



ITER-India, Institute for Plasma Research

Block A, Sangath SKYZ, Bhat- Motera Road, Koteswar, Ahmedabad 380005 Gujarat, India.

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Email : purchase@iter-india.org

ENQUIRY - LOCAL

OFFICE COPY ENQUIRY NO : I-IEN22003
Date : 23/06/2022
Due Date : 12/07/2022 by 5:00 PM (IST)

We invite your rate/s for the following item/s. The Instructions to bidders and Terms & Conditions are attached herewith.

Important note:

1. Enquiry No., Date & Due Date should appear on the envelope otherwise your offer will be rejected.
2. Address quotation only to the Purchase officer.


Sr No.	Material Description	Quantity	Unit
1	Prototype Machining of Plasma Grid Segment	1	NOS

Note :

- (1) Submit your quotation in hard copy (sealed envelope superscribing enquiry no and due date) AT THE ABOVE ADDRESS.
- (2) Any clarification on this enquiry may be sought from the Purchase Officer, ITER-India. (Email id: purchase@iter-india.in)
- (3) Quote with complete technical details.
- (4) Quotation should invariably be submitted in the attached format (Quotation Format) ONLY else ITER-India may not consider your offer.
- (5) Detailed specifications & other terms are as per attached Annexure-A. Complete Annexure-A shall be signed & stamped on each page by bidder & to be return back along with the offer. This will be considered as an acceptance of bidder on Annexure-A.
- (6) Work shall start after the Placement of order.
- (7) Any bidder from a country that shares a land border with India(i) , excluding countries as listed on the website of the Ministry of External Affairs(ii) , to which the Government of India has extended lines of credit or in which the Government of India is engaged in development projects (hereinafter called 'Restricted Countries') shall be eligible to bid in this tender only if Bidder is registered(iii) with the Registration Committee constituted by the Department for Promotion of Industry and Internal Trade (DPIIT). Bidders shall enclose the certificate in this regard as per Annexure III. (i) <https://mea.gov.in/india-and-neighbours.htm> (ii) <http://meadashboard.gov.in/indicators/92> (iii) https://dipp.gov.in/sites/default/files/Revised-Application-Format-for-Registration-of-Bidders-15_Oct_2020.pdf
- (8) Bidder from such Restricted Countries" means: - a) An entity incorporated, established, or registered in such a country; or b) A subsidiary of an entity incorporated, established, or registered in such a country; or c) An entity substantially controlled through entities incorporated, established, or registered in such a country; or d) An entity whose beneficial owner is situated in such a country; or e) An Indian (or other) agent of such an entity; or f) A natural person who is a citizen of such a country; or g) A consortium/ joint venture where any member falls under any of the above

- (9) In Bids for Turnkey contracts, including Works contracts, the successful bidder shall not be allowed to sub-contract works to any contractor from such Restricted Countries unless such contractor is similarly registered. In such cases, the bidders shall enclose the certificate as per Annexure II.
- (10) If Bidder has proposed to sub-contract Services or incidental Goods directly/ indirectly from the vendors from such countries, such vendor shall be required to be registered with the Competent Authority. However, if Bidder procures raw material, components, and sub-assemblies from such countries"" vendors, such vendors shall not require registration.
- (11) Class-I Local Suppliers, Class-II Local Suppliers and Non Local Suppliers are eligible to bid for this enquiry. Refer Government notification no. P-4501/2/2017-PP (BEII) issued by Ministry of Commerce & industry in this regard Provisions as per this notification as amended from time to time shall apply for this tender including bid evaluation
- (12) Class-I Local Suppliers, Class-II Local Suppliers and Non Local Suppliers will submit duly signed self declaration on their letter head as per Annexure-III along with the offer failing which bid may not be considered for further evaluation
- (13) Qualification Criteria for bidder against this enquiry are mentioned in Annexure-I of attached Annexure-A. Bidder need to submit documents in compliance to the criteria. Failing which your bid may not be considered.
- (14) Failure Liability: in case of failure during Production Proof Sample (PPS) as well as during bulk production and based on failure analysis by ITER-India, mutual agreement shall be done for further action. Vender / Service provider shall not be entitled for payment of extra cost for test set-up/process performed/to be reperformed due to such failures, however, required FIM will be provided by Purchaser for reproduction of sample / bulk (as applicable).
- (15) GeM Availability report ID : GEM/GARPTS/17052022/OQR9156XUR19 dated 17.05.2022.
- (16) Preference to Make In India products (For bids < 200 Crore):Preference shall be given to Class-I local supplier as defined in public procurement (Preference to Make in India), Order 2017 as amended from time to time and its subsequent Orders/Notifications issued by concerned Nodal Ministry for specific Goods/Products. The minimum local content to qualify as a Class-I local supplier is 50% & for Class-II is 20%. If the bidder wants to avail the Purchase preference, the bidder must upload a certificate from the OEM regarding the percentage of the local content and the details of locations at which the local value addition is made along with their bid, failing which no purchase preference shall be granted. In case the bid value is more than Rs 10 Crore, the declaration relating to percentage of local content shall be certified by the statutory auditor or cost auditor, if the OEM is a company and by a practicing cost accountant or a chartered accountant for OEMs other than companies as per the Public Procurement (preference to Make-in -India) order 2017 dated 04.06.2020. Only Class-I and Class-II Local suppliers as per MII order dated 4.6.2020 will be eligible to bid. Non - Local suppliers as per MII order dated 04.06.2020 are not eligible to participate. However, eligible micro and small enterprises will be allowed to participate .In case Buyer has selected Purchase preference to Micro and Small Enterprises clause in the bid, the same will get precedence over this clause.
- (17) Purchase preference to Micro and Small Enterprises (MSEs): Purchase preference will be given to MSEs as defined in Public Procurement Policy for Micro and Small Enterprises (MSEs) Order, 2012 dated 23.03.2012 issued by Ministry of Micro, Small and Medium Enterprises and its subsequent Orders/Notifications issued by concerned Ministry. If the bidder wants to avail the Purchase preference, the bidder must be the manufacturer of the offered product in case of bid for supply of goods. Traders are excluded from the purview of Public Procurement Policy for Micro and Small Enterprises. In respect of bid for Services, the bidder must be the Service provider of the offered Service. Relevant documentary evidence in this regard shall be uploaded along with the bid in respect of the offered product or service. If L-1 is not an MSE and MSE Seller (s) has/have quoted price within L-1+ 15% (Selected by Buyer)of margin of purchase preference /price band defined in relevant policy, such Seller shall be given opportunity to match L-1 price and contract will be awarded for 100%(selected by Buyer) percentage of total QUANTITY.

