lift & Transverse each of Hoist	A schematic layout of the crane is attached for understanding hoist lift above & below rail level, span and general assembly of crab.	
3.4.1	Lift of Hoist	Lifts of main and auxiliary hoists will be as mentioned below:	
3.4.1.1	Main Hoist Lift above LT rail	4.2 m	
	Main Hoist Lift below LT rail	4.0 m	
3.4.1.2	Auxiliary Hoist Lift above LT rail	4.5 m	
	Auxiliary Hoist Lift below LT rail	4.0 m	
3.5	Speed	The operational speed in fast motion should be as follows (100 % speed in all motions should be achieved at ≈50Hz.):	
3.5.1	Hoists	5 m/min	
3.5.2	Long Travel	20 m/min	
3.5.3	Cross travel	10 m/min	
3.5.4	Micro Motion	a) Speed in micro motion for all the above travels will be through VFD and will be	

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		<p>set at 10% of the corresponding speed in fast motion.</p> <p>b) For Long Travel 3 speed setting should be there @ 10%, 50% and 100% of the Full speed.</p>	
3.6	Design Requirements for Components		
3.6.1	Wire Rope	<p>The wire ropes shall be of suitable diameter as per supplier's design of crane. The rope shall conform to IS: 2266. The factor of safety based on nominal breaking strength and safe working load of rope shall not be less than 6. The rope must be of Construction 6 x 37, Fiber Core, RHO, 1960 N/mm² UTS (min.) galvanized. Minimum No. of falls should be 4 for hoists; both ends of wire rope should terminate on rope drum.</p>	
3.6.2	Hook	<p>The hook of the crane shall be of 20 & 05 Ton S.W.L point hook/long shank Trapezoidal 'C' shank hook as per IS: 3815.</p> <p>The hook block shall be designed to lift without twisting. The hook shall be high tensile forged steel, capable of swiveling and designed to turn easily on roller thrust bearings with protective skirt for bearing. The hook shall be capable of being readily removed and replaced and fixed rigidly. The hooks shall be provided with locking device to prevent the rotation of hook when desired. Hook geometry shall comply with the requirements of IS-15560 or IPSS.</p> <p>Length of hook shank and other dimensions of the hook to be suitable as per purchaser's site requirement. Opening of hook shall be in such a way that 120 mm diameter shaft can go through it.</p> <p>The hook shall be of proof load tested marked and duly certified by competent authority. The material of construction of hook shall conform to Mild Steel Grade 2 as per IS-1875. Hook material shall be tested for chemical and mechanical properties and test certificate shall be submitted. NDTs like MPT and UT in addition to dimensional checks and visual examinations to be performed on hook after machining of the shank.</p>	
3.6.3	Sheave	<p>a) Material: The sheaves shall be of carbon steel casting/ forged steel having chemical and mechanical properties as per grade I of IS: 2707-1996.</p> <p>b) Grooves: Sheaves shall be machine grooved to a depth not less than 1.5 times the diameter of rope. The grooves shall be finished smoothly and free from surface defects liable to injure the rope. The contour at bottom of the groove shall be circular over an angle of approximately 130° ±5°. The radius of this part of grooves shall be larger than the radius of rope by an appropriate amount as per table 2 of IS: 3177.</p> <p>c) Diameter of Sheaves: The diameter of the sheaves at the bottom of the groove</p>	

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		<p>shall not be less than that of the drums as specified in IS: 3177.</p> <p>d) Sheave Guards: Sheaves shall be provided with guards to retain the rope in the grooves if necessary.</p>	
3.6.4	Bearings	<p>The type of bearings for various parts shall be as per IS: 3177. Provision shall be made for service lubrication of all bearings. Bearing enclosures shall be designed as far as practicable to exclude dirt and prevent leakage of oil or grease. Suitable drip pans shall be provided as required to collect oil and grease, which may drop, from operating parts. All drip pans shall be accessible for draining and cleaning. All bearings of gearing shall be antifriction type. Angular contact ball or taper & roller bearings shall be used wherever necessary. The bearings shall correctly locate the shafts while allowing for internal expansion of the shafts. Bearings shall be enclosed in suitable housing with proper plugs to provide grease and holes to permit easy lubrication.</p>	
3.6.5	Rope Drum	<p>The drum shall be preferably machined from seamless pipe (ASTM A 106 Gr B) otherwise the drum shall be fabricated from structural steel plate to IS: 2062 Gr B. All butt welds shall be subjected to 100% radiography. The pipe/plate shall be physical, chemical, and ultrasonic tested by approved laboratory and test certificates shall be submitted.</p> <p>a) The rope drum should be sufficiently wide to accommodate in one layer, the entire length of rope required for the specified lift and in addition not fewer than two dead turns at each anchored end and one spare groove at opposite end.</p> <p>b) The drum shall be flanged at both ends and flanges shall project to a distance not less than two rope diameters above rope. A spur or other wheel secured to the drum may be regarded as forming one of the flanges.</p> <p>c) Rope anchorage shall be readily accessible.</p> <p>d) Strength of the drum: Drums shall be designed to withstand the compressive stress caused by wound on rope and the local bending stress caused in the drum at the groove when rope is wound on. The bending stress due to the beam action of the drum shall also be taken into consideration.</p> <p>e) Diameter: The drum diameter measured at the bottom of the groove shall not be less than the appropriate value specified the IS: 3177.</p> <p>f) Drum grooves: The lead angle of rope shall not exceed 5° (1 in 12) on either side of the helix angle of groove in the drum. Rope drums shall be machine grooved and the contour at the bottom of groove shall be circular over an angle of 120°. The radius of the groove shall be larger than the radius of rope as per IS: 3177. The depth of groove shall not be less than 0.35 times diameter of rope. The</p>	

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		clearance between the adjacent turns of ropes shall be as per IS: 3177.	
3.6.6	Coupling	All couplings shall be of steel and designed to suit the maximum torque that may be developed. Alignment of all solid couplings to be made accurately. Flexible coupling shall be initially aligned with the same accuracy as solid couplings. Flexible couplings shall be fitted between motor shafts and extension shafts.	
3.6.7	Shafts & Axles	Shafts shall be made from solid rolled or forged steel bars as per relevant IS standards. Shafts & axles shall be of EN8 and EN9 respectively. Shafts and axles shall have ample strength and rigidity, adequate bearing surface for their purposes. Suitable heat treatment should be provided to shafts to ensure desired mechanical properties. They shall wherever necessary, be finished smoothly and if shouldered, shall be provided with fillets of as large a radius as possible and/ or tapered to suit. Keys, keyways, splines and serrations shall conform to relevant Indian standards. Shafts are required to be tested chemically and mechanically and test certificate from approved laboratory shall be submitted. Shafts should also be tested by Ultrasonic test.	
3.6.8	Gear Boxes	<p>All Gear boxes shall be of totally enclosed, oil splash lubricated dust proof construction. The gears shall be readily removable and boxes shall be oil tight. They should be of rigid construction and fitted with inspection covers and lifting lugs wherever necessary.</p> <p>The HP rating of gearbox for individual motion shall be greater than mechanical HP rating of the motor selected for that motion. The design calculation for HP rating of gearbox shall be provided as per IS 4460. It is also desired that the design calculation of gearbox shall consist of selection of gears, shafts and bearings.</p> <p>Facilities for oil filling, adequate breathing, drainage and means of indicating clearly the correct oil levels shall be provided.</p> <p>Gear box feet shall be machined and shall be seated and positively located on appropriate level surface preferably machined except where integral or shaft mounted. All the gearboxes must be stress relieved to remove any residual stresses induced during fabrication.</p> <p>The housing shall be of sufficient design not to permit a temperature in excess of 90° of the oil bath and shall be adequately supported and readily removable without disturbing the gear assembly.</p> <p>Internal of gearbox shall be sand blasted and painted with 2 coats of oil resisting enamel paint.</p> <p>Quality Assurance: Plates must be tested for chemical, mechanical properties and shall meet that required grade and valid test certificate from approved laboratory</p>	

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		<p>shall be submitted.</p> <p>All gear boxes shall be standard products of reputed gear box manufactures. Make of the items shall be subject to approval by purchaser. Shaft shall be turned from solid rolled or forged steel bar. Gear boxes for all motions will be connected to their loads through flexible geared couplings, on floating shafts principle, and to their drivers through flexible coupling.</p> <p>Gears: Gears shall comply with relevant Indian standard and shall be machine cut. The gears shall be of forged steel with teeth cut from the solid blanks, Pinions shall be of Steel forging. All shafts and axles shall be turned from forged steel bars. Material of construction of gears and pinions shall be EN 19 and EN 24 respectively or better. Shaft and axles shall be of EN 8 and EN 9 respectively or better. The rating of gears shall be established as per IS: 4460. Gears and pinions teeth shall be treated for resistance to wear. Gears shall have tooth form and modules as recommended in IS 3681 and they shall be adequately designed to stand shock load and vibration. They shall not be excessively noisy in operation. Gear blanks are to be tested chemically and mechanically and test certificate from approved laboratory shall be submitted. Ultrasonic Testing has to be in proof machined condition.</p> <p>Noise level of gearbox shall be within 80 db at 1 meter distance from gearbox. Gear manufacturer should have the testing facility for the gears.</p>	
3.6.9	Crane wheels	<p>Wheels for bridge and trolley shall be of double flange type. Wheels shall be mounted on axles rotating in L type bearing housing. Spherical roller bearing shall be provided for wheel and rope drum pedestal. 8 Nos. of wheels are recommended for the LT motion. The wheels shall be mounted in such a manner as to facilitate removal and replacement easily. Jacking pad shall be provided on web plates of bogie on both sides directly below the pin center for removal of LT & CT wheel. Materials for wheels shall be forged EN9 steel with a hardness of minimum 300 BHN. The dimension of flanges of track wheels shall be as per IS: 3177- 1999. Wheel material shall be tested chemically, mechanically. Wheels shall be tested ultrasonically and test certificates shall be submitted.</p> <p>Trolley rails complete with all fixtures i.e. clamps, plates, anchor bolts</p> <p>End stoppers and spring-loaded buffers for the bridge and trolley travel on both ends. Anti-topple lugs shall be provided.</p>	
3.6.10	Storm anchor/ Parking lock	Mechanical Swing lock and screw arrangement for locking with rail for LT motion	

