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NORTHERN RAILWAY

Section-I

SPECIFICATION FOR CNC UNDER FLOOR WHEEL LATHE (BG)

IMPORTANT FEATURES OF THE TENDER

1. INSTRUCTIONS TO TENDERERS FOR FILLING TECHNICAL BID

- 1.1 Unless otherwise stated, latest alterations/ revisions of specifications/ standards/ drawings shall be applicable. In respect of safety standards and environmental standards relevant to the machine, the machine manufacturers shall ensure compliance with International (CE/ISO/DIN/JIS)/National standards (IS) (wherever applicable).
- 1.2 Tenderers should offer and quote for all the specified concomitant accessories, as these are considered essential for commissioning and utilization of the machine. Even if bidder does not recommend the purchase of any of these accessories, the price must be quoted for comparison purposes and their recommendation/suggestion to be indicated in the offer. Tenderers should also quote for optional accessories, spares and consumable spares as asked in the specifications.
- 1.3 In case, any item is required in sets, please specify nos./pieces per set. This is essential for proper technical evaluation of the offer. Offers received without this may be considered as incomplete and liable to be rejected.
- 1.4 The bidder should quote only for the specified make of sub-assemblies and equipment wherever specified. Makes of sub-systems other than the specified ones will normally not be acceptable. In case, some other make is quoted, specific reasons for the same including its features/advantages over specified makes must be brought out in the offer.
- 1.5 In case there is a contradiction in any information provided (some parametric values given in the specification and those given in the brochure or some other document enclosed by the tenderer), unless specifically mentioned, the value as given in specification shall be taken as confirmed by the tenderer and offer evaluated accordingly.
- 1.6 Bidder or his authorized agent, in their own interest, should visit the consignees listed in clause 3 Section-I with prior appointment with Controlling Officer and acquaint themselves with existing process of manufacturing/remanufacturing, site conditions, availability of crane facility etc.
- 1.7 The Purchaser may accept internationally accepted alternative specifications which ensure equal or higher quality than the specifications mentioned in the Technical Specification. However, the decision of the Purchaser in this regard shall be final. A copy of the alternative specifications offered should be sent along with the offer. The Tenderer should also furnish "Statement of Deviations" from tender specifications (as per Annexure -A, Section-III) along with the offer.
- 1.8 The new stock of Locos/ Coaches can be seen at following places:

WDG4/WDP4 locomotives	:Diesel Loco Shed, South West Railway, Hubli
WAG9/WAP5 locomotives	:Electric Loco Shed, Ghaziabad, Northern Railway
WDM3A/WDG3A locomotives	:Diesel Loco Shed, Northern Railway Tughlakabad
LHB Coaches	:Coaching Depot, New Delhi
Train 18 Coaches	:Train Set Depot, Shakurbasti

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कार्यालय, उ०रे०
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2

DESCRIPTION:

CNC Under Floor Wheel Lathe as per specification no. **NR/MECH/CNC-UFWL (BG)/WITH WORKS/2024(Rev-00)** is required as per main features and description of tender requirements in Section-I & technical specification in Section-II for re- profiling of wheel sets of Broad Gauge (BG) Diesel & Electric Locomotives, diesel & electric multiple units, coaches and wagons without removing the wheel sets, bogie brake gear, axle box covers or any other components of the locomotives/coaches/ wagons as per drawings mentioned in Annexure-F of section-III. Re-profiling simultaneously at both ends, independent wheel sets with inboard or out-board journals by means of suitable hold-down device. Machining of inside faces of the wheel in continuation to profile turning of the tread & flange.

2.1 The machine shall have following configuration:

2.1.1 The machine shall consist of hauling system, lifting & positioning system, drive system, measuring system, cutting depth determination system, tread profile machining system swarf disposal system, tooling system, lubrication system, hold down device etc.

