HINDUSTAN AERONAUTICS LIMITED,
AIRCRAFT DIVISION, NASIK

NAME OF WORK

CIVIL, ELECTRICAL AND OTHER UTILITY SERVICES FOR CONSTRUCTION OF HANGARS AND ALLIED FACILITIES FOR PACKAGE -CIVIL- III (OVERHAUL COMPLEX) IN FACTORY AREA [EXCLUDING PRE-ENGINEERED BUILDING STRUCTURES (PEB)]

TENDER NO.NK/FW-CAP-ROH-622/10-11

PACKAGE -CIVIL- III

VOLUME –II

TECHNICAL SPECIFICATION
**TECHNICAL SPECIFICATIONS**

**FOR**

**COMPRESSED AIR PIPING WORK**

**CONTENTS:**

<table>
<thead>
<tr>
<th>S.NO</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>SCOPE OF WORK</td>
</tr>
<tr>
<td>2</td>
<td>CUTTING AND WELDING PROCEDURE</td>
</tr>
<tr>
<td>3</td>
<td>TECHNICAL SPECIFICATION</td>
</tr>
<tr>
<td>4</td>
<td>LIST OF APPROVED MAKES</td>
</tr>
</tbody>
</table>
1.0 SCOPE OF WORK:

The scope of work includes supply, installation, testing and successful commissioning and handing over of complete compressed air Pipeline Work.

SCOPE: This specification covers the general requirements for on site shop fabrication, erection, commissioning, testing and cleaning of compressed air pipelines. All pipe work shall be in conformity with the requirements of the applicable drawings and specifications. Where specific details of fabrication are not shown on the drawings or specified herein, fabrication shall be in accordance with BS 3351/ ASA B 31.3

Piping shall also comply with applicable state, local or other Governmental laws and codes. All work shall be performed in accordance with the best modern practice for this type of work and shall be of highest quality workmanship.

Any deviations from these specifications, must have the approval of Consultant / Owner.

LIST OF BUILDINGS:

1. Building No. 1/1 : Overhaul Hangar
2. Shop 201 : Dismantling shop
3. Shop 202 : Structure repair shop
4. Shop 203 : Final assembly shop
5. Shop 208 : 
6. Shop 209 : Section for removal of varnish and paint coating
7. Building 84a : Shop of washing and testing of fuel compartments
8. External low pressure and high pressure piping for Package-II & II Buildings from low pressure compressor house and turbo cool high pressure compressor house.
9. High pressure compressed air piping inside filling station for pressure ranges of 25-100barg, 100-150barg, 150-200barg and 200-250barg.

1.1 DETAILED SCOPE OF WORK FOR PIPING WORK:

(a) No changes without prior approval
(b) Site safety, security and cleanliness
(c) Project schedule
(d) Discrepancies / interferences resolved before installation.
(e) Supply of piping materials to work site/shop, fabrication and erection, testing and commissioning of all piping system in accordance with the specification.

(d) Fabrication and erection of pipe supports, brackets, as per pipe support standards and drawings and instructions of Engineer-in-Charge.

1. The contractor shall also bear the cost of repair, changes, replacement, etc. due to noncompliance with the standards, codes or due to disregard of instructions given by Engineer-in-Charge.

(i) It is the responsibility of the contractor to take care of all the material brought inside the HAL until the time of handing over to the Owners.

(i) Any other items as required in the drawings/specifications are to be fabricated and erected from the available materials.

❖ All incidental jobs connected with Industrial piping work such as cutting chasing in concrete and brick work and making good cutting/drilling holes through walls, floors and grouting for fixing of supports etc. complete.

(a) The contractor for this work shall be required to work in Co-operation with other civil engineering,
Electrical etc Contractors should give them all reasonable assistance and help for the execution of the work in an efficient manner as directed. Any work done without regard or consultation with other trades shall be removed by the Contractor without additional cost to the Owner, to permit the proper installation of all other works as desired by the Architects.

(i) Repair all damages done to the premises as a result of this installation and removal of all debris left by those engaged for this installation to the satisfaction of the Owner.

1.2 **PIPE JOINTS:**
In general joints shall be butt welded as specified in the applicable valve and piping specifications, with flanges and butt weld fittings used where required. Flange faces shall be in a plane perpendicular, true and square to the center line of the pipe to which they are welded.

Bolts on flanged joints shall be drawn up to provide even and adequate pressure on gaskets.

**WELDING**

Fabricated piping system shall be erected as detailed on piping layout drawing and as advised by the consultant and / or owner. The contractor shall provide adequate field joints bearing in mind the fact that there may be variations in locations of equipments, equipment nozzles, inserts, structures, etc. but not limited to the aforesaid contingencies only. In certain cases site measurement may have to be taken before commencement of fabrication.

Flange joints shall be used at connections to equipments, valves, flanged fittings and wherever required for ease of erection and maintenance as indicated in the drawings.

1.3 **MEASUREMENTS:**
The measurements (for the payment purpose) shall be considered as per actual laid quantity. The mode of measurement shall be in running meters for the compressed air pipeline including fittings such as bends, elbows, tees, unions, nuts, bolts, washers, gaskets, nipples, expanders/reducers complete with adequate supports, and wrapping/ coating for the underground pipeline.

Measurements (for the payment purpose) of the Flanges, Long Radius bends, Isolation (Ball) valves, Filters, Pressure gauges, Drip leg drains, Quick fix couplers with plug, Air compressor, Air dryer and Air receiver shall be considered as per the actual quantity used.