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3.6.11	Seismic arrestor	Seismic arresters to be fixed for LT & CT motion.	
3.6.12	Mechanical Stopper and Hydraulic Buffer	Mechanical stopper and Hydraulic buffer shall be provided for each end of crab and LT carriage. Mechanical buffer for LT should be aligned with that of the existing crane at purchaser's site.	
3.6.13	Limit Switches	<p>a) Both hoist shall be provided with two limit switches for over hoisting and these shall be of following type: The first limit switch to act in case of over hoisting shall be rotary type with self-resetting feature and included in the respective motor control circuit. The second shall be gravity operated hand reset type connected in the main contactor control. The rotary type limit switch should also act in case of over lowering.</p> <p>b) Long travel and Cross travel shall be provided with limit switches to prevent OVER TRAVELLING and OVER-TRAVERSING respectively. The limit switches shall operate the respective motor control circuits.</p> <p>c) The heavy-duty limit switches with IP-55 enclosure with properly designed actuators (metallic) shall be provided and shall be readily accessible for adjustment and repair.</p>	
3.6.14	Drive unit	Equal driving efforts shall be applied at each drive wheel of the bridge and crab to prevent one end traveling faster than the other. All machineries for the drive unit shall be properly aligned. Self-aligning type gear couplings shall be used between connecting shafts to take care of transverse as well as axial movement wherever necessary. Wherever components of considerable amount of inertia are directly mounted on the high-speed shaft they shall be balanced statically as well as dynamically to minimize vibration.	
3.6.15	Drive motors	<p>All motors shall be squirrel cage totally enclosed, 415V \pm 10%, 50Hz \pm 3% fan cooled (IP55), S4 duty with 40% CDF and provided with class F insulation shall be suitable for VFD operation(Vacuum Pressure Impregnation).The motors shall be suitable for reversing, and frequent acceleration and mechanical brake. The starting and pull out torque shall be above 250% of rated torque for hoisting application. All motors shall conform to latest IS 325 & IS 12615. The motors shall have thermisters embedded in motor winding. The thermister trip relay shall be provided in control panel.</p> <p>The main hoist motor shall be offered for type test at manufacturer's works. Routine and Type test certificates shall be provided for all remaining motors.</p>	

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3.6.16	Brakes and rectifiers	<p>The brakes shall be capable of performing satisfactorily under all design and test load conditions.</p> <p>The hoist shall be provided with two brakes (one is hydraulic thruster operated and other is DCEM) and CT and LT motions shall be provided with hydraulic thruster operated brakes. All brakes shall be rated for half an hour continuous rating and for 150% load capacities. All brakes shall be fail safe type.</p> <p>All brakes shall be rated to hold load in off position for infinite time without slippage. Each brake shall carry a suitable and permanently marked plate which shall describe the adjustments to be made to obtain the correct brake setting.</p> <p>The thruster motor shall be of 3 phase, totally enclosed class B insulated, continuously rated motor. The thruster motor shall be designed for frequent switching operation in the range of 700 switching per hour. Thruster shall have reserve of at least 30% stroke length available for necessary adjustment as well as provision for adjustment of time for upward and downward travels of the piston.</p> <p>Rectifier unit (DC Supply) shall be of full wave with 415, 50Hz as incoming supply. These units shall be of 30 min rating and shall be provided with class F insulation.</p> <p>Double shoe type brakes shall be provided for each drive of all motions of the crane. The brake shoe shall be self-aligning type and shall have large cooling surface for low temperature rise.</p>	
3.6.17	Cables	<p>Power and control cables shall be segregated. Power terminal blocks shall be separated from each other by means of insulated terminal spacers. All power cables shall be selected as of a minimum size of 6 Sq.mm or one size higher than as per IS and control cables of a minimum size of 2.5 Sq.mm. Both power and control cables shall be of copper conductors and multi stranded (Class 5 as per IS694). Single strand wires shall not be used for wiring. Cable drag chain system shall be provided for Crab including mounting brackets, vertical separators, support plates, installation kit, extra glide nut and bolts, base channels, tie wrap plates, holding trays, chain flex, etc. to accommodate all cables. Power supply for Crab shall be given through flexible trailing cable systems mounted on retracting support. The system shall consist of insulated multi-conductor or several single conductor cables with permanent termination on the bridge and on the trolley. The flexible trailing cables shall have ample length and shall be supported by means of properly designed movable clamps. These clamps shall be fitted with rollers and shall run freely on a guide rail allowing relative movement of bridge and trolley without undue stress or wear on the suspended cable. The flexible trailing cable shall be of class 6 as per IS: 8130, silicon rubber insulated (IE5) and silicon rubber sheathed conforming to IS:</p>	

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		9968 (Part-I).	
3.6.18	Cable reeling drum (CRD)	The power supply shall be by cable reeling drum mounted on one leg of the crane, which will be motorized. Power points are available in a span of 100 M each. The CRD shall be torque regulated motorized type with limit switches to prevent over stress on the cables. The CRD shall have 4 + 1 terminal i.e. (3-phase terminal, neutral + earth terminal).	
3.6.19	Contactors	<p>Contactors shall be of crane duty and suitable for frequent operation. The contactors shall be silver-plated. The contactors shall be capable of making and breaking duty (AC-4).</p> <p>Contactors coil shall be of impregnated type and temperature rise of coil for repeated operation should not exceed the permissible limit of class insulation.</p> <p>Contactors current rating shall be at least 25% higher than the maximum current rating of motors being controlled.</p> <p>All the contactors, Motor Circuit breakers, OLR, MCB, time relays should be SCHNEIDER/SIEMENS/L&T or equivalent make. The supplier should indicate the make clearly in their quotation. Separate over load relay shall be provided for each motor of long travel.</p>	
3.6.20	Grounding	The crane structure motor frame and metal cases of all electrical equipment including metal conduits or cable guards shall be effectively connected to earth complying with Indian Electricity Rules: IS-3043. Each motor shall be grounded at two points with bare copper conductor wire of size in accordance to IS-3043. However, all other non- current carrying metal surfaces shall be earthed with one no. of 14 SWG bare copper conductor wire. The PCC/MCC panel shall be earthed in accordance to IEC-61439. When any equipment will be connected to the supply by flexible cables, the particular equipment shall be connected to earth by means of an earthing conductor enclosed with the current carrying conductors within the flexible cable. The crane wheel, flexible conduits and other metal parts shall not be used for earthing purpose.	
3.6.21	Illumination & Buzzer	The lighting system shall be suitable for 240 volts±10% single phase, 50 Hz supply fed from the live side of the disconnect switch located in the protective panel. The illumination system shall be controlled by separate isolating switches. Lighting fixtures shall be suitable for outdoor applications. Suitable No. of floodlights are to be fitted to the main bridge on both sides of the crane. A suitable buzzer should be provided which should be clearly audible in the operational area of the crane which is located outdoor.	
3.6.22	Wiring	The supplier shall furnish and install all power, control and auxiliary circuit wiring	

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		<p>of the equipment and panels located in the trolley, bridge. The wiring shall be complete in all respects to ensure the proper functioning of the equipment. All wiring to any motor shall be done with 1100 V grade XLPE insulated copper conductor, FRLS PVC outer sheathed cable for armored cables and HR FRLS PVC cables for unarmored cables of suitable sizes. Minimum size of cable for power wiring shall not be less than 6 mm² sizes. For selecting the rating of the cables for power wiring, consideration shall be given to the duty of the motor, ambient temperature, grouting of disposition cables, voltage drop etc. All cables shall be adequately protected against mechanical damage, if unarmored cables are used, the same shall be mechanically protected by running through heavy duty electrical conduits. However, no conduits are required for wiring in case armored cables are used. Each motor shall be wired up independently. Power and control wiring shall be effectively separated. For control panel wiring, each wire shall be identified at both ends in accordance with supplier's wiring system diagram. All wiring termination to the panel shall be made with clamp type connection block. Screw type terminals with screw directly impinging on conductor are not acceptable. All electrical panels shall be chemically treated; thickness of component mounting plates shall be 3 mm. All wiring shall be done with 2.5 sq.mm HFFR wires. The control cables shall be color coded for ease in identification.</p>	
3.6.23	Radio-remote pendent and associated panel	<p>Radio remote pendent and associated panel: Radio Remote Control with min 12 nos. of Push Buttons conforming to IS: 3177 for 3 Motion EOT Crane along with the following features should be provided.</p> <ol style="list-style-type: none"> 1. Main Power : Start/Stop 2. Main line contactor : ON 3. Main & Auxiliary Hoist : Up/down 4. Cross travel : Left/Right 5. Long Travel : Forward/Reverse 6. Alarm/Hooter : Required 7. Emergency stop : Required 8. Under bridge light : Required 9. Main/Micro speed selection : Required 10. Or increment/decrement in speed : Required 11. Lock/key for functioning of remote: Required 12. Operating range should be 100 meters approx or more for radio Remote. 13. Isolation transformer and surge suppressor for the receiver supply to be provided. 	