2.2 **LEADING PARAMETERS**

2.2.1 **MAJOR PARAMETERS:**

2.2.1.1	Track gauge	1676 mm
2.2.1.2	Cutting speed (infinitely variable)	15 to 120 m/min
2.2.1.3	Feed (infinitely variable)	0.1 to 2 mm/rev.
2.2.1.4	Axle load	8 to 25 tonnes
2.2.1.5	Tread diameter	700 to 1250mm

2.2.2 **JOB PARAMETERS**

2.2.2.1	Width of vehicle	3660mm (max.) Refer drawing no. COFMOW/UFWL/BG/2007 Sheet 1 of 7.
2.2.2.2	Wheel gauge (distance between inner faces of flanges)	1595 to 1602mm
2.2.2.3	Width of tyre	125 to 140mm
2.2.2.4	Distance between axles of vehicle	1600mm
2.2.2.5	Axle length	1889 to 2750mm

2.2.3 **OTHER PARAMETERS**

2.2.3.1	Power supply	415V+10% to - 20%, 50Hz+/-3%
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Note: No deviation shall be permitted against Major Parameters.

2.3 **PERFORMANCE STANDARDS:**

- 2.3.1 Re-profiling in-situ simultaneously at both ends without any interruption in a single setting old work hardened and new wheel set as per drawings mentioned in Annexure-F of Section-III of broad gauge Diesel & Electric Locomotives, diesel & electric multiple units, coaches and wagons without removing the wheel sets, bogie brake gear, axle box covers or any other components of the locomotives/coaches/ wagons.
- 2.3.2 Re-profiling simultaneously at both ends, independent wheel sets with inboard or out-board journals by means of suitable hold-down device.
- 2.3.3 Machining of inside faces of the wheel in continuation to profile turning of the

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tread & flange.

2.3.4 Surface Finish and Accuracy:

The machine shall be capable of re-profiling wheel sets to the following standards during the finish cut:

- 2.3.4.1 The circumferential eccentricity of tread diameter on any wheel shall not exceed 0.3mm.
- 2.3.4.2 The difference in tread diameter of two wheels on the same axle shall not exceed 0.3mm.
- 2.3.4.3 The inaccuracy of profile reproduction shall not exceed 0.2 mm when measured with a standard profile gauge.
- 2.3.4.4 Surface finish of the machined wheel shall be 20 microns (Ra) or better.
- 2.3.5 A suitable load-meter to indicate load on the machine shall be provided. The load-meter shall have an indication to indicate the maximum load the machine can take.
- 2.3.6 **Noise Level:** Noise level of the machine under full load shall not exceed 85 dB when measured at a distance of 7 meters from the machine in free field conditions as per IS: 4758-1968 and ISO test code 230 part-5.
- 2.3.7 Working in normal Indian Railway environment with temperature up to 50 degree C and relative humidity upto saturation.

2.4 CYCLE TIME:

- 2.4.1 The machine claimed cycle time shall be proved for removal of 8 mm material radially (diameter reduction up to 16mm) in maximum two passes (two cuts) on normally worn out wheels. The claimed productivity shall be achieved with the accuracies as specified in clause no. 2.3 of section I for wheel tread dia. of at least 700mm or above. The exact sequence of operation including multiple cuts shall be explained in the offer.
- 2.4.2 The details of automatic mode of operation of machine during one complete cycle, should be indicated in the bid.
- 2.4.3 The basis of the timing should be clearly given with details of all the cutting parameters. The timing should be maintainable for regular 8 hours shift for double shift working six days per week with machine availability of 85% without affecting normal life and accuracy of the machine.
- 2.4.4 Using single operator the average cycle time for profile turning of one wheel set should not exceed 48 minutes. The cycle time offered shall include floor-to-floor machining time for all the activities including following:
- Hauling from edge of pit
 - Loading
 - Machine startup
 - Initial orientation and programming
 - Control panel operation
 - Pre-machining measurement
 - profile turning
 - Post-machining measurement
 - Unloading

The break-up of floor-to-floor cycle time indicating depth of each cut (rough &

finish cut) and cutting parameters shall be indicated in the bid. The average cycle time shall be calculated from the total cycle time taken for the machining of all (normally 6) wheel sets of the vehicle.