Encl:- as above


Rakhi Dharamdasani
Sr. Officer (Purchase & Stores)
ITER-India (IPR)

TERMS AND CONDITIONS

1. The quotation and any order resulting from this enquiry shall be governed by our Conditions of Order and supplier quoting against this enquiry shall be deemed to have read and understood the same in to
2. Where counter terms and conditions have been offered by the Tenderer, the same shall not be deemed to have been accepted by ITER-India unless our specific written acceptance thereof is obtained.
3. Quotation: Your quotation superscripting our enquiry No., date, due date and brief description of item should be submitted to the Purchase Officer, ITER-India in sealed envelope on or before the due date. Late/ delayed/incomplete quotations will not be considered. Envelopes received without Enquiry number, date, due date and brief description of item may be rejected. The quoted prices should be firm for a period of 90 days from due date for placing order. ITER-India is not bound to accept lowest rate/s. Bidder shall submit the price bid/offer on bidder's letter head with official seal and sign on each page.
4. The bid documents shall be prepared in English language only
5. All pages of the bid documents shall be numbered. Each page of the bid document shall be stamped and initialized.
6. In the event of any date indicated above is a declared Holiday, the next working day with the same time limit shall become operative for the respective purpose mentioned herein
7. In case of deviation in payment terms including demand of advance other than specified in payment schedule and accepted by ITER-India, prevailing Prime Lending Rate (PLR) of Sol will be loaded for price comparison purpose
8. ITER-India and their authorized representatives may visit the Contractor/Sub-contractors if required as part of technical evaluation process
9. ITER-India reserves the right to place order on one or more parties.
10. Specifications: Material should be offered strictly conforming to our specifications/drawings, if any deviation, if any, should be clearly indicated by the supplier in their quotation. The Tenderer should also indicate the make/Type number of the materials offered and catalogues, technical literature and samples, wherever necessary should accompany the quotation. Clarification/s on specifications/drawings should be obtained from Purchase Officer before submitting quotation.
11. Terms of Prices : Quotation should be submitted on door delivery basis, duly packed & insured without extra charge wherever possible.. In the case of Indian suppliers, the material is to be delivered at our stores free of charge duly packed & insured.
12. Unit rate/s should be valid throughout the validity of Purchase Order for addition/deletion purposes. Break-up of price should be furnished. The quoted price should not be subject to price escalation for whatsoever reasons. The quoted price shall be firm, fixed and non-revisable during the validity/ extended validity of Purchase Order.
13. Prices are required to be quoted according to the units indicated in the tender form/Enquiry. When Quotations are given in terms of units other than those specified in the tender form, relationship between the two sets of units must be furnished.
14. Tender should be free from Correction and Erasures. Corrections, if any, must be attested. All amounts shall be indicated both in words as well as in figures. Where there is difference between amounts quoted in words and figures, amount quoted in words shall prevail. Unsigned quotations will summarily be rejected.
15. ITER-India shall be under no obligation to accept the lowest or any tender and reserves the right of acceptance of the whole or any part of the tender or portion of the quantity offered and the tenderers shall supply the same at the rates quoted. ITER-India also reserves the right to split the order at its sole discretion.
16. Octroi is not applicable at present.
17. Delivery date/Period: Delivery period is essence of the Order. Supplier must indicate the firm delivery date by which the materials will be dispatched / delivered by them from the date of our order.
18. Delivery period shall be clearly indicated against each item separately.
19. Inspection: Materials on its arrival at ITER-India will be inspected by our Engineer/Stores In-Charge, and his decision in the matter will be final. However, where the items are required to be inspected at the Suppliers Premises, Supplier has to give advance notice to the Purchaser regarding readiness of the material to enable Purchase/Stores section to depute his representative for inspection.
20. Payment: Payment will be arranged for accepted materials only within 30 days from the date of acceptance of materials at ITER-India and receipt of error free bills in our accounts section, complete in all respects.
21. No correspondence will be entertained within 30 days from the date of receipt of material and bills, whichever is later.
22. The Contractor/Supplier shall at all times indemnify the purchaser against all claims which may be made in respect of the stores for infringement of any right protected by Patent, Registration of design or Trade mark and shall take all risk of accidents or damage, which may cause failure of supply from whatever cause arising and the entire responsibility for sufficiency of all means used by him for the fulfillment of the Order.
23. Successful tenderer will have to furnish in the form a bank Guarantee or in Indemnity bond form as called for by the Purchaser towards adequate security for the materials/property provided/issued by the Purchaser as Free Issue material for the due execution of the Order. Insurance for the Free Issue material shall be arranged by the Supplier/Contractor at his risk and cost.
24. Non-compliance to tender specifications and/or tender scope and/or tender terms and conditions are liable for rejection. Decision of ITER-India in respect of non-compliance shall be final and binding on the bidders.
25. Canvassing in any form with regard to this tender will lead to rejection of the bid.
26. The Project director, ITER-India reserves the right to accept or reject any quotations fully or partly or to cancel the enquiry without assigning any reasons.
27. This enquiry is not a commitment and the Purchaser reserves the right to reject or cancel any or all offers.
28. Jurisdiction: The Order shall be governed by the laws of India for the time being in force. The Courts of Ahmedabad/Gandhinagar only shall have jurisdiction to deal with and decide any legal or dispute arising out of this Order.
29. Unsuccessful bidders will not be intimated about the results of the enquiry/tender.
30. Purchase will not be responsible for payment of any interest to the Supplier, in case of delay in releasing payment.
31. The price evaluation shall be carried out on landed price.