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		<p>14. For Long-travel provision for 3 speed selection should be available.</p> <p>15. The wiring should be connected to terminals/ equipment with proper size copper cable, wire lugs.</p> <p>16. Supplier must give circuit diagrams of the entire RRC. All panel wires, cables should be ferruled, numbered and the same should appear on electrical drawings.</p> <p>17. Common push button for horn and start.</p> <p>18. Emergency Mushroom type PB with lock and Key on top panel of RRC Transmitter, 4 line LCD display for battery status, RRC fault, RF field strength etc.</p>																					
3.6.24	Control Panel	<p>The following minimum equipment shall be provided in control panel: All the switchgears inclusive of the power contactors, motor controlling VFDs, SDFs, etc. shall be housed in a PCC/MCC panel. The panel shall be fabricated in accordance to IEC-61439/IEC-60439. The type of enclosure for the panel shall be IP-54 in accordance to IS-2147. Bottom entry of the cables shall be sealed by rubber grommets.</p> <p style="text-align: center;">Panel Technical Particulars:</p> <hr/> <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Reference Standard</td> <td style="width: 50%;">: IEC-61439/IEC-60439</td> </tr> <tr> <td>Rated operating Voltage (U_e)</td> <td>: 415V ± 10%, 50Hz ± 3%</td> </tr> <tr> <td>Rated Insulation Level (U_i)</td> <td>: 690V</td> </tr> <tr> <td>Rated Overvoltage Category</td> <td>: II</td> </tr> <tr> <td>Panel IP Class</td> <td>: IP -54 or superior</td> </tr> <tr> <td>Environment pollution Degree</td> <td>: 3</td> </tr> <tr> <td>EMC Compliance</td> <td>: Class A</td> </tr> <tr> <td>Resistance to Corrosion</td> <td>: Outdoor Mounting Shall comply to Severity Test-B</td> </tr> <tr> <td>System Earthing</td> <td>: TN-S (In accordance to IS-3034)</td> </tr> <tr> <td>Panel Cable entry</td> <td>: Bottom side only</td> </tr> </table> <hr/> <p>1. Main line connecting/disconnecting switch, TPN, SFU, rated operational current, AC-23 utilization category. Conformance to IS 13947 (Part 3) and IEC: 60947.</p> <p>2. One triple pole air break type main contactor with thermal overload relay.</p>	Reference Standard	: IEC-61439/IEC-60439	Rated operating Voltage (U _e)	: 415V ± 10%, 50Hz ± 3%	Rated Insulation Level (U _i)	: 690V	Rated Overvoltage Category	: II	Panel IP Class	: IP -54 or superior	Environment pollution Degree	: 3	EMC Compliance	: Class A	Resistance to Corrosion	: Outdoor Mounting Shall comply to Severity Test-B	System Earthing	: TN-S (In accordance to IS-3034)	Panel Cable entry	: Bottom side only	
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		<p>Hoisting duty Power Contactors, coil voltage 48V AC, 2NO + 2NC built in auxiliary contacts, Utilization category 3ph, 415V, 50Hz AC4, Conformance to IS 13947 (Part 4/Sec.1) and IEC: 60947-4-1.</p> <ol style="list-style-type: none"> 3. Emergency push button at convenient height for the operation for interruption of the entire power. 4. Lighting transformer 1Ø, 415/240V, 1.0 KVA, fitted with MCB, DP, Curve -C, Breaking Capacity - 10 kA, Current rating-10A, in the incoming and outgoing circuit of transformer. 5. Control transformer 1Ø, 2.0KVA, 380-400-415/42-48V, fitted with MCB, DP, Curve -C, Breaking Capacity - 10 kA, Current rating-10A, in the incoming and outgoing circuit of transformer. 6. Current transformers wound coil type, 200/5A, class of accuracy - 0.5, Rated Burden- 15VA. 7. Ammeter analog type cut out 92 x 92 mm, 270° Span, range: 0-200A, fitted with, Isolating CT secondary terminals, selector switch 5A, 4 position, 360° angle of rotation. 8. Main supply on/off lamps on the door of the protective panel. 9. Electrical interlock shall be provided to prevent the main contactor being closed unless all controllers are in OFF position. 10. All internal wiring shall be identified with numbering rules at both ends. 11. Panel shall have internal illumination with LED lamp. 12. Power for lighting circuit shall be tapped from the incoming side of isolators. 13. A socket 2 pin + earth, 230V, 10A with a switch and MCB protection shall be provided. 14. Cabin lamp bulk head fitting 12W LED, 230V AC fitted with wire guard. 15. Foot switch for bell 10A, 230V, SP. 16. Bell 6" 60W, 230V AC. 14. Fan 12" sweep, 60W, 230V AC 15. Individual MCB protection of suitable rating shall be provided for control circuit supply, fan supply and lighting supply. 16. The crane shall be operated from either the master controller or radio remote control unit. <p>Selection between the master controller and the RRC unit shall be by means of rotary selector switch placed on control panel.</p> <p>Complete instructions covering the crane operation, maintenance and lubrication shall be mounted at control panel in permanent frame for convenient reference.</p>	
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3.6.25	Enclosure and general specification of VFD panel	<p style="text-align: center;">Non-slip type insulation mat should be provided on Control Panel's floor.</p> <ol style="list-style-type: none"> 1. Separate panel shall be provided for Incomer, Main Hoist, and Auxiliary & CT/LT. The panel construction shall be in accordance to IEC-61439/IEC-60439. The type of enclosure for the panel shall be IP-54 in accordance to IS-2147. 2. Each panel enclosure shall be suitable for outdoor installation, weatherproof, rainproof (using single walled double door enclosure and rain canopy all around roof), vermin proof, fixed type self-supporting, floor mounting. 3. Body and Doors of the panel shall be fabricated with 2mm thick CRCA sheet steel. 4. Partitions of the panel shall be fabricated with 1.6mm thick CRCA sheet steel. 5. The panel shall be painted with a minimum of two coats of powder coating of 631 light grey Shade after 7 Tanks Hot Pretreatment Process. 6. Each panel shall have a separate incomer SFU/MCCB. 7. Neoprene Gaskets with minimum 6mm thickness shall be provided on the inside of each door. 8. Control supply shall be of 48V AC tapped from Power bus through auxiliary/control transformer. 9. Incomer feeders shall consists of R, Y, B indication lamps (LED type), Voltmeters (analog type) to measure phase & line voltage, Ammeters (analog type). 10. All the VVVF Drive feeders shall consist of 6inch cooling fan with filter unit for cooling purpose. 11. Design Ambient Temperature: 40°C for the MCC panel. The temperature in VVVF DRIVE compartment shall not be more than 45°C or the maximum limit that the drive can withstand. 12. Each compartment shall be provided with a LED and door limit switches. Suitable power points shall be provided inside the panel for maintenance. 13. All the switchgears shall be mounted in the mounting plate. 14. All Panels shall be designed for cable entry from the bottom of panel. Sufficient space shall be provided for easy of termination and connection. Necessary removable type Gland plates shall be provided on the bottom of the panel. 15. A ground bus shall be extended full length of the each panel. The ground bus shall be provided with two-bolt drilling with G.I. bolts and nuts at each end to receive 50 x 6 mm G.I. flat. The ratings of all powers cables, SFUs, MCCBs, and Contactors shall be one size higher than the rating/ size suggested in respective IS codes. And Fuses rating shall be of same as suggested in IS code. 16. VFD Ready, Run, Forward, Reverse indications shall be provided on the panel. 	
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		All Switchgear in the panel shall be easily accessible for easy maintenance and replacement of components.	
3.6.26	General specifications for VVVF drives	<p style="text-align: center;"><u>VFD Technical Particulars:</u></p> <p>Reference Standard : IEC 61800-1/ BS EN 61800: Adjustable speed electrical power drive systems</p> <p>Rated Operating I/P Voltage : 415 ± 10% Volts, 3-phase, 50 ± 3% Hz</p> <p>VFD Power rating : The VFD shall be rated for heavy duty crane load applications. The VFD current rating shall be at least 25% higher than the rating of motors being controlled.</p> <p>VFD Total Harmonic Distortion (THD) : The VFD shall confirm to the THD limitations as listed in the IEEE-519: 2014- Recommended Practices and Requirements for Harmonic Control in Electric Power Systems THD to be < 5% Individual frequency THD to be < 3%</p> <p>VFD EMC compatibility : The VFD must be CE marked According to EN 61800-3, the VFD is intended for Catagory-C3 environmental use. The VFD shall have inbuilt Class-A filter</p> <p>Inbuilt Protection Features : Fault Self Diagnosis DC link over/under voltage Motor over temperature Inverter over temperature IGBT Fault Input/output phase failure</p>	

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			<p>Motor short-circuit/overload protection</p> <p>Earth Fault protection</p> <p>Motor automatic tuning: the VFD shall be able to determine the motor static & dynamic characteristics automatically</p>		
		Fault History	: Shall have inbuilt fault history recording feature for at least 10 old faults		
		Display Parameter List	: 2 line LED display to show at least two selectable parameters during normal VFD operation		
		Digital/Analog Interface	: Input: 4-DI (isolated), 2 Analog Output: 4-DO (isolated), 2 Analog		
		Degree of Protection	: IP 21 or above		
		Cooling Mechanism	: In-built forced air		
		<ol style="list-style-type: none"> 1. Separate VFD shall be provided for Hoist, CT and LT motions. Hoist control is through feedback encoder for closed loop control. 2. The Variable Frequency Drives shall be suitable for continuous operation for ambient temperature 50°C and of crane duty. 3. All Drives shall achieve the maximum speed of respective motion at 50Hz frequency. 4. The Drives shall be suitable to vary the motor speed from zero to rated RPM. The model shall be selected to suit the application and heavy duty rating and shall conform to the latest edition of IEC / IS and also meet the requirements of IEEE. 5. Dynamic braking resistor of suitable rating shall be installed for each VFD separately outside the VFD cubicle. 6. Routine test certificates shall be provided for each VFD. 7. All VFD drives shall be protected by suitable rated HRC fuse. 			

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3.6.27	Structural Components	
3.6.27.1	Bridge Girder (Main Girder) and A-frame (vertical support structure)	<p>Bridge girder shall be of standard manufacturing design i.e. welded plate, box type double girder construction with internal diaphragms and external web stiffeners. Members of A-frames shall also be welded plate, box type construction. The material of construction to be M.S plates conforming to IS: 2062 Grade B. The minimum thickness of load bearing plates shall not be less than 10 mm and that of non-load bearing plates not to be less than 6 mm. The ratio of the length of girder to depth at any place shall not be greater than 18. The ratio of the effective length of the compression flange of the girder (l) to the breadth of flange of the girder shall not exceed 60.</p> <p>The joints between individual members of A-frames and that between the A-frames and bridge girders shall be bolted with high tensile steel fasteners.</p> <p>Lifting points: To enable handling of crane girder without any damage during erection, due care should be given to provide handling points and mark the same clearly on girders.</p> <p>Cambers: - Girders shall be cambered to an amount approximately equal to the dead load deflection plus one-half the live load deflection.</p> <p>Limiting deflection: - The deflection of member or the structure as a whole (without taking into consideration impact factor) should not be such as would impair the strength or efficiency of structure or lead to damage to finishing. Girder shall be designed so that the vertical deflection caused by the 125 % of safe working load and the weight of crab in central position shall not exceed 1/1200 of the span.</p> <p>Quality Assurance: Plates must be tested for chemical, mechanical properties and shall meet that required grade and valid test certificate from approved laboratories shall be submitted. Fabrication shall be done by qualified welder using qualified welding procedure. All the butt welds shall be 100% radiographed.</p>
3.6.27.2	End carriage and Crab structure	<p>The design shall be such that the load from the crab is divided equally between supporting box girders. End carriage and crab frame shall be manufactured using rolled sections/plates and shall be all welded rigid construction. All quality control and finishing procedure adopted for main girder shall be applied to end carriage and crab frame also. Appropriately positioned jacking pads shall be provided for easy removal of individual wheels. End carriage and crab structures shall be provided with derailing stiffeners at all four corners to prevent fall of structure by no more than 25 mm in the unlikely event of wheel</p>