- 2.4.5 The machine shall be capable of turning wheels having tensile strength up to 110 Kg/mm². The tensile strength of work-hardened spots can be up to 125 Kg/mm². The machine using indigenously available throwaway carbide tools shall operate without vibrations or chatter at all loads.
- 2.4.6 A graph showing the depth of cut the machine capable of taking with a feed rate of 1mm per revolution, at different axle loads up to 25 tonnes shall be submitted in the bid for wheel material having tensile strength of 75, 90, 110 and 125 Kg/mm².

2.5 PROVE OUT AT FIRM'S PREMISES:

The machine is required to prove out to establish the claimed productivity as per clause 2.4. The proving out shall be done at inspection stage itself at supplier's premises for 02 (Two) nos. loose wheels sets as given in Annexure-F of Section-III.

The consignee will provide Min. 5 nos. wheel sets on returnable basis to the supplier on submission of Indemnity bond by firm for an amount to be indicated by the consignee. In case the wheel sets are not available with consignee, supplier may take similar wheel sets from the nearby Railway locations / Units on returnable basis against Indemnity bond. The supplier will collect the Loose wheels set at his cost and will be subject to provisions of clause 4100 of bid document Pt. I.

2.6 PROVE OUT AT CONSIGNEE'S WORKS:

- 2.6.1 The machine shall be prove out for complete profile machining of 02 (Two) nos. of loose wheel sets & any one stock of coaches/wagons

or

Any one stock of loco (Any type as per Annexure-F of Section-III) per 8 hour shift before commissioning.

The supplier shall demonstrate machine performance and prove out the claimed capability as a part of successful commissioning at the consignee's works as given in para 2.4 for a period of four 8 hrs. shifts.

After such successful demonstration as mentioned herein, the consignee shall take over and watch the machine performance for a period of one month, before the final proving test certificate is issued.

3.0 QUANTITY & CONSIGNEE:

S. N.	CONSIGNEE	QUANTITY REQUIRED	Specification No.
1	SSE(C&W)/BSB	One	NR/MECH/CNC-UFWL(BG)/WITH WORKS/2024(Rev-00)

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4.0

SCOPE OF SUPPLY:

4.1

The scope of supply shall include design, manufacturing, supply, installation, testing, commissioning and proving of machine on turnkey basis. It includes all the concomitant accessories/ equipments & concomitant works, required to make the machine fully functional when connected to a power source. It shall also include installation and commissioning of related equipment, training of personnel in operation and maintenance of machine and supply of technical documentation.

4.2

CONCOMITANT ACCESSORIES

4.2.1

The machine should be accompanied with the following concomitant accessories:

4.2.1.1

First fill of oils and lubricants.

: (Quantity of each item shall be indicated in the bid).

4.2.1.2

Electrical cables for connecting control cabinet to machine

: 10m

4.2.1.4

Retractable rails with their drive

: one set

4.2.1.5

Hauling device

: one no. each

Rail Cum Road Shunter and Winching Arrangement both are required

4.2.1.6

Toolings

: 2 nos. of tool holders and 50 nos. of tool inserts of each type including for brake disc machining.

4.2.1.7

Compatible voltage stabilizer (Ref. Cl.- 2.13.2 of Section-II)

: one no.

4.2.1.8

Compatible ultra isolation transformer (Ref. Cl.- 2.13.3 of Section-II)

: one no.

4.2.1.9

Hydraulic hold down device for outboard journals

: one set

4.2.1.10

Drive rollers (as spare in addition to those fitted on the machine)

: one set

4.2.1.11

Conveyor type swarf disposal system

: one set

4.2.1.12

Electrostatic oil filtration equipment (Ref. Cl 1.2.10 of section-II)

: one no.

4.2.1.13

Checking gauges for all wheel profiles mentioned in the drawings as per Annexure F of Section-III

: one set

4.2.1.14

Pumping unit with motor for clearing accumulated water inside pit

: one unit

4.2.1.15

Brake disc machining arrangement for LHB wheel sets. (As per clause 1.2.7.6 of Section-II)

: one set

4.2.1.16

Chip Crusher (As per clause 1.2.12.2 of Section-II)

: one set

4.2.2

Concomitant works :

4.2.2.1

The scope of supply shall also include the following concomitant works. The cost of these works shall be quoted separately and the cost shall also be included for the purpose of commercial evaluation.

