

U. R RAO SATELLITE CENTRE, BENGALURU

SCOPE OF WORK

FABRICATION, ASSEMBLY AND SUPPLY OF IN-PLANE TEST BENCH AS PER THE DRAWINGS

REFERENCE DRAWING:

Sl. No.	Drawing Description	Drawing Number
1	ASSEMBLY DRAWING	
1.1	TEST BENCH-INPLANE ASSY	ISAC-DTDF-DGEN-01-00007/000
2	PART DRAWINGS	
2.1	TEST BENCH-INPLANE (Sheet 1 of 2)	ISAC-DTDF-DGEN-01-00006/000
2.2	TEST BENCH-INPLANE (Sheet 2 of 2)	ISAC-DTDF-DGEN-01-00006/000
2.3	END CAP-1	ISAC-DTDF-DGEN-01-00008/000
2.4	END CAP-2	ISAC-DTDF-DGEN-01-00009/000
2.5	L-ANGLE	ISAC-DTDF-DGEN-01-00010/000
2.6	END CAP-3	ISAC-DTDF-DGEN-01-00011/000
2.7	END CAP-4	ISAC-DTDF-DGEN-01-00012/000

1. Scope of work includes, **Fabrication, Assembly, Welding, Inspection, Packing and Supply to URSC as per reference drawings.**
2. Material to be used is Mild Steel (MS). C – Channel and / or Box type Section as per the drawing.
3. Vendor shall use only Indian Standard (IS) hot rolled steel channels (MC) conforming to IS 808 : 1989 (BIS) standards (equivalent or superior standards)
4. Raw material will not be supplied. The quotation should include cost of raw material.
5. Fabrication involves machining, as per the approved part drawing.
6. Single piece of C-Channel/ Box Section raw material to be used as per the approved part drawing (i.e., Two or more cut Pieces joined by Welding or other means should not be used).
7. Vendor has to maintain the location tolerances as per the drawings. Dimensional tolerances are to be maintained during machining.
8. Vendor has to follow the recommended weld standards with proper edge preparations and fixtures.
9. All the welded joints are to be free from defects such as cracks, discontinuity, porosity, etc.
10. Welds are to be inspected for the above defects using suitable Non-Destructive Test such as die penetrant, visual inspection, etc.
11. Machining on weldments shall be avoided.

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12. Planarity of Part 2A and 2D mentioned in drawing ISAC-DTDF-DGEN-01-00006/000, should be maintained with a tolerance of 1 mm.
13. All 6 legs should be resting on the ground at same level.
14. Dimensional Inspection of Final Assembled test bench should be carried out as per the assembled drawing.
15. Pre-despatch inspection by URSC will be carried out before Painting.

16. **PAINTING**

PU (Poly Urethane) paint (SPRAY PAINTING WITH GREY/ SKY BLUE COLOUR) with suitable epoxy primer has to be applied on all the surfaces of members of all the assemblies / sub-assemblies. The following surface preparations are to be carried out before applying the paint.

- Round off the edges, remove burrs, remove undue built up of weld, etc.
 - Clean the surface, make it free from oil, dirt, etc.
 - Primer to be applied on all un-machined surfaces.
17. Vendor shall give a warranty for 1 (ONE) year on the final assembly after the acceptance from our end as per purchase order terms and conditions. Warranty shall include any defects in materials, processes such as workmanship defects / fabrication defects like welding, painting, etc.
 18. Packing and Dispatch: Finished Product should be properly packed to avoid damage during transportation and supplied to URSC, Bangalore.