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		<p>axle failure.</p> <p>Monsoon protection cover:-</p> <p>End carriage (LT trollies) and Crab (CT trollies) should be of closed type providing suitable cover for protecting them from rain water however, it should be convenient for maintenance of components inside these covers. The cover should be made of 18 SWG or thicker aluminum sheet with supporting frame made of 32 NB or higher size heavy duty steel pipes or rolled steel sections with minimum thickness 5 mm or more. The cover for crab should be cabin type covering the crab from top as well as from all four sides, should have minimum height of 2500 mm, should, should be bolted with the crab frame and should have proper lifting hook for its easy removal using mobile crane. A hinged door (height 2000 mm & width 800 mm) with bolt with provision of locking should be provided to the crab cabin and it should have access ladder from main' bridge platform. This ladder should be movable with the crab and it should be provided with proper man guard. The crab cabin should have louvered/sliding windows at-least three side for proper ventilation during maintenance works inside the crab cabin.</p> <p>The crab cabin should be equipped with suitable support structures for installing chain-pulley blocks or other lifting tackles for handling & maintenance of gear boxes, drive motors etc. inside the crab.</p>	
3.6.27.3	Platforms, ladders and railings	<p>Safe means of access shall be provided to every place where any person engaged Examination or maintenance of the crane has to work. Adequate hand holds and footholds shall be provided wherever necessary. Platforms should be provided along both the main bridge girders, these bridge girder platforms should be interconnected with another platform at both ends of the bridge girders.</p> <p>Every platform shall be securely fenced with double tired guard rail and toe guards, unless parts of the crane structure provide equal safety and platforms shall be of sufficient width to enable normal maintenance work to be undertaken safely. On bridge platforms, which shall not be less, than 800 mm, facing shall extend along the full length of the outer edge.</p> <p>All the platforms should be connected to main girder by a bolted joint to enable easy transport of girders and platforms as separate parts.</p> <p>Platforms should be of chequered/non slip surface Aluminum plates of thickness 6 mm or more bolted to supports made of rolled MS sections.</p> <p>Side rails to ladder shall extend to a reasonable distance beyond platforms, or</p>	

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		<p>some other reliable handhold shall be provided.</p> <p>Ladders shall if possible slope forwards and shall be provided with proper man guards. Ladders should have clear width of 450 mm or more. Steps should be made of 25NB Heavy duty seamless/welded ground smooth steel pipes spaced 300 mm apart.</p> <p>Platform railings should be made of 25NB Heavy duty seamless/welded ground steel pipes placed in tiers 500 mm apart, top rail at 1000mm from platform/walkway level and vertical posts made of MS rolled section of thickness not less than 6 mm and spaced not more than 1.75 meters apart. Pipes used for making hand railings/ladders should be heavy duty carbon steel pipes of size 25NB or more. Support structures for these hand railings/ladders should be MS rolled section of thickness not less than 6 mm.</p>	
3.6.27.4	CAPACITY PLATE	A plate mentioning rated capacity of hoist, year of manufacture etc. shall be placed so as to be easily legible to read from the grounds.	
3.6.28	Tools and accessories provided with crane	<p>One no. of 2.5 kg CO2 gas type fire extinguisher shall be provided near the control panel. A tool box equipped with all necessary mechanical & electrical tools along-with the tools listed below:-</p> <ol style="list-style-type: none"> 1. Double end spanner – one set 2. Ring spanner – One Set 3. Hammer 2lbs –One No. 4. Hammer 5lbs – One No. 5. Screw driver – One Set 6. Cutter pliers – Three No. 7. 20 T Hydraulic Jack (Remote pump type) – One No. 8. Grease gun (5kg capacity) – Two No. 9. Socket wrench – One Set 10. Torque wrench – 1 No 	
3.7	PREFERED BOUGHT OUT COMPONENTS	<ol style="list-style-type: none"> a) All the items shall have rating / specifications to take care of full design factors as per tender technical specifications or relevant I.S. standard whichever is more stringent. b) The Bidder agrees to use bought out items given below. However, ratings/size/type etc of such items shall be subject to the approval by the Purchaser. Deviations from the preferred makes / makes of other bought out items not covered in the list shall be subject to the approval by the Purchaser. c) The Purchaser shall have right to inspect purchase orders, test certificates 	

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		etc. of the bought items. d) Bought out items should not be modified by crane's manufacturer and a certificate stating that no modification have been done by crane's manufacturer for any bought out items, should be provided.	
3.7.1	Steel	Tata / Sail or equivalent	
3.7.2	Gear box	ELECON/RADICON/SHANTI/ALLENBURY/SEW or equivalent	
3.7.3	Electro Hydraulic Thruster Brake	SPEED-O-CONTROL/ ELECTROMAG or equivalent	
3.7.4	DCEM Brake	BCH /SPEED-O-CONTROL / OMEGA CONTROL/STORMCRAFT or equivalent	
3.7.5	Hoisting rope	Usha Martin or equivalent BIS approved	
3.7.6	Hook & Hook Block	B.R. HERMAN & MOHATA / E.E KARACHIWALA / Smriti Forging / Hercules Forging or equivalent	
3.7.7	Bearing	SKF / FAG or equivalent	
3.7.8	Geared Coupling	HICLIFF/NUTEK or equivalent	
3.7.9	Fasteners	Unbrako / API or equivalent	
3.7.10	Electric Motors	Siemens/ABB/Crompton greaves/Bharat Bijlee or equivalent	
3.7.11	DSL	SAFE LINE / SUSHIL or equivalent	
3.7.12	VVVF control drive with drive enclosure	Schneider Electric/ ABB/ Siemens or equivalent	
3.7.13	Feedback encoder for VVVF control drive	Hubner / Hengstler or equivalent	
3.7.14	Transformer	AE / Kappa or equivalent	
3.7.15	Fuses	SIEMENS / L&T/Schneider or equivalent	
3.7.16	Main Isolator	SIEMENS / L&T/ Schneider or equivalent	
3.7.17	Contactors	BCH/SIEMENS / L&T/ Schneider or equivalent	
3.7.18	Limit Switches	Siemens, BCH, Schneider or equivalent	
3.7.19	Fixed cabling system	UNIVERSAL, FINOLEX,TORRENT, Polycab, or equivalent	
3.7.20	Flexible Cable wiring (HFFR / FRLS)	FINOLEX / RR CABLE/ POLYCAB or equivalent	
3.7.21	Control Panel	TECHNO ELECTRICALS / KAIREL / Rittal or equivalent	
3.7.22	Pendent Push buttons	SIEMENS / SCHNIEDER/Tecknic/ or equivalent	
3.6.23	Switch Fuse	SIEMENS / L&T / Schneider or equivalent	

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3.7.24	LED indicating lamps	Schneider / Siemens/Tecknic / Speed-O-Control or equivalent	
3.7.25	Radio Remote Pendant	SNT controls / Stromag /Acropolis or equivalent	
3.7.26	Load cell	IPA or equivalent BIS approved	
3.8	<p>APPLICABLE CODES & STANDARDS</p> <p>The crane shall comply with all currently applicable statues, regulation and safety codes relating to the design, construction and operation of cranes in the locality where the crane will be installed. No part of these specifications shall be construed to relieve the vendor of his responsibility to supply a functionally adequate crane. The crane supplied shall comply with the latest applicable Indian / International standards. Other national standards are acceptable if they are established to be equal or superior to the referred standards.</p> <p>In the event of any conflict between codes & standards and this specification, the requirements of this specification shall govern. Some of the applicable codes are listed below:</p>		
	IS : 807 (2006)	Code of Practice for Design, Manufacture, Erection & Testing (Structural portion) of Cranes and Hoists.	
	IS : 3177 (1999)	Code of Practice for Design of E.O.T. and Gantry Cranes other than steel works Cranes	
	IS: 4460/ISO 6336	Gears - Spur and Helical Gears - Calculation of Load Capacity	
	IS- 3815	Point hooks with shank up to 160 Ton.	
	IS : 2266 (2002)	Steel Wires for Ropes for General Engineering Purposes. Hoisting rope.	
	IS : 3443	Crane Rail Sections	
	IS 2062 (2011)	Specification for structural steel.	
	IS : 325	Three Phase Induction Motors	
	IS : 4029	Guide for Testing Three Phase Induction Motors	
	ASME Section V	For non-destructive testing	
	ASME Sec. VIII Div-1	Code of construction in conjunction with section IX for fabrication.	
	ASME Section IX	For welding procedure and performance qualification	
	IS : 3757	High strength structural bolts	
	IS : 814	Welding Consumables	
	IS : 816	Code of Practice for use of Metal Arc Welding for General Construction in Mild steel	
	IS : 823	Code of Practice for use of Metal Arc Welding of Mild steel.	
	IS : 875	Code of Practice for design loads (other than earthquake) for building and structure Part-3:- Wind load	
	IS: 1875	Material of construction of hooks	
	IS: 5749	Forged Rams horn hooks	

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	IS: 8610	Wrought iron and mild steel hooks for cranes, slings, blocks and general engineering purposes	
	IS: 1477	Code of practice for painting of ferrous metal in building and allied finish	
	IS: 1030	Steel casting for general engineering purposes	
	IS: 1852	Rolling and cutting tolerance for hot rolled steel product	
	IS: 970	Wrought steel in the form of bar and for up to 6 inch rolling section and general engineering purposes	
4.0	FABRICATION AND TESTING REQUIREMENTS		
4.1	FABRICATION	The materials may be cut and formed to the required shape by any process that will not unduly impair the physical properties of materials. The edges that will be exposed in the finished form shall be rounded off to a radius of at least 3 mm or chamfered at 45 degrees to at least 4 mm flat. All materials shall be grounded smooth and straightened and any slag of previous molten material shall be removed prior to further fabrication or use.	
4.1.1	MATERIAL	Material of construction for various components will be as mentioned in the technical specifications for components at 3.6 above.	
4.1.2	WELDING		
4.1.2.1	Welding shall conform to IS-814, IS-816, and IS-823. The welding procedures and performance qualification of welders shall be in accordance with Section-IX of ASME Boiler and pressure vessel code. Electrodes for welding shall conform to IS-814.		
4.1.2.2	The welding procedures and welder's performance qualification report shall be submitted to purchaser for approval. The welding shall be carried out only by the qualified welder as approved by purchaser.		
4.1.2.3	All welds should be free from defects like blow holes, lack of penetration, slag inclusions, porosity etc. and the welding shall be uniform.		
4.1.2.4	Purchaser reserves the right to check any weld by suitable non- destructive test and if any weld is found defective, supplier shall repair the same free of cost after obtaining the approval from the purchaser.		
4.1.2.5	Weld procedures adopted shall involve least amount of warping and not detrimental to the integrity of the sections being welded.		
4.1.3	BALANCING: All rotating components i.e. wheel, sheave, shafts, brake drums etc. shall be statically & dynamically balanced individually and as an assembly itself shall be put to balancing by appropriate method. The balancing grade shall be 2.5 as per ISO 1940 and the vibration level shall be as per ISO 14694.		

