

रेल डिब्बा कारखाना, कपूरथला

MD44121

Date: 02.03.2023

Sub: Minimum infrastructural requirement for manufacture of Cross Section of FIAT bogie (PL No. 33502006).

Ref: Dy. CME/DP letter no. MD34331 dated 01.03.2023.

General:		
#	Requirement	Remarks
1	Firm shall have valid latest ISO 9001 certification.	
2	Firm shall have valid certification as per ISO-3834 or EN15085.	
3	Firm shall have adequate covered shed for manufacturing of Cross Section and for storage of raw materials underneath.	
4	Firm should have certified welder. Welder qualified with ITI or equivalent qualification and certified as per EN-287 or ISO9606-1 or latest shall only be deployed.	
M&P Facilities:		
1	Plasma or LASER profile cutting machine with minimum capacity to cut plates up to thickness of 15 mm.	
2	CNC-HMC/ CNC-VMC/ CNC-Boring Machine capable of performing operations at distance of 890mm X 440mm as mentioned in the relevant drawing in single setting only .	
3	Degreasing/ De-rusting facilities for cleaning of raw material.	
4	Hydraulic press/ Press brake of minimum 50 tone capacity.	
5	MAG welding set (400A or more) & shielding media: mixture of 82% Argon and 18% CO ₂ Filler material to be used as per specification no. EN440-G3Si1.	
Testing Facilities:		
1	Measuring instrument required for measurement of dimensions of item.	
2	Level surface plate of suitable size.	
3	Welding gauges.	
4	Digital surface roughness tester.	
5	Digital dry film thickness tester.	
6	DPT facility	
7	<p>Chemical & physical testing:</p> <p>Firm shall have following infrastructure in-house OR Tie-up with NABL approved lab:</p> <p>a) Spectro-analysis facility to check chemical composition.</p> <p>b) Hardness testing machine.</p>	

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SSE/BD