FORMAT FOR SUBMISSION OF QUOTATION

Enquiry No. : I-IEN22003
Name of Party : OFFICE COPY
Quotation No. & Date :
Due on : 12/07/2022 by 5:00 PM (IST)

Sr no.	Material Description	Qty	Unit	Rate	Total
1	Prototype Machining of Plasma Grid Segment	1	NOS		
				Grand Total	

COMMERCIAL TERMS & CONDITIONS *

Sr.No		Bidder's Compliance
1	Free Door delivery	
2	Payment: ITER-India payment terms will apply (Please Refer Sr. No. 9 or Attached Annexure-A)	Comply Yes/No (In case of No Please provide details)
3	Bid Validity Period (Refer Sr. No. 3 of Terms and Conditions)	Comply Yes/No (In case of No Please provide details)
4	GST (To Specify as applicable)	
5	GST No. (To Specify)	
6	SAC Code (To Specify)	
7	Udhyog Aadhar No. & Category (Micro/Small Enterprise, Also specify firm is owned by SC/ST/Woman/General)	
8	Discount(if any)	
9	Remarks	

* Fill in the applicable details

Place:

Authorised Signatory:

Date:

Company Seal



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Annexure - A

Scope of Work & Technical Specification

Prototype Machining of Plasma Grid Segment

1. Introduction

The component named as 'Accelerator grid segment' is used in the Neutral Beam Source for Nuclear Fusion Plants. The component is made from a sheet of Half Hard (R240) Oxygen Free Copper material and is actively cooled.

Form the construction perspective, it has milled cooling channels (see Fig. 1 below) which are then closed by copper electrodeposition (see Fig. 2 below) and then the apertures of specific shape are drilled (see Fig. 3 below).

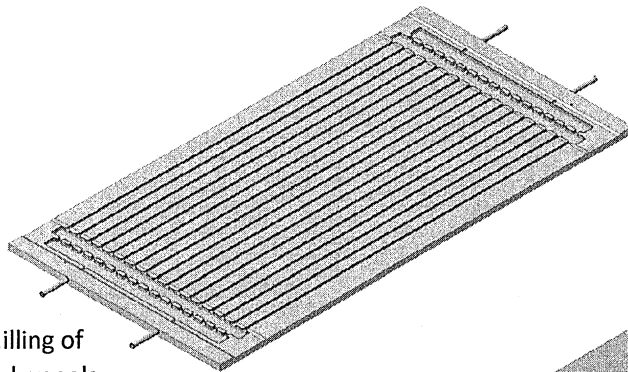


Fig.1: Milling of cooling channels

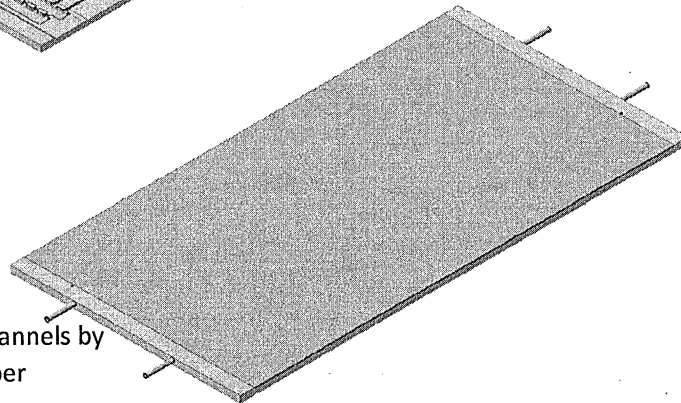


Fig.2: Closing of milled channels by electrodeposition of copper

(this step is not in the scope of bidder)

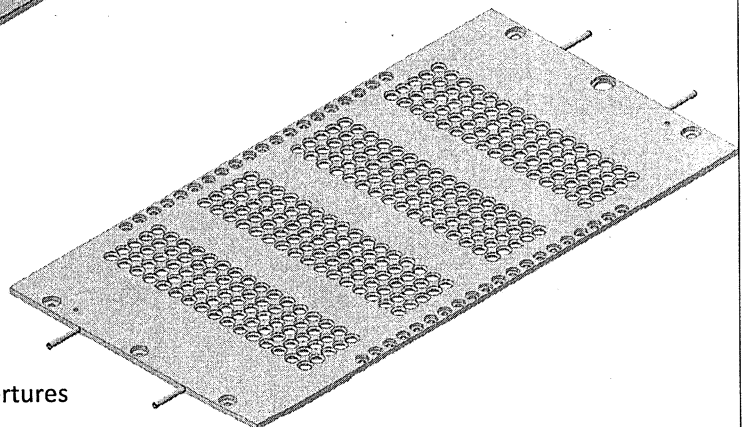


Fig.3: Milling of apertures

While the electrodeposition will be taken care by The Purchaser, we are looking for a competent machining company to perform the milling of the channels and drilling of the



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apertures. The subsequent pages provide the details of the scope of work and the component drawings.