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4.2	INSPECTION: Supplier will prepare detailed quality assurance plan (QAP) based on enclosed indicative QAP at annexure-A and technical specifications and submit to purchaser for approval prior to fabrication/procurement of bought out items. The inspection requirements for all components/ equipments shall conform to design and fabrication requirements as defined in the relevant codes and standards as well as in this specification. Stage- wise inspection and testing will be carried out as per approved QAP. Enclosed QAP is indicative only. Supplier should prepare the QAP based on the all the technical requirements of this specifications.	
4.2.1	The supplier shall maintain proper inspection records and make it available to purchaser's representative whenever required. Supplier shall make necessary arrangements for the inspection by the purchaser or his authorized representative.	
4.2.2	Supplier shall provide to the purchaser or his representative all the necessary test certificates for the standard components and materials bought out from the market. The test certificates for mechanical properties and chemical composition of the materials to be used for fabrication /construction of the crane shall be provided. The supplier shall make arrangements to scrutinize and purchase only good and trouble free components and preferably with the approval of the purchaser. The steel castings and forging for load carrying parts shall be tested by appropriate Dye-penetrant and ultrasonic tests for getting the defect free units.	
4.2.3	The supplier shall offer the inspection of main girders in U shape i.e. prior to welding of bottom flange and painting.	
4.2.4	After assembly of bridge, the water level test for wheel assemblies shall be conducted at works.	
4.2.5	Welds for major load bearing components like bridge girders, A-frame, end carriages, trolley frames etc. shall be examined as follows: a) All butt welds shall be 100% radiographed. b) All butt, T-joints and fillet welds shall be checked by dye penetrant test for root and subsequent each pass of welding.	
4.2.6	Purchaser reserves the right to inspect any material or equipment furnished or used by supplier under the contract and to reject any, which is found defective in workmanship or design, or otherwise unsuitable for the use and purpose intended, or which is not in accordance with the intend of contract.	
4.2.7	Should purchaser waive the right to inspect any equipment, that waiver shall not relieve supplier in any way of his responsibility and obligations under the contract.	
4.2.8	Purchaser reserves the right to call for certificates for all material and equipment at any stage of manufacture.	
4.2.9	In the events of purchaser's inspection revealing poor quality of goods, purchaser shall be at liberty to specify additional procedures, if required to ascertain supplier's compliance with the equipment specifications.	

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4.2.10	Even though purchaser or his representative carries out inspection, such inspection shall not however relieve supplier from his responsibilities for furnishing the equipment conforming to the requirements of the contract.	
4.3	TEST CERTIFICATES: Following test certificates shall be furnished by the supplier for review/verification by the purchaser.	
a)	Manufacturer's test certificates (MTC) for mechanical properties and chemical compositions of structural steels, fasteners, sheaves, hooks, wire ropes, rope drums, wheels, gears and pinions, shafts and axles etc.	
b)	Functional tests for all equipment	
c)	Radiography Test (RT) reports of butt welds and T-joints.	
d)	Test reports of Liquid Penetrant Test (LPT) of fillet, butt and T-joint welds.	
e)	Test reports of Liquid Penetrant Test of hooks and sheaves	
f)	Ultrasonic Test (UT) reports for hooks, rope drums, shafts & axles, gears & pinions, wheels etc.	
g)	Insulation test for all electrical equipment and continuity test for all cables.	
h)	Type and Routine tests for motors.	
i)	Test certificates for brakes and clutches.	
j)	Routine test certificates for all VFDs and DBRs.	
k)	Detailed list of brought out items with make, model, sr. no., rating etc.	
l)	Test certificate for bought out components including material test certificates for all load bearing parts of these bought out components.	
m)	Test certificate for proof load of hook & breaking strength of wire rope.	
n)	Test certificate for balancing of rotary components.	
4.3.1	In lieu of test certificates from the manufacturer of the materials or non- correlation of the material with corresponding MTC, purchaser's representative will randomly select the sample of the material which shall be tested at NABL approved lab as per the specifications at supplier's cost and the test certificate shall be verified by the purchaser prior to the starting of fabrication.	
4.3.2	For reviewing the test reports for LPT, UT and RT, purchaser's representative may re-conduct up to 3 % of the total quantity of each type of these tests at random in his presence at supplier's cost. If considerable discrepancy is observed in the test results found by purchaser's representative and the test reports submitted by the supplier then the supplier will have to repeat the test for full quantity in presence of purchaser's representative.	
4.4	Testing of Crane	
4.4.1	Before shipment, the crane shall be carefully fitted and shop assembled, clearly match marked to facilitate assembly at the site. The shop operational and running tests for machinery assembled on the bridge structure shall be conducted for all mechanical and electrical parts and automatic devices to	

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	demonstrate that the crane is in satisfactory operating condition. Supporting arrangements shall be provided in a manner to allow free movement of hook for determining high hook elevation and hook lift.	
4.4.2	<p>TESTING AT SUPPLIER'S WORKS</p> <p>The following tests on complete crane in presence of purchaser's representatives shall be carried out at supplier's works:-</p> <ol style="list-style-type: none"> a) Review of test certificates as listed at 4.3 b) Visual inspection and dimensional checks. c) No load test trials shall be conducted. Motor currents, functional checks of drives for each motion, functionality of all limit switches and interlocks shall be verified. d) Rated load test: Checks for functioning of motions, travel limits, interlock operations, brake operations, functioning of drive mechanisms at rated load shall be conducted in addition to checks for specified speeds and bridge girder's deflection at rated load. e) Noise level shall be less than 80db at 1 m. distance from crab. f) Overload test at 125% of rated load for each hoist. No permanent deflection or flaw should be there in the load bearing components after overload test. Slippage of brake should not be there. Deflection should be within (1/1200) of the span. No distortion, permanent strain, damages or deformation of any part of the equipment to be supplied under this specification shall occur as a result of the above testing. This shall be confirmed by LPT of hooks and weld joints on load bearing structural components and visual examination of other components after the load test. 	
4.4.3	<p>TESTING AT PURCHASER'S SITE (AFTER ERECTION)</p> <p>Following tests on the crane shall be carried after erection at purchaser's site:-</p> <ol style="list-style-type: none"> a) Checks for dimensions and alignments. b) Test for proper functioning of the crane at no load condition. c) Test for proper functioning of the crane at intermediate loads (i.e. at loads between no load and rated load) d) Rated load test: After erecting the crane at site, the crane shall be tested at the rated load. Checks for functioning of all motions, travel limits, interlock operations, positioning accuracy of drive mechanisms at rated load shall be conducted in addition to the checking of specified speeds at rated load. The maximum deflection with rated load shall not exceed 1/1200 of the span. <p>For both the hoists each type of braking mechanism will be tested independently by isolating other type of braking mechanism. Each braking mechanism should be able to hold the rated load without slippage. Supplier will produce detailed procedure for purchaser's approval for testing individual brakes at rated load.</p>	

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		e) Overload test of main hoists at loads 25 Tons. No slippage of brakes should be there.	
4.4.4	All the tests shall be carried out as per latest IS-3177 unless otherwise specified.		
4.4.5	No distortion, permanent strain, damages or deformation of any part of the equipment to be supplied under this specification shall occur as a result of the above testing.		
4.4.6	Arrangement of Test Loads	The necessary loads and lifting tackles for conducting load testing at purchaser's site will be arranged by purchaser. Supplier will arrange tests loads for testing at supplier's works.	
4.4.7	Arrangement of Testing Instruments	The supplier shall arrange at his own cost the required testing and inspection instruments for use at ex-works and at site.	
5.0	DOCUMENTATION		
5.1	DESIGN DOCUMENTS		
5.1.1	The supplier shall provide detailed design calculations for selection of mechanisms like motors, brake, wheel, rail, wire rope, rope drum, hook & its bearings, gear boxes, shafts, bearings etc. and structural members like girders, end carriage, crab structure etc. The design calculation shall be approved by the purchaser before the fabrication of the crane.		
5.1.2	The design calculations of structural members for seismic and wind load should also be produced by the supplier for purchaser's approval prior to fabrication. The swing calculation, design calculations for anti-topple lugs, wheel stoppers, end buffers shall also be provided.		
5.1.3	Four copies of approved design calculations shall be provided to the purchaser.		
5.2	DRAWINGS		
5.2.1	The bids shall accompany two sets of general layout drawings of the crane based on purchaser's tender specifications.		
5.2.2	<p>The supplier shall furnish two sets of following drawings to get the approval of the purchaser prior to fabrication.</p> <ol style="list-style-type: none"> a) General Arrangement of crane. b) Main girders, L.T. bridge and end carriage: Assembly and structural details. c) Crab Assembly and structural details. d) Drive units for L.T., C.T. and main & auxiliary hoist: assembly and parts details. e) L.T. drive shaft and wheels: Assembly and details. f) Assembly and detail drawings for rope drum, hook and hook -block. g) Rails details and their fixing arrangement for L.T and C.T along with end stoppers. 		

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	<ul style="list-style-type: none"> h) Limit switch arrangement and details. i) Arrangement for LT & CT cable j) Electrical power and control circuit diagram. k) Schematic & wiring diagram of power and control system. l) GA of control panel m) Pendant wiring diagram. n) Crane clearance diagram. o) Crab cover p) Necessary installation, maintenance and operational drawing. 	
5.2.3	The drawings shall be made using AutoCAD.	
5.2.4	It is the responsibility of the supplier to incorporate correctly all the comments conveyed by the purchaser on supplier's drawings.	
5.2.5	Drawings prepared by supplier and approved by purchaser shall be considered as part of specification. However, examination and approval of drawings by purchaser shall not relieve the supplier of his responsibility for proper engineering, design, workmanship and functioning of the cranes under the contract.	
5.2.6	If any time before the completion of work, changes are made necessitating revision of approved drawings, supplier shall make such revisions and obtain the approval of the purchaser.	
5.2.7	Supplier shall incorporate the as built changes in the drawing.	
5.2.8	All bought out components specifications (order specs) shall be specified in drawing.	
5.2.9	Supplier shall provide 3 sets of hard copies of all the drawings as well as soft copies in AutoCAD as well as in pdf format in CD media to purchaser for his records.	
5.3	OTHER DOCUMENTATION	
5.3.1	<p>Supplier shall furnish Three sets of bound copies of following documents:</p> <ul style="list-style-type: none"> a) Quality Surveillance Document. b) Design Documents. c) Operation & Maintenance manuals. d) Spare parts manual. 	

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5.3.1.1	Quality Surveillance document shall consist of Technical Specification of crane, Purchase Order copy, amendments if any, shipping release, packing list, approved quality assurance plan, test certificates for all raw materials, test certificates and performance test reports for bought out items, internal inspection report, assembly inspection report, joint inspection report, minutes of meeting, approved procedures for welding qualifications (WPS, PQR and WPQ) and NDT procedures (LPT, RT and UT) and finally load testing and functional test reports.		
5.3.1.2	Design documents shall consist of design calculations for mechanisms, structural members, swing calculation & verification for earthquake event and wind load and all as built drawings mentioned.		
5.3.1.3	<p>Operation & Maintenance manual</p> <p>Supplier shall provide operation and maintenance manuals for installation, operation and maintenance of all equipment. The instructions for use of spare parts recommended with special emphasis on trouble shooting. Maintenance schedule and its frequency shall also be included. Each manual shall consist of one set of above-mentioned approved as built drawings and catalogues / technical literatures for the bought out components.</p> <p>The manual shall include Electrical complete wiring details with detailed BOM, settings for the VFD etc.</p>		
5.3.1.4	The manuals shall be specific to the equipment supplied and shall not be general in nature.		
5.3.1.5	The supplier shall submit one preliminary copy of operation and maintenance manuals to the purchaser before submission of final actual manuals. One approved copy will be provided to the supplier for preparing final operation and maintenance manuals.		
6.0	PACKING, SHIPMENT AND DELIVERY		
6.1	PACKING	After carrying out the tests at manufacturing works as specified in this document, the crane shall be carefully disassembled into major sub- assemblies and then properly packed, crated and protected from damage during transport, transit and storage at site. The packing shall include adequate cushioning, blocking, bracing, skidding, hoisting and tie down provisions. All machined parts shall be protected with anti-rust grease. All electrical devices shall be sealed against dust and moisture or water, wherever applicable.	
6.2	SHIPMENT AND UNLOADING	Supplier shall be responsible for any damage to the equipment during transport, transit and storage equipment at the site. Transit insurance and unloading of equipment and its components at site /store is in supplier's scope. The supplier without any extra cost shall replace the damaged item and supply any short supply inside the intact package.	
6.3	PLACE OF DELIVERY	Delivery must not take place until the receipt of proper shipping release from Purchaser. Place of delivery is CWMF Stores, BARC, Kalpakkam, Kancheepuram dist, Tamilnadu 603102.	

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7.0	ERECTION AT SITE AND COMMISSIONING	
7.1	The supplier shall install the crane at SWMF, CWMF, BARCF, KALPAKKAM, as per specifications and drawings in consultation with purchaser's site representative. Supplier is advised to visit the site and get himself fully acquainted with all the conditions and procedures at site. Ignorance of site conditions shall, in no case whatsoever be the basis for claim for extra payment.	
7.2	<p>Temporarily electric power of 415 volts, 3 phase, 50Hz and 230 volts subject to the following conditions:</p> <p>a) The electric power will not be used for heating purposes.</p> <p>b) The purchaser shall meter the supply of power to the contractor at the points at which the supply is given. For this purpose, the contractor will be liable to pay the rent of meter at rates to be fixed by purchaser. If any dispute on accuracy of meter is raised by contractor, the meter under dispute shall be checked in the Standards laboratory of the State Government in Chennai and the meter replaced if required. No request for rebate on past consumption will be entertained, nor will any recovery be made on account of any excess consumption. The Fees levied by the Chief Electrical Inspector to the Government of Tamilnadu for testing the meter shall be collected from the Contractor.</p> <p>The purchaser may, at his discretion, replace any meter installed.</p> <p>c) The purchaser will supply this power to the Contractor at a point, which will be within 130 meter of the locations of the works.</p> <p>d) The contractor's temporary distribution system shall be subjected in every respect to the approval of the Purchaser and shall be so arranged as to avoid any interference with the operations of the other contactor at site.</p> <p>e) It shall be the responsibility of the Contractor to provide and maintain the complete installation on the load side of the supply with due regard to the safety requirements at site. All cabling and installations shall comply in all respects with the appropriate statutory requirement given in the following</p> <p style="padding-left: 40px;">i) Indian Electricity Act, 1910 (As amended)</p> <p style="padding-left: 40px;">ii) Electricity Supply Act, 1948 (As amended)</p> <p style="padding-left: 40px;">iii) Indian Electricity Rules, 1956 (As amended)</p> <p style="padding-left: 40px;">and shall be subject to approval of the Purchaser. Any expenses on the inspection required by an authorized inspector under the above regulations shall be borne by the Contractor.</p> <p>f) The power supply will also be regulated as per terms and conditions of supply of Tamilnadu Electricity Board.</p>	

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	<p>g) The contractor shall maintain the power factor at not less than 0.8, by installing, if necessary, at his own cost, suitable corrective devices, The contractor's failure to take up necessary action in this regard within a period stipulated by the purchaser may entail installation of the corrective devices by the purchaser at the contractor's risk and cost.</p> <p>h) The purchaser will not be liable for any loss or damage to the Contractor's equipment as a result of variations in voltage of frequency of interruption/ stoppage resulting in interruption/ stoppage of power supply for a continuous period not exceeding 24 hours, the contractor shall have no claim whatsoever against the Purchaser. For any power failure/ stoppage resulting in interruptions for continuous period exceeding 24hours, the contractor will be eligible for only reasonable extension of time and not for any compensation on this account.</p> <p>i) Purchaser will not be liable for any loss to the contractor arising from interruption, failure or stoppage of works and any attendant delays consequent upon such interruptions, failure or stoppage of power supply or variations in voltage or frequency.</p> <p>j) Electric energy drawn by the contractor for works will be charged at the rate of Rs.12 per KWhr plus Rs.100 fixed charges per month on the basis of actual consumption.</p> <p>After completion of the works, the contractor shall promptly dismantle the distribution and other facilities he may have erected, at his own cost.</p> <p>The contractor shall make his own arrangements for all the necessary tools and necessities required for the work.</p>	
7.3	Service water will be made available at one point at site free of cost.	
7.4	Contractor shall at his own cost, make arrangements for transport of his personnel to and from the site. Neither living accommodation for space for labor colony will be provided by purchaser. It shall be supplier's responsibility to make all accommodation arrangements.	
7.5	For arranging temporary entry passes to their workers for unloading/erection/testings etc. at site the supplier will have to submit applications in prescribed format well in advance to purchaser's security section along-with their latest photographs, valid photo-identity proof (e.g. Voter ID, Aadhar, PAN, Passport, Driving License etc.) and Police verification certificate.	
7.6	<p>a) All material handling equipment, scaffoldings, tools and tackles etc. required for the erection work shall be arranged by the supplier.</p> <p>b) Supplier will have to provide safety wears/gadgets to all his staff working at site as per instruction of purchaser's safety officer. Arrangement of all the safety wears/gadgets such as safety shoes, helmets, safety belt, hand gloves etc. is in scope of supplier.</p> <p>c) The supplier shall employ his rigging staff for shipment of material to desired area. Safety procedures prevalent at site shall be complied in total and instruction in this regard from time to</p>	

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	<p>time by purchaser's engineer shall be followed in all respects.</p> <p>d) Supplier shall cooperate with other contractors for the use of purchaser's facilities. Insurance of supplier's personnel working at site for installation purpose shall be taken care of as per stipulation of Government of India.</p> <p>e) Purchaser shall not be held liable for any damage to person or property resulting from the use of construction tools and equipment furnished, rented or loaned to the contractors by the purchaser. Supplier shall take suitable insurance policy for the work-force engaged by him to work at site.</p> <p>f) Contractor shall be solely responsible for all injury to persons and for any other damage due to any cause in any way connected with carrying out this contract. Contractor shall indemnify purchaser in respect of all claims brought against the purchaser by anybody in this regard.</p>	
7.7	The supplier at all times shall work in coordination with purchaser's engineering staff and offer them all facilities to become familiar with the erection, operation and maintenance of the equipment. Contractor shall work in harmony with other contractors at site in such a manner to enable the other work to be performed without any hindrance.	
7.8	After installation the crane shall be commissioned by the supplier and handed to the purchaser in complete working condition. Before handing over the tests (full load test, overload test, travel limits, hook approaches etc.) as desired at site shall be carried out and demonstrated in presence of the purchaser's representatives. Inspection of crane shall be carried out as per latest edition of IS: 3177.	
7.9	Installation and commissioning of the complete crane at site shall be done as per the agreed time schedule between the supplier and purchaser. The complete responsibility for the installation and commissioning of the crane shall rest with the supplier.	
7.10	<p>The contractor shall at all times keep the site free from the accumulation of waste materials and debris and upon completion of the works shall clean away and dispose of all surplus materials, rubbish and temporary works of whatsoever nature and kind as directed by the purchaser and shall leave the works and site clean and tidy.</p> <p>The contractor shall be responsible for the taking of all safety precautions during the construction and on completion of the works and for leaving the site safe at all times and at the end of each working day and at all times when the work is temporarily suspended he shall protect all construction materials, equipment and facilities from causing damage to existing property or interfering with the operations of the facility when it goes into service.</p> <p>The contractor shall comply with all applicable provisions of the safety regulations, clean-up program and other precautionary measures which the purchaser has in effect at site.</p> <p>During erection of the various units, safety precautions such as providing ladders for safe approach shall be provided by the contractor. A safety supervisor will be stationed on the works and the contractor shall comply with any instruction given by the safety supervisor regarding safety, precautions, and protective measures, clean up and any practices with which in the opinion of the safety</p>	