4.2.2.1.1

Construction of covered shed for housing under floorwheel lathe (Ref. Cl. 1.2.15 of section-II)

Applicable for BSB consignee

4.2.2.2

Linkage of track (Ref. Cl. 1.2.16 of section-II)

4.2.2.2.1

Inside shed (for shed size Ref. cl.1.2.15.3 of section-II)

As required

4.2.2.2.2

Outside shed (ref. Cl.1.2.16.2 of section-II). Bidder shall furnish the rate in respect of track linkage per meter of length basis.

: 500 meters (Max.)

4.2.2.3

Power supply connection (Ref. Cl. 1.2.17 of section-II) Bidder shall furnish the rate in respect of per meter of length basis.

: 500 meters (Max.)

Note:

Concomitant works as described in clauses 4.2.2.2, 4.2.2.2.1, 4.2.2.2.2 and 4.2.2.3 above.

4.3

OPTIONAL ACCESSORIES:

4.3.1

Following optional accessories will be quoted by the tenderer. Cost of optional accessories shall be quoted separately and shall not be included in the basic price of the machine. Cost of optional accessories will not be taken for commercial evaluation of the firms.

4.3.2

Firm should also quote charges for modification in software for any other profile, not specified in the tender, on each profile basis for future requirement, due to amendment in wheel profile drawings at later stage

4.3.3

Suitable device for turning of wheel sets of the locomotives with coupled axles as stipulated in the COFMOW's drawings described at S. No (B), items 5 & 6, of Annexure- F of section -III shall be quoted as optional accessory. Distance between coupled axles may vary from 1500 to 2650 mm. Details of the device and its working procedure shall be explained in the bid.

4.3.4

Measurement system for the running wheel set.

Measurement system for the running wheel set shall be installed on the line feeding the rolling stock to the CNC Under Floor Wheel Lathe. This will enable the non-contact laser based pre-measurement of all the wheels of rolling stock before it reaches CNC Under Floor Wheel Lathe. This will result in identification of the proper wear and diameter of all the wheel sets of the rolling stock. This data will be directly uploaded to the CNC system of Under Floor Wheel Lathe to enable wheel set re-profiling in proper order. System shall enable measurement of following parameters of all the wheel sets when the rolling stock is moving at a speed of max. 10 KMPH.

- 4.3.4.1 Diameter of both the wheels of wheel set within ± 1.5 mm.
- 4.3.4.2 Flange thickness of both the wheels of wheel set within ± 0.25 mm.
- 4.3.4.3 Flange height of both the wheels of wheel set within ± 0.25 mm.
- 4.3.4.4 Distance between inside faces (back to back distance) of two wheels of wheel set within ± 0.5 mm.

Details of system shall be explained in the offer.

4.3.5

Chip Compactor - 1 no.

Heavy duty chip compactor shall be considered for compacting the chips generated from CNC Surface Wheel Lathe to final bale size of approximately 8" X 8" X 10" to 12".

4.3.6

Connection of drainage line from under floor wheel lathe shed to nearest point of existing drainage line of shed/depot/unit. Rate should be quoted on per meter basis.

4.3.7

Operation of CNC Under Floor Wheel Lathe as per clause 1.2.20 of Section-II

4.3.8

Any accessory which can improve the productivity, performance, reliability, efficiency, or enhance the capability of the machine as a whole or part thereof, should be quoted as optional accessory.

5.**EVALUATION CRITERIA:**

5.1

Cost of the basic machine.

5.2

Cost of the concomitant accessories according to tender specifications.

5.3

Cost of any other accessory which in the opinion of supplier is essentially required for making the machine fully functional.

5.4

Cost of Turnkey Charges viz. foundation, installation & commissioning etc.

5.5

Cost of concomitant works according to tender specifications.

5.6

Cost of Preventive Maintenance during 1st & 2nd year of Warranty Period.