2. Scope of Work

Stage	Description	Qty.	Scope
1	Raw Material		One plate shall be provided by The Purchaser as a Free Issue Material (FIM). Details of these material are provided in clause 8 below. Bidder shall collect the FIM from The ITER-India, Lab.
2	Machining of the cooling channels and other features as per drawing PG-001 (attached herewith)	1 Nos.	Bidder's scope
3	Dimensional measurement of the plate as per drawing PG-001	1 Nos.	Bidder's scope
4	Packing and delivery of the machined plate to Indore (address shall be conveyed after the contract award)	1 No.	Bidder's scope
5	Electrodeposition of copper of plate at Indore		This is not in the scope of bidder. It is Purchaser's responsibility of The Purchaser to perform this task.
6	Pick-up & transport(including transit insurance) of the plate from Indore (detailed address shall be shared after contract award) to service provider's premises.	1 No.	Bidder's scope
7	Machining of the apertures and other features as per drawing PG-002	1 No.	Bidder's scope
8	Dimensional measurement as per drawing PG-002 (including transit insurance)	1 No.	Bidder's scope
9	Packing and delivery of the machined plate to The Purchaser	1 No.	Bidder's scope

- 2.1 Failure Liability: in case of failure during Production Proof Sample (PPS) as well as during bulk production and based on failure analysis by ITER-India, mutual agreement shall be done for further action. Vendor / Service provider shall not be entitled for payment of extra cost for test set-up/process performed/to be re-performed due to such failures, however, required FIM will be provided by Purchaser for reproduction of sample / bulk (as applicable).



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3. Drawings

Following detailed drawings have been provided as a part of this specification.

PG-001: Grid cooling channel machining

PG-002: Grid aperture machining

The component shall be machined as per the dimensions and tolerances provided in the drawing. Where the tolerances are not provided on the drawing, ISO 2768-mk shall be followed.

4. Dimensional measurement

Dimensional measurement of following features shall be performed by using Coordinate Measurement Machine (CMM):

- Reference hole diameter and position
- Dimension and position of cooling channels
- Dimensions and position of all the 320 apertures
- Flatness of complete plate
- Dimensions and position of busbar holes
- Dimensions and position of grid fixing holes
- Thickness of the plate for both machining stage

Bidder may use the external service / sub-contractor for CMM measurement, with prior intimation to The Purchaser.

Surface finish shall be measured as per the drawing requirements.

Dimensions of rest of the features can be performed by the conventional measurement tools.

Bidder shall notify The Purchaser atleast 15 days before the measurement. Based on Purchaser's discretion, representative shall participate in the measurement as an observer.

The dimensional report shall be provided to the Purchaser for review and approval at the end of completion of stage-3 and stage-8.

5. Jigs and fixtures

Design and manufacturing of jigs and fixture required for machining, dimensional measurement and shipping shall be responsibility of the bidder. The material of the jigs shall be compatible to Oxygen free copper and shall not have any detrimental effect (e.g rusting etc.) to the base material. The details of material shall be submitted to Purchaser for agreement prior to use.



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6. Pre-dispatch inspection / Factory Acceptance Test

- 6.1. Visual examination after stage-2
- 6.2. Dimensional examination after stage-3
- 6.3. Visual examination after stage-7
- 6.4. Dimensional examination after stage-8

7. Delivery schedule

Stage	Description	Duration
1	Raw Material	To be collected within 15 days from PO
2	Machining of the cooling channels and other features as per drawing PG-001 (attached herewith)	Within 3 months after handing over the material
3	Dimensional measurement of the plate as per drawing PG-001	
4	Packing and delivery of the machined plate to Indore (address shall be conveyed after the contract award)	Within 15 days after acceptance test
5	Electrodeposition of copper	This process shall take about 6 to 8 months. Once completed, Purchaser shall intimate the bidder for collection of the material from Indore.
6	Pick-up the plate from Indore (detailed address shall be shared after contract award)	Within 15 days of intimation from Purchaser
7	Machining of the apertures and other features as per drawing PG-002	Within 3 months after handling over the material
8	Dimensional measurement as per drawing PG-002	
9	Packing and delivery of the machined plate to Purchaser	Within 15 days after acceptance test



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8. Details of raw material to be provided by Purchaser as FIM

EN 13599; R240 grade Oxygen Free Copper

Dimensions in mm

Sl.No	DIMENSION	HEAT ID	Qty	PLATE DESIGNATION
1	1000 x 600 x 12	A1194	1	A1194-1

MECHANICAL PROPERTIES				
Heat ID	Plate No	Y.S. (0.2% Proof Stress) (≥180 MPa)	U.T.S (240- 300MPa)	Elongation (≥ 15%)
A1194 RT-1	1	234.8	244.0	37.8
A1194 RT-2	1	231.8	243.5	41.8

ITER-India will issue following materials as Free Issue Material (FIM) to the Contractor for this Contract.

Details of Free Issue Material (FIM)

Sr. No	Item Details	Quantity	Unit Price in INR	Total Price in INR
1	EN 135599; R240 Grade Oxygen Free Copper	1 No.	3,00,000/-	3,00,000/-
Total				3,00,000/-

Contractor shall collect the FIM on his own cost and risk from Purchaser against submission of Insurance Policy towards adequate security for the materials provided by the Purchaser as Free Issue Material (FIM) for the due execution of the Contract.

Contractor shall take an Insurance Policy for the value of the FIM + 10% covering all insurable risks, including risks not expressly mentioned in this Contract. The Insurance Policy shall be valid till the actual delivery date and shall cover the following.

INSURED: Name and address of the Contractor

BENEFICIARY: ITER-India, IPR acting through Project Director or any other Officials authorized by ITER-India.

RISKS COVERED: Any loss or damage to the Purchaser's material due to Fire, riot, burglary, strike, theft, civil commotion and any damages arising out of external sources such as damages due to the materials falling on Purchaser's materials and to protect against weather conditions and any risks as covered under ICC(A).



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The Contractor shall be responsible for the safety of the FIM all through the period during which the materials will remain in his possession. The Contractor shall take all necessary precautions against any loss, deterioration or destruction of the FIM from whatever cause arising whilst the said material remains in his possession and/or his custody or control, the Contractor shall also not mix-up the material in question with any of his goods and shall render true and proper accounts of the material actually used. The Contractor shall not use the FIM for other than Purchaser's job and utmost care should be taken to minimize the wastage or loss. Contractor will be held responsible for spoilage and damage during the process. The decision as to whether the Contractor has occasioned any loss, deterioration or destruction of the FIM whilst in his possession, custody or control from whatever cause arising, as also the decision regarding quantum of the damages suffered by the Purchaser shall be final and binding upon the Contractor.

The Purchaser at all times has the right to enter the Contractor's premises where the free issue materials are stored or where the free issue materials under manufacture.

9. Payment Term :

40% payment of basic order value will be released within 30 days from the date of successful completion of stage-4 of scope of work. Remaining 60% payment + applicable taxes will be released within 30 days from the from the date of Final Acceptance and receipt of error free invoice complete in all respect along with all supporting documents.

Bidder Signature	
Name of the signatory & Title	Title
Bidder's Official seal	
Place & Date	DD-MM-YYYY



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ANNEXURE – I

Qualification Criteria for Prototype machining of Plasma grid segment

S. No.	Criteria	Documents required to attached for evaluation
1	<p>Bidder shall have in-house facility of performing the main machining operations (i.e. milling of channels and aperture machining)</p> <p>Note: No sub-contracting is allowed except lapping/other surface finish operations and CMM measurement.</p>	<p>Details of the machine(s) to be used for machining operation (channels and aperture machining), which shall at least include:</p> <ul style="list-style-type: none">• Max. size of the component that can be machined• Typical accuracies of the machine(s). <p>Photograph(s) which shows that the machine is in the premises of the bidder AND declaration by the bidder that the he owns the machine</p>
2	<p>Bidder shall have experience of CuOF/Cu-ETP/CuCrZr machining</p>	<p>Details related to experience, i.e. PO copy/drawing/dimensional report/photos with major dimensions of jobs completed shall be submitted by bidder.</p>



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Annexure - II

Bid Form: Self Declaration(On company letter head) (Along with supporting documents, if any)

Tender No:

Tender Title:

Bidder's Name: _____ (Address and contact details)

Bidder's Offer No. _____ Date: _____

Restrictions on procurement from Bidders from a country or countries, or class of countries under Rule 144(xi) of the General Financial Rules 2017.

We have read the clause regarding restrictions on procurement from a bidder of a country which shares a land border with India and on sub-contracting to contractors from such countries, and solemnly certify that we fulfil all requirements in this regard and are eligible to be considered. We certify that:

- (a) *we are not from such a country or, if from such a country, we are registered with the Competent Authority (copy enclosed). and;*
- (b) *we shall not subcontract any work to a contractor from such countries unless such contractor is registered with the Competent Authority.*

Penalties for false or misleading declarations:

We hereby confirm that the particulars given above are factually correct and nothing is concealed and also undertake to advise any further changes to the above details. We understand that any wrong or misleading self-declaration by us would be violation of Code of integrity and would attract penalties as mentioned in this tender document, including debarment.

(Signature with date)

(Name and designation) Duly authorized to sign Bid for and on behalf of

(Name & address of the Bidder and Seal of Company)



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Annexure-III

(to be printed in letter head)

Self-Certification under preference to Make in India order
Certificate

In line with Government Public Procurement Order No. P-45021/2/2017-PP (BE-II) dated 04.06.2020 as amended from time to time and as applicable on the date of submission of tender/enquiry, we hereby certify that we M/s _____ are Class I local supplier/ Class II local supplier/Non-Local supplier and quoted item/service against ITER-India Enquiry/Tender No. Dated has/have local content i.e., _____%. Details of location at which local value addition will be made as follows: _____.

We also understand, false declarations will be in breach of the code of integrity under rule 175(1)(i)(h) of the General Financial Rules for which a bidder or its successors can be debarred for up to two years as per Rule 151(iii) of the General Financial Rules along with such other actions as may be permissible under law.