1.4 **RESPONSIBILITY**

(a) **DRAWINGS:**
The drawing enclosed herewith is the guidance to the contractor. The contractor shall submit shop floor drawings for the consultant approval. The contractor should execute the pipeline on the drawings enclosed. After the completion of the test and handing over the work, the contractor shall submit 3 sets of hard copies of as-built drawings. If required, draft copies of the same shall be approved by the consultant.

**DRAWING/INFORMATION REQUIRED FROM SUCCESSFUL TENDERER WITHIN 15 DAYS AFTER AWARD OF WORK:**

Bar chart showing engineering, manufacturing and dispatch of each equipment and erection services.

Drawing, literature and technical particulars of all bought out items.

Schedule for valves and piping material.

(i) **PAINTING:**
All piping, furnished under this work shall be properly painted with two coats of a synthetic enamel paint over a coat of primer after installation as per IS Code. Arrow marks for indicating flow direction and stenciling to be done as per Good Engineering Practice.

Colour Code of the piping shall be SKY BLUE

a) **SCAFFOLDING:**
All scaffolding and ladders required for the proper execution of the work shall be in the scope of the contractor.
b) **QUALITY OF MATERIALS AND GENERAL STANDARDS OF WORK**

The contractor under this contract commits himself to use the first class materials and assumes full responsibility for the quality of all material incorporated or brought for incorporation in the work. The work shall be executed in accordance with the best engineering practice and as per directions of the consultant.

c) **SAMPLES**

The samples of all the materials to be incorporated in the work shall be furnished to the consultant and got approved prior to bulk procurement. Necessary certificates / documents required for the bought out items are to be produced.

a) **GUARANTEE:**

The contractor shall guarantee the material and workmanship of the entire system for a period of 12 months from the date of commissioning or 18 months from the date of the supply of the items and hand over necessary documentations. Guarantee / test certificates of equipment from suppliers / manufacturers / contractor shall be handed over to the Owner.

In case of any defective equipment / material / workmanship, the contractor shall rectify/modify/replace the defective item at free of cost. Any delay on the part of the contractor in doing so, gives the owner the right to get the defect rectified through other agency and the cost for the same shall then be borne by the contractor.

a. **INSTRUCTION MANUAL/COMPLETION DRAWINGS/TRAINING:**

The contractor shall furnish detailed instruction and operation manual in quadruplicate. The contractor shall also furnish detailed completion drawings as soft copy (in AutoCAD format) and hard copy on tracing sheet. The drawings shall be inclusive of control schematic, if any. The contractor shall train the Employer's personnel in the operation and maintenance of the system.

1. **TESTING:**

The Contractor shall arrange to test the entire system as per the procedure enumerated under particular specifications, after the erection is completed. The test reports shall be duly signed and sealed by foreman and subsequently submitted to the Owners and Architects in triplicate. If the results of the tests are not found to be satisfactory by the Owners and Architects, necessary rectification shall be done until the test results are found to be satisfactory. The installation shall be deemed to be completed only after successful completion of the tests.

(a) **TESTING PROCEDURE:**

All piping shall be hydraulically tested for 1.5 times of working pressure after completion of erection to check for leakages. The water shall be held for 6 hours and any leakages found are to be rectified, the water has to be drained out completely, flush out the entire pipe line with the compressed air continuously to remove all traces of the moisture / water traces if any left with in the pipeline.

The pipeline where hydraulic testing is not practically feasible there it shall be pneumatically tested at 1.5 times of working pressure after completion of erection to check for leakages.

d) **PRE-DESPATCH INSPECTION:**

Pre-dispatch inspection to be arranged for representatives of owner for the items like Air compressor, Air dryer and Air Receiver at the suppliers work. Where the performance of the equipments can be checked. The responsibility lies with the contractor for successful installation and commissioning of the equipments towards entire satisfaction to the owner at the site. Final acceptance shall be after entire satisfaction to owner.

2. **CUTTING AND WELDING PROCEDURE:**

2.1 **CUTTING:**

Pipe and plates shall be cut as per the standard engineering practice by suitable means. No Electric metal arc cutting shall be allowed.

All edges cut by oxy-acetylene shall be cleaned of impurities prior to welding joints.

2.2 **CUTTING TOLERANCE SHALL BE AS FOLLOWS:**

a) For pipe or plates connected at both ends to - 1mm
b) Elsewhere to -3mm

2.3 **EDGE PREPARATION OFPIPES FOR WELDING:**

The edge preparation for welding of pipes more than ½” wall thickness shall be done by flame cutting and followed by grinding. Cut faces shall not have cracks or irregular. Edge preparation of pipe diameters below ½” wall thickness shall be done by Grinding Machine.

Sharp edges, rust of cut edges, notches, and irregularities fissures due to faulty cutting shall be chipped, grounded over the length.

Edge preparation for welding joints shall be carefully and accurately made so as to facilitate a perfect weld joints. Generally no special edge preparation shall be required for pipes under 1/6” wall thick.

Edge preparation beveling denotes cutting and grinding of the same so as to result in ‘V’ or ‘X’ shapes as per IS: 823.

The pipes to be assembled shall be clean and dry on the welding edges. Under no circumstances wet, greasy rust or dirt covered parts shall be welded.

2.4 **WELDING PROCEDURE:**

Welding shall be carried out only by fully qualified welders as tested and approved