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	supervisor may present unavoidable hazard.	
8.0	<p>CLEANING, PROTECTION AND PAINTING : All exposed surfaces other than machined surfaces, shall be sand blast cleaned to fine surface as per IS 1477. Casting shall be properly smoothed before painting. All oils and grease shall be removed by solvent cleaning. Sand blast cleaning of the surfaces shall remove completely all visible mill scales, rust, old paint & foreign matter. All treated surfaces shall be cleaned before application of paints. After cleaning and drawing, all surfaces except finished and machined surface and inside the gear cases shall receive two coats of epoxy primer. Final two coats of 3 mill thick. All exposed metal surfaces shall be protected from environmental effects. All parts except motors, resistors, gears thruster etc shall be painted in three layers. First layer of coating shall be done with Zinc-Chromate Epoxy primer (50 micron). Second Layer of coating shall be done with Coal tar Epoxy (100 micron) and third layer of coating shall be done with glossy Polyurethane UV resistant paint (100 micron)in golden yellow color. All the painting material shall be from reputed company.</p> <p>Interior of all gearbox housing shall be give one coat of rust inhibitor. Final painting of all equipment and structures shall be done by Supplier. Internal painting of all panels shall be semi-gloss white with external painting semi- gloss light grey. Before the equipment is closed they shall be carefully checked to be sure that all extraneous matters such as rags, rubbish, foreign matter etc. have been removed. After the interior is cleaned and dried opening shall be closed with cap to prevent entry of water, dirt or any other foreign matter.</p>	
9.0	<p>GUARANTEE: Supplier shall guarantee that the goods furnished by him shall be in full accordance with the requirements of the specifications and are new and of high quality.</p> <p>Supplier shall also provide the guarantee that the goods are free from defects in design, materials or workmanship.</p> <p>The supplier shall indicate clearly the terms covered under guarantee / warranty and its period from the date of satisfactory commissioning and handing over of the crane.</p> <p>The guarantee /warranty shall cover for a period of 18 months from the supply or 12 months from the date of satisfactory commissioning and handing over of the crane to the purchaser at site whichever is earlier.</p>	
10.0	<p>DELIVERY PERIOD: The equipment should be manufactured, tested, supplied, erected and satisfactorily commissioned at site within 12 months from the date of issue of purchase order.</p> <p>Supplier should submit the detailed schedule along-with the bid as per the format at enclosed annexure-C</p>	

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11	QUALIFICATION CRITERIA FOR THE BIDDER	
11.1	The bidders who have experience for design; manufacturing supply and installation of gantry crane with minimum 20 Te crane capacities are eligible to submit their bid. Copies of purchase order/ work orders of cranes (at least 3 nos.) supplied in past 5 years in support of confirmation of technical specification.	
11.2	The bidder shall have organizational structure with respect to design, drafting, engineering planning, and procurement manufacturing/production and quality assurance. An organization chart shall be submitted.	
11.3	Annual Turn-over of the bidder in last three financial years (average) ending 2019-20 shall not be less than the Rs. 1,09,00,000/- of the equipment. Firm should not have incurred any loss in more than two years during the last five financial years.	
11.4	The firm should not be under liquidation, court receivership, or similar proceedings. A self-certified statement by the firm should be furnished.	
11.5	Outsourcing for manufacturing the equipment to the value of 30% is permissible with prior approval. Outsourcing of components should be detailed out during the bid.	
11.6	Past experience/ performance of vendor with DAE/BARC/ PSU/ Govt. Sector shall also be considered during evaluation.	
11.7	BIDDER EVALUATION FORM: - Bidder evaluation form is enclosed as annexure- B. Bidder will have to submit filled form along-with their bid.	
12.0	CONFIRMATION/ DEVIATION STATEMENT: Last column of this technical specification sheet is to be filled by the bidder and is to be submitted along-with the bid. Confirmation to the specifications or deviations should be clearly mentioned. Technical data of the equipment being offered should be mentioned wherever applicable. Make of brought out items should also be mentioned. Separate annexure may be attached if required.	

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ANNEXURE-A

QUALITY ASSURANCE PLAN- QAP

[NOTE:-This QAP is indicative only. Vendor will have to prepare the QAP fulfilling all the technical requirements of the technical specifications, drawings and relevant codes/standards for approval of purchaser]

QAP – Part-1 – For Structural Components

S. N.	Item	Type of checks/inspection	Quantum of check	Reference standard/ acceptance criteria	Format of record	Agency			Remarks
						P	W	R	
1	Drawings	Review of drawing	100%	Technical specifications	Approved drawings	V		C	
2	Material Identification								
2.a	Plates & rolled structural steels	1. Visual Identification 2. Dimensional checks 3. Chemical composition analysis 4. Mechanical properties analysis	100%	IS 2062:2011 Grade E250 A/B	Correlated Mill Test Reports or Lab. Test Certificates*	V		C	*Test reports/certificates should be from NABL accredited lab.
2.b	Welding consumables	1. Visual inspection 2. Chemical composition analysis	100%	IS 814	Correlated Mill Test Reports	V		C	
2.c	Fasteners	1. Visual inspection 2. Chemical composition analysis 3. Mechanical properties	100%	IS 3757	Correlated Mill Test Reports or Lab. Test Certificates*	V		C	*Test reports/certificates should be from NABL accredited lab.
3	Welding Process	1. Welding Procedure Qualification 2. Welding Performance Qualification	100%	ASME B&PV Sec IX and technical specification	Approved WPS, PQR and WPQ	V	C	C	

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4	NDT procedure	Review of NDT procedures to be carried at different stages (VT, LPT, RTetc.)	100%	Technical specification and ASME B&PV Sec V	Approved NDT procedures	V		C	
5	Marking, cutting and Dimensional checks	Visual inspection and dimensional measurements	100%	Technical specification and approved drawings	Inspection reports	V		C	
6	Weld joints	<ol style="list-style-type: none"> 1. Visual fit-up check 2. VT and LPT after root pass for all welds joints 3. VT and LPT after each pass for all weld joints 4. RT of butt welds after final pass 	100%	Technical specifications and approved NDT procedures	WIR (Weld Inspection Report)	V		C*	*For reviewing the test reports for LPT and RT, purchaser's representative may re-conduct upto 3 % of the total quantity of each type of these tests at random in his presence at supplier's cost. If considerable discrepancy is observed in the test results found by purchaser's representative and the test reports submitted by the supplier then the supplier will have to repeat the test for full quantity in presence of purchaser's representative.
7	Stress Relieving	Review of HT charts	100%	IS-3177 and approved HT process	Reviewed HT charts	V		C	
8	Painting	<ol style="list-style-type: none"> 1. Visual inspection 2. DFT checks for each coat 	100%	Technical specifications	Inspection report	V		C	

LEGENDS:- P:- Perform, W:- Witness, R:- Review; V:- Vendor (Supplier) , C:- Customer (Purchaser)

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QAP – Part-2 – For Bought out items and other components

S. N.	Item	Type of checks/inspection	Quantum of check	Reference standard/ acceptance criteria	Format of record	Agency			Remarks
						P	W	R	
1.0	Bought out components	Review of list containing details of bought out items	100%	Technical specifications and approved design documents	Approved list of bought out items	V		C	
2.0	Wire ropes	1. Visual examination 2. Dimensional checks 3. Mechanical properties analysis	100%	IS 2266 and approved design documents	Correlated Mill Test Reports or Lab. Test Certificates*	V		C	*Test reports/certificates should be from NABL accredited lab.
3.0	Wire rope drum								
3.1	Raw material identification	1. Visual Identification 2. Dimensional checks 3. Chemical composition analysis 4. Mechanical properties analysis	100%	ASTM A106 Gr. B for pipe and IS 2062:2011 Grade E250 A/B for plate	Correlated Mill Test Reports or Lab. Test Certificates*				*Test reports/certificates should be from NABL accredited lab.
		UT of pipe/plate	100%	Technical specification and approved UT procedure	UT report	V		C	
3.2	Weld joint inspection (For welded rope drum)	1. VT and LPT after root pass 2. VT and LPT after each pass 3. RT after final pass	100%	Technical specifications and approved NDT procedures	WIR (Weld Inspection Report)	V		C	
3.3	Dimensional checks	Visual examination and dimensional checks	100%	Approved design and IS 3177	Dimensional check reports	V		C	
4.0	Sheave	1. Visual examination 2. Dimensional checks	100%	IS 3177	Dimensional check reports	V		C	

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		1. Chemical composition analysis 2. Mechanical properties analysis	100%	IS 2707	Mill Test Reports or Lab. Test Certificates	V		C	
5.0	Hook	1. Visual examination 2. Dimensional checks	100%	IS-15560 or IPSS	Dimensional check reports	V		C	
		1. Chemical composition analysis 2. Mechanical properties analysis	100%	IS-1875 Class 3A (high tensile forged steel) or 20Mn2 for IPSS	Mill Test Reports or Lab. Test Certificates	V		C	
		1. MPT 2. UT	100%	Technical specification and approved NDT procedure	MPT and UT report	V		C	
6.0	Bearings	1. Visual examination 2. Dimensional checks 3. Review of TC	100%	Technical specification and manufacturer's catalogue	Manufacturer's TC	V		C	
7.0	Coupling	1. Visual examination 2. Dimensional checks	100%	Technical specification and manufacturer's catalogue	Manufacturer's TC	V		C	
8.0	Shafts & Axles	1. Visual examination 2. Dimensional checks	100%	Technical specifications, approved design,	Dimensional check reports	V		C	
		1. Chemical composition analysis 2. Mechanical properties analysis	100%	BS 970 (EN8 or EN9) or better material as per approved design	Mill Test Reports or Lab. Test Certificates	V		C	
		1. UT	100%	Approved UT procedure	UT report	V		C	
		Heat treatment	100%	Technical specification and Approved HT procedure	Reviewed HT charts	V		C	

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9.0	Gear Boxes								
9.1	Gears & pinions	1. Visual examination 2. Dimensional checks	100%	Technical specifications and manufacturer's catalogue	Dimensional check reports	V		C	
		1. Chemical composition analysis 2. Mechanical properties analysis	100%	BS 970 (EN19 for gear EN24 for pinion) or better material as per approved design	Mill Test Reports or Lab. Test Certificates	V		C	
		1.UT	100%	Manufacturer's UT procedure	UT report	V		C	
		Heat treatment	100%	Manufacturer's HT procedure	Reviewed HT charts	V		C	
9.2	Gear box shafts	1. Visual examination 2. Dimensional checks	100%	Technical specifications and manufacturer's catalogue	Dimensional check reports	V		C	
		1. Chemical composition analysis 2. Mechanical properties analysis	100%	BS 970 (EN8 or EN9) or better material as per approved design	Mill Test Reports or Lab. Test Certificates	V		C	
		1.UT	100%	Manufacturer's UT procedure	UT report	V		C	
		Heat treatment	100%	Manufacturer's HT procedure	Reviewed HT charts	V		C	
9.3	Gearbox housing	1. Visual examination 2. Chemical composition & Mechanical properties analysis	100%	Manufacturer's catalogue and technical specifications	Manufacturer's TC	V		C	
9.4	Gearbox assembly	1. Visual examination 2. Checks for speed reduction ratio, temperature, noise & vibration at no load	100%	Manufacturer's catalogue and technical specifications	Manufacturer's TC	V		C	

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10.0	Wheels	1. Visual examination 2. Dimensional checks	100%	IS-3177	Dimensional check reports	V		C	
		1. Chemical composition analysis 2. Mechanical properties analysis	100%	BS-970 (EN9) or equivalent IS code	Mill Test Reports or Lab. Test Certificates	V		C	
		UT	100%	Technical specification and approved NDT procedure	UT report	V		C	
11.0	Electric Motors								
11.1	Hoist Motors	1. Visual examination 2. Routine test 3. Type test	100%	Technical specifications and manufacturer's catalogue	Routine test and type test reports	V	C	C	
11.2	Other Motors	1. Visual examination 2. Routine test 3. Type test	100%			V		C	
12.0	Brakes	1. Visual examination 2. Review of manufacturer's TC	100%	Manufacturer's catalogue	Reviewed TC	V		C	
13.0	Rotary Components (Wheels, sheaves, shafts and brake drums)	Balancing	100%	Balancing grade 2.5 as per ISO 1940	Balancing certificate	V		C	

LEGENDS:- P:- Perform, W:- Witness, R:- Review; V:- Vendor (Supplier) , C:- Customer (Purchaser)

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QAP – Part-3 – For Fully assembled crane

S. N.	Item	Type of checks/inspection	Quantum of check	Reference standard/ acceptance criteria	Format of record	Agency			Remarks
						P	W	R	
1	Verification of completeness of earlier stages of inspection	Review of QA documents	100%	Technical specifications, QAP Part-1 &2	Verified history docket			C	
2	Main girder, end carriages, trolley, MH, AH, LT & CT drive assemblies, MH, AH, LT & CT gear boxes,	Visual inspection and Dimensional checks	100%	Technical specifications & approved drawing	Dimensional check reports				
		Speed checks-LT & CT wheels (forward/reverse)	100%	Technical specifications, manufacturer's catalogue and name plate details	Inspection report	V	C		
		Speed checks-MH & AH (upward/downward)							
		MH, AH, LT & CT drive assemblies							
		MH, AH, LT & CT Brakes operation							
No load currents for MH, AH, LT & CT in clock-wise & anti clock-wise motions									
3	Fully assembled	Load test & deflection tests with no load, intermediate loads and SWL	100%	Technical specifications	Test reports	V	C		
		Overload test							
		Load currents for all motors LT, CT, MH, AH operations including speed measurements with SWL		Technical specifications and motor's name plate details					
4	As built drawings	Review of all the as built drawings	100%	Technical specifications	Approved as built drawings	V		C	

LEGENDS: - P: - Perform, W: - Witness, R: - Review; V: - Vendor (Supplier), C: - Customer (Purchaser)

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ANNEXURE B				
BIDDER EVALUATION FORM				
<p>Notes :</p> <ul style="list-style-type: none"> • The form shall be completed in all respects by the bidder. Comments/remarks like “already given with the tender” or “details shall be on receipt of order” etc. are not acceptable. • Bidder shall obtain solvency certificate from his banker and attach with this form. If the bidder has more than one banker, a separate solvency certificate from each banker shall be submitted. • If space is not sufficient, bidder may give additional information on separate sheets. 				
1.	Vendor’s Name			
2.	Quotation No. & Date			
3.	Equipment Offered	Tendered item		
4.1	Product(s) Manufactured by the Bidder			
4.2	Product(s) Marketed by the Bidder			
5.	Registration Details (With Registration Number)			
6.	Works Premises Owned By or Rented in Name Of :			
7.	Nature of Organisation (Proprietary/Partnership/Pvt.Ltd./Public Ltd./others)			
8.	Date of incorporation (include all details in case of sister organization, if any)			
9.	Top Management (Names, Qualification, Position and Experience)			
	Name(s)	Qualification	Position	Experience

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10.	Performance of Preceding three years with profit and loss. (also indicate anticipated performance for current year)			
	Year	Capital (Authorised / Working)	Turnover	Net Profit/Loss
	Yr-1			
	Yr-2			
	Yr-3			
	Yr-4			
	Yr-5			
	Note: Copies of Annual Reports/Profit & Loss Accounts for periods mentioned above must be enclosed for reference.			
11.	Name of Banker(s) with full Address, Fax. No. & Tel. No.			
12.	Value of Solvency Certificate(s) issued by Banker(s). The certificate(s) shall be latest ones (Value not less than 40% of the estimated cost, issued not earlier than one year from the date of starting of sale of tender)			
	The Bidder shall obtain Solvency Certificate from each of firm's banker and submit the same to the Purchaser.			
13.	Year of Starting the Factory			
14.	Year of Starting Manufacture of Equipment indicated in the Tender			
15.	License/Contract Details			

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16.	Sub contract details for any of the parts of crane					
17.	List of Key Department <i>(Enclose organization chart for reference)</i>					
18.	Staff Details					
	Graduate Engineers	Diploma Holders	Supervisors Trained/Skilled Operators	Unskilled Operators	Others (Specify)	
	Design & Drawing					
	Production Planning & Control					
	Fabrication & Metal Finish					
	Quality Control & Testing					
	Sales					
	Others (Specify)					
	TOTAL					
Note : In case of common staff for various departments, indicate the same as common staff						
19.	Details of Facilities Available					

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19.1	Office Area :			
19.2	Works Area (s) : If manufacturing facilities are at more than one place, details of each works shall be separately given			
	Addresses of Works	Covered Area	Uncovered Area	Total Plot Area
19.3	Design & Drawing Office Facilities Available : (Give details)			
20.	Details of Fabrication facilities: It shall include list of machines, equipment etc. available, No. and details of welding sets, No. and details of qualified welders:			
20.1	Quality Control and Testing Facilities Available : (Specifications & other details of the Equipments, machines & Facilities, available at Works and Quality Assurance Plan shall be given separately)			
20.2	Quality Assurance Plan followed : Note: Enclose QAP followed in respect of the equipment specified in the tender. (Ignore if already furnished.)			

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20.3	Tie Up with Testing Agencies/Laboratories and details of tests carried out:	
	Type of Tests/ Qualifications	Address of Testing Agencies/Laboratories with FAX & Tel Nos.
	Physical	
	Chemical	
	Radiography	
	Ultrasonic	
	Welder Qualification	
20.4	Facilities available for Load Testing of Crane	
21.	Documentation: (yes/no)	
	<ul style="list-style-type: none"> (a) Reference standards specific to tender enquiry (b) Plant standards availability with each departments duly updated (c) Drawing availability for purchaser's retention (d) Procurement of materials with emphasis on test certificates for purchaser's verification (e) Availability of inward inspection (f) Availability of process inspection (g) Availability of final inspection 	

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22.	Work Experience:					
22.1	The BIDDER shall furnish here a list (as per format given hereunder) of similar capacity crane manufacturing &/ erection jobs executed by him to whom a reference may be made by the PURCHASER in case the PURCHASER considers such a reference necessary.					
22.2	Give a list of similar jobs executed in the recent past for the Govt. organization especially that of Department of Atomic Energy. (as per format given hereunder)					
	S. N.	Name of the Client	Details of Gantry Cranes supplied (20 T & above)	Value of Order	Year & Period of Job execution	Name, address, Tel. & FAX No. of the officer of the client to whom reference may be made by the Purchaser.
23.	List of Gantry Cranes/E.O.T. Cranes under manufacture at vendor's works at present					
Sl. No.	Details of Cranes under manufacture		Client's address, Fax.No., Telex No., Phone No.			Remarks
Signature : Name of the Officer : <u>Company Seal</u>						

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ANNEXURE C:		
BIDDER'S TIME SCHEDULE FOR MANUFACTURE, SHIPMENT TO SITE, ERECTION AND COMMISSIONING OF CRANE		
The BIDDER shall indicate the time schedule for the following key events from the date of issue of Letter of Intent/Purchase Order.		
	Particulars of Activities	TIME REQUIRED
1.1	Design of crane, preparation & submission of design drawings, design calculations and data.	
1.2	Preparation of additional shop drawings if any, submission of the same to the purchaser for information and comments if any. (It shall be the responsibility of the supplier to satisfy himself that any such additional drawings prepared by him satisfy all the design requirements as indicated in the purchaser's drawings and tender specification.)	
1.3	Time required for manufacture of the crane, including procurement of major items for the crane after clearance/approval of the drawings/items by the Purchaser and making the entire equipment available for testing at the manufacturer's workshop	
1.4	Testing of the crane & major items at the manufacturer's works.	
1.5	Start delivery to Site of Structures/Equipment	
1.6	Completion of delivery of Structures/Equipment	
1.7	Start of erection	
1.8	Mechanical erection of crane	
1.9	Completion of Electrification of crane.	
2.0	Performance tests in the Purchaser's premises.	
2.1	Time required for submission of all as built drawings and manuals.	
We, the undersigned hereby undertake to meet the above time schedule from the date of issue of Letter of Intent/Purchaser Order.		
SIGNATURE :		
DESIGNATION :		
COMPANY :		
SEAL OF COMPANY	DATE :	