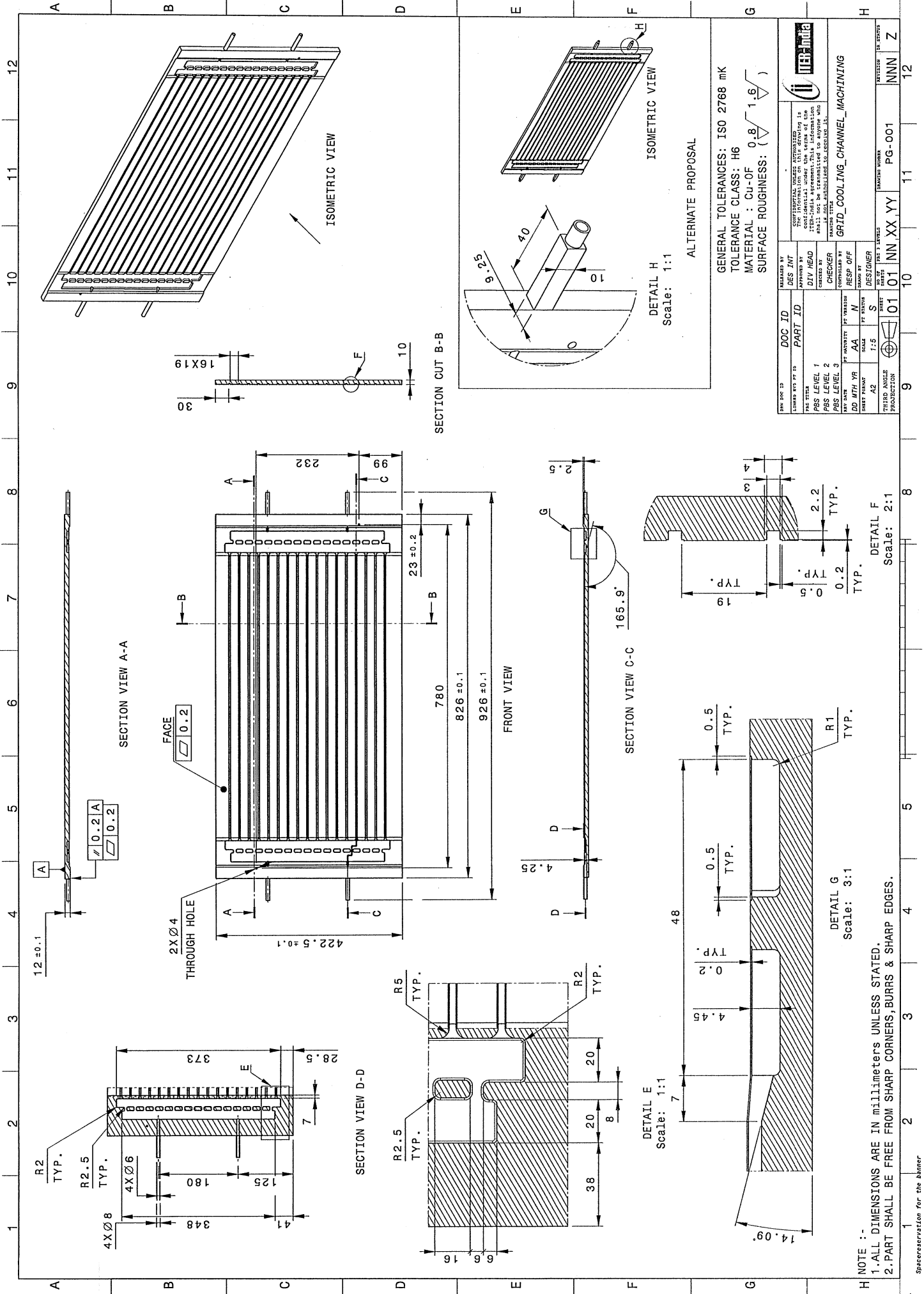
Thanking You

Signature with date:

Name:

Designation:

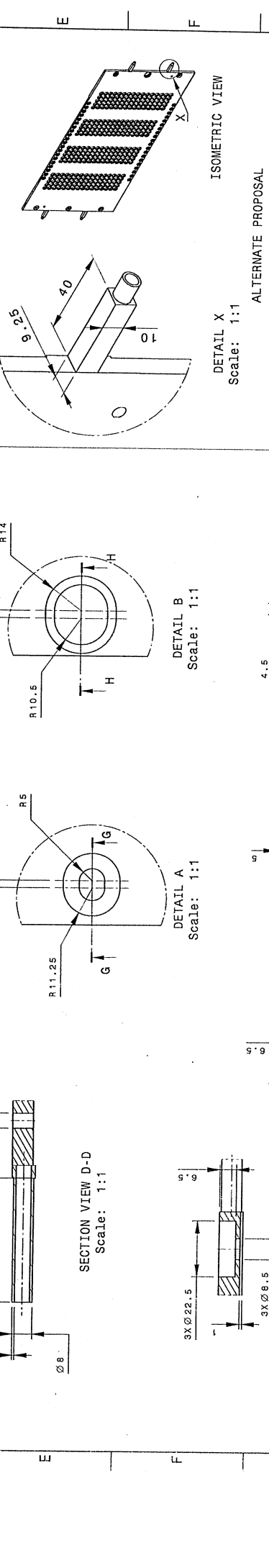
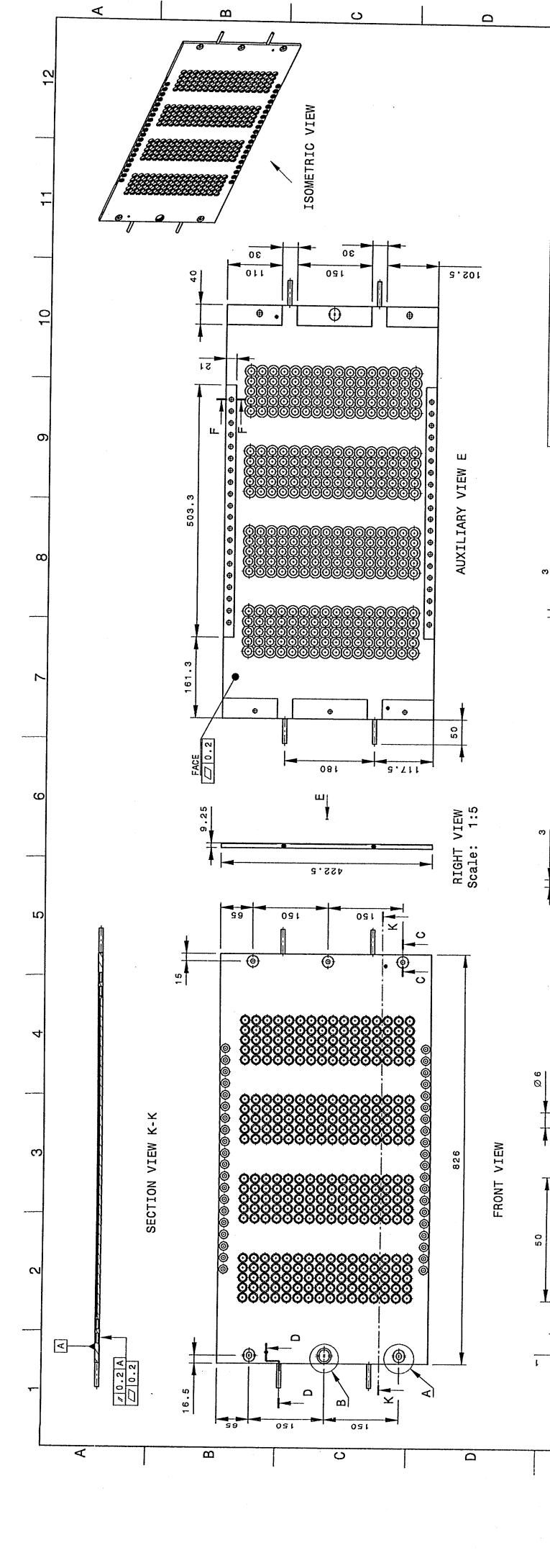
Official Seal



DATE: 01/01/2013	DESIGN: INT	DESIGNED BY: DIV HEAD	APPROVED BY: CHECKER	CONTROLLED BY: RESP OFF	DRAWN BY: S	DESIGNER: N	DATE: 01/01/2013
DOC ID: 01	PART ID: 01	REV: 1	REV: 1	REV: 1	REV: 1	REV: 1	REV: 1
<p>ISO 9001:2008 CERTIFIED</p> <p>THE INFORMATION ON THIS DRAWING IS THE PROPERTY OF INTER-INDIA. IT SHALL NOT BE TRANSMITTED TO ANYONE WHO HAS NOT BEEN AUTHORIZED TO DO SO.</p> <p>INTER-INDIA</p> <p>GRID_COOLING_CHANNEL_MACHINING</p>							<p>PG-001</p> <p>01 NN XX YY</p> <p>11</p> <p>12</p>

NOTE :-
 1. ALL DIMENSIONS ARE IN MILLIMETERS UNLESS STATED.
 2. PART SHALL BE FREE FROM SHARP CORNERS, BURRS & SHARP EDGES.





GENERAL TOLERANCES: ISO 2768 mK
 TOLERANCE CLASS: H6
 MATERIAL: CU-OF
 SURFACE ROUGHNESS: $\sqrt{0.8}$ $\sqrt{1.6}$ $\sqrt{}$

DESIGNED BY: DES INT	APPROVED BY: DES INT	SCALE: 1:1	INT
CHECKED BY: DES INT	DATE: 10/11/19	CHECKED BY: DES INT	INT
DRAWN BY: DES INT	CHECKED BY: DES INT	DRAWN BY: DES INT	INT
DATE: 10/11/19	CHECKED BY: DES INT	DATE: 10/11/19	INT
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DATE: 10/11/19	CHECKED BY: DES INT	DATE: 10/11/19	INT
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GRID_APERTURE_MACHINING

REVISION: 01

DATE: 10/11/19

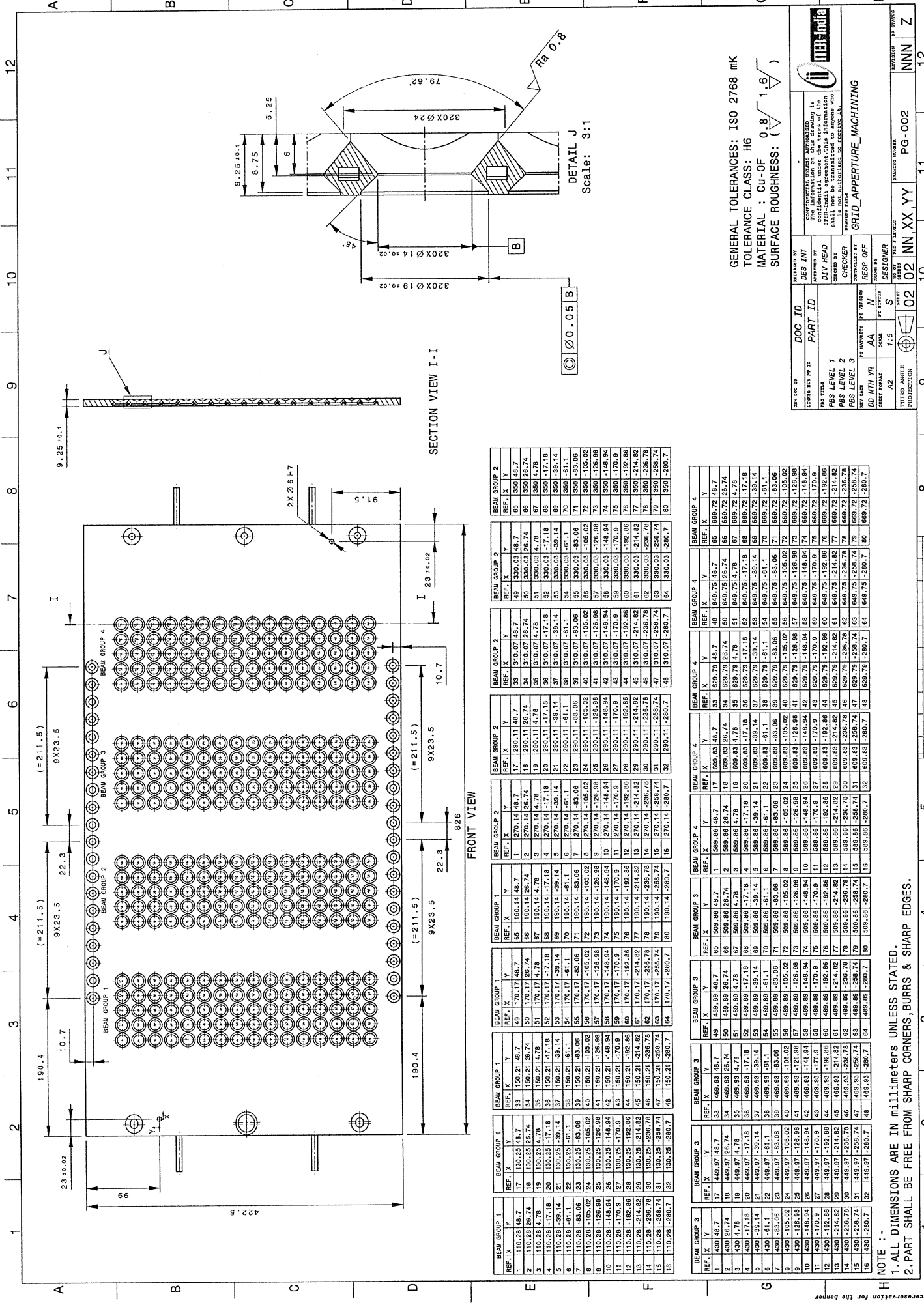
PROJECT: 002

DRAWING NUMBER: 002

DATE: 10/11/19

PROJECT: 002

NOTE :-
 1.-ALL DIMENSIONS ARE IN millimeters UNLESS STATED.
 2.-PART SHALL BE FREE FROM SHARP CORNERS, BURRS & SHARP EDGES.



GENERAL TOLERANCES: ISO 2768 mK
 TOLERANCE CLASS: H6
 MATERIAL: Cu-Of
 SURFACE ROUGHNESS: (Ra) 0.8 (Rz) 1.6

DESIGNED BY: DES INT
 DRAWN BY: DES INT
 CHECKED BY: DES INT
 APPROVED BY: DES INT

DATE: 02.02.2022
 SHEET NO: 02.02.2022
 PROJECT: NN XX YY
 PG-002

PRODUCTION: 11 10 09

SCALE: 1:5

PRODUCTION: 11 10 09

PRODUCTION: 11 10 09

PRODUCTION: 11 10 09

SECTION VIEW I-I

FRONT VIEW

BEAM GROUP 1			BEAM GROUP 2			BEAM GROUP 3			BEAM GROUP 4		
REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z
1	10.28	48.7	17	130.25	48.7	17	290.11	48.7	17	609.83	48.7
2	110.28	28.74	18	130.25	28.74	18	290.11	28.74	18	609.83	28.74
3	110.28	4.78	19	130.25	4.78	19	290.11	4.78	19	609.83	4.78
4	110.28	-17.18	20	130.25	-17.18	20	290.11	-17.18	20	609.83	-17.18
5	110.28	-39.14	21	130.25	-39.14	21	290.11	-39.14	21	609.83	-39.14
6	110.28	-61.1	22	130.25	-61.1	22	290.11	-61.1	22	609.83	-61.1
7	110.28	-83.06	23	130.25	-83.06	23	290.11	-83.06	23	609.83	-83.06
8	110.28	-105.02	24	130.25	-105.02	24	290.11	-105.02	24	609.83	-105.02
9	110.28	-126.98	25	130.25	-126.98	25	290.11	-126.98	25	609.83	-126.98
10	110.28	-148.94	26	130.25	-148.94	26	290.11	-148.94	26	609.83	-148.94
11	110.28	-170.9	27	130.25	-170.9	27	290.11	-170.9	27	609.83	-170.9
12	110.28	-192.86	28	130.25	-192.86	28	290.11	-192.86	28	609.83	-192.86
13	110.28	-214.82	29	130.25	-214.82	29	290.11	-214.82	29	609.83	-214.82
14	110.28	-236.78	30	130.25	-236.78	30	290.11	-236.78	30	609.83	-236.78
15	110.28	-258.74	31	130.25	-258.74	31	290.11	-258.74	31	609.83	-258.74
16	110.28	-280.7	32	130.25	-280.7	32	290.11	-280.7	32	609.83	-280.7

BEAM GROUP 1			BEAM GROUP 2			BEAM GROUP 3			BEAM GROUP 4		
REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z	REF. X	REF. Y	REF. Z
33	310.07	48.7	33	629.79	48.7	33	629.79	48.7	33	629.79	48.7
34	310.07	28.74	34	629.79	28.74	34	629.79	28.74	34	629.79	28.74
35	310.07	4.78	35	629.79	4.78	35	629.79	4.78	35	629.79	4.78
36	310.07	-17.18	36	629.79	-17.18	36	629.79	-17.18	36	629.79	-17.18
37	310.07	-39.14	37	629.79	-39.14	37	629.79	-39.14	37	629.79	-39.14
38	310.07	-61.1	38	629.79	-61.1	38	629.79	-61.1	38	629.79	-61.1
39	310.07	-83.06	39	629.79	-83.06	39	629.79	-83.06	39	629.79	-83.06
40	310.07	-105.02	40	629.79	-105.02	40	629.79	-105.02	40	629.79	-105.02
41	310.07	-126.98	41	629.79	-126.98	41	629.79	-126.98	41	629.79	-126.98
42	310.07	-148.94	42	629.79	-148.94	42	629.79	-148.94	42	629.79	-148.94
43	310.07	-170.9	43	629.79	-170.9	43	629.79	-170.9	43	629.79	-170.9
44	310.07	-192.86	44	629.79	-192.86	44	629.79	-192.86	44	629.79	-192.86
45	310.07	-214.82	45	629.79	-214.82	45	629.79	-214.82	45	629.79	-214.82
46	310.07	-236.78	46	629.79	-236.78	46	629.79	-236.78	46	629.79	-236.78
47	310.07	-258.74	47	629.79	-258.74	47	629.79	-258.74	47	629.79	-258.74
48	310.07	-280.7	48	629.79	-280.7	48	629.79	-280.7	48	629.79	-280.7

NOTE :-
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 2- PART SHALL BE FREE FROM SHARP CORNERS, BURRS & SHARP EDGES.