

Fabrication and Supply of ISUPM, ISU400 & NIM400 Components**I. Scope of Work:-**

Material procurement, Process preparation, Pre machining, stress relieving, final machining, surface treatment, Inspection and supply of ISUM, ISU400 & NIM400 components.

II. Hard ware Details:-

SL. No	Item Description	Drawing No.	Qty (Nos.)
1	Housing for ISUPM	8201 82 01 01 & 01M	21
2	Housing for Electronics module ISU400	8204 03 01A 01	12
3	Housing for NIM400	8204 64 00 01	20

III. Prerequisite of the vendor:

1. Party must be a qualified vendor of IISU or any other ISRO centres which is executing precision machining operations successfully.
2. Party must comply that their facility is under regular quality/vendor audit by IISU or any other ISRO centre's quality team without any non-conformance.
3. Party must have:
 - ∇ High precision machining centre with positional accuracy of better than 0.01 mm.
 - ∇ Co-ordinate measuring machine with an accuracy of 0.002 mm or better.
 - ∇ Party shall have all facilities within the campus and cannot sub contract any of the machining operation/heat treatment.
 - ∇ Before placing the order, vendor evaluation will be done by IISU team for verifying the availability of machines and its accuracies.
 - ∇ Submit filled compliance sheet (format attached as Annexure-V) along with quotation. Quotation without filled compliance sheet will be rejected.
 - ∇ Surface Treatment should be done by the party or ISRO approved surface treatment facility.

IV. Terms and conditions:

1. Party has to procure the material as per the requirements (As mentioned in Annexure-II).
2. Party has to sent the copies of material test certificate to IISU for approval before starting fabrication.
3. Party should machine the item in all respects within the tolerance limits mentioned in the drawing.
4. Preparation of detailed fabrication and inspection process sheet for the above and submit to us.
5. Preparation of all required toolings, fixtures etc for fabrication.
6. Submit the process to us for approval.
7. After approval, fabricate the item with the identified materials.
8. Party has to maintain a foolproof system to control the material flow to avoid any type of mixing / change of raw material.
9. In all the taped holes tapping with 1st tap should be done in the machine itself before surface treatment.
10. Necessary helicoil thread inserts (free running type), with Stainless Steel Grade 304 (AS7245 – Austenitic Corrosion Resistant Steel) material, as per DIN 8140-1, should be purchased by party and insertion has to be done on the hardware as per drawing.
11. Before helicoil insertion, tapped holes have to be inspected and cleared by helicoil plug gauges.
12. Components have to be stress relieved after rough machining (Naturally stress relieving by keeping in stress free condition for 2 weeks)
13. Part supply of components is acceptable & payment will be done on pro date basis.
14. Items have to be surface treated as per drawing. Party has to submit the details of surface treatment as well as the facility details along with the quotation.
15. Identification number has to be engraved on the surface as given in drawing if required.

16. Items are to be inspected and complete inspection report has to be prepared in the inspection format including anodic coating [party has to prepare the inspection format and submit to us with process sheet].
17. Party has to deliver the item within **6 months** from the date of release of purchase order.
18. Purchase order will be placed to suitable vendors in full or the subset.
19. As the party is providing the material **PBG & warranty is applicable.**

V. Acceptance Criteria:-

After completion of the scope of work, IISU will depute inspection Engineer for pre-delivery inspection at your site and for acceptance.