5.7

Cost of comprehensive AMC for five years after the warranty as per clause 17 of Section -II.

5.8

Duties and taxes as quoted by the bidder, insurance and freight

6.0**OTHER ITEMS TO BE QUOTED:**

The following items need to be quoted additionally though these will not be part of commercial evaluation:

6.1

Optional accessories with break up of individual items as specified in clause 4.3 of Section-I

6.2

Consumables as per clause 6 of Section-II with break up of individual items as applicable.

Sr. DME/C & W/LKO.

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7.0

DELIVERY SCHEDULE CHART:

In the event of acceptance of the offer, the machine(s) shall be supplied as per the following Milestone Chart:

NAME OF MACHINE: CNC UNDER FLOOR WHEEL LATHE

SPECIFICATION NO. : NR/MECH/CNC-UFWL(BG)/WITH WORKS/2024(Rev-00)

SN.	Activity	Activity Code	Outer Limit of Time Schedule expected by NR
1.	Issue of LOA	D1	-
2.	Submission of PBG By Successful Bidder	D2	D1+ 4 weeks
3.	Issue of AT / PO by NR (after verification of PBG)	D3	D2+30 days
4.	Opening of LC by NR (for foreign suppliers)	D4	D3+30 days
5	Submission of GA drawings and requisition for the trial component (s) (if applicable) to consignee by Successful Bidder/Supplier along with information on power and other utilities required for machine.	D5	D3 + 45 days
6.	Approval of GA drawings by consignee (to be governed by clause 11.2 of section-II) and confirmation of availability of components to be proved out at manufacturer premises and value of BG required for providing prove out components.	D6	D5+ 45 days
7.	Confirmation of availability of clear site by consignee	D7	By D6 (i.e. at the time of approval of GA drg.)
7.1	Construction of shed, linkage of track, power supply connection by supplier (as applicable for the consignees)	D 7.1	D7+210 days
8	Completion of foundation	D8	D7.1+150 days or latest by D 10
9	Submission of BG and collection of components from consignee by the supplier for prove out of machine at manufacturer's works.	D9	<u>D6 + 60 days</u>
10	Supply/ Delivery of machine (for foreign suppliers on FOBbasis)	D10	<p>For First machine: D4 + 210 days Or D7 + 210 Days (whichever is later)</p> <p>Thereafter subsequent machines: @ one machines per month Indigenous portion of supply (if any) For first machine D7 + 210 days Or receipt of machine at site whichever is later Thereafter subsequent machines: @ one machines per month</p>

Signature Not Verified
Sr. DME/C & W LKO.
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	Supply/ Delivery of machine(for indigenous suppliers)	D10	For First machine: D7 + 210 days Thereafter subsequent machines: @ one machines per month
11	Power connection for the machine and other on siterequirements to be provided by railways	D11	D10 + 7 days
12	Railway to give call to supplier for the commissioning of machine	D12	D10 + 7 days
13	Installation, commissioning and proving out of machine by supplier	D13	D11 + 90 days D12 + 90 days (whichever is later)
14	Issue of PTC by consignee	D14	D13 + 30 days
15	Warranty by supplier	D15	D13 + 2 years
16	AMC	D16	D15 + 5 years

Note:

Notwithstanding the delivery period indicated elsewhere in the tender document, the delivery indicated in this schedule shall be taken as overriding and final.

8.0**Payment terms for Concomitant Works (Covered Shed, Linkage of Track and Power Supply Connections):**

Payment for construction of covered shed, Linkage of track and power supply connections shall be claimed by the contractor, consignee-wise, as follows:

- 75% Payment of the cost of all taken together (Covered Shed, Linkage of Track and power supply connections), will be made on the issue of completion certificate by the consignee and receipt of machine at site.
- 15% Payment of the cost will be made upon issue of PTC for the respective Under Floor Wheel Lathe.
- Balance 10% shall be released on submission of Final Acceptance Certificate, No Objection Certificate (NOC) & No Claim Certificate (NCC) issued by consignee and submission of Bank Guarantee of 10% as Warranty Bank Guarantee (WBG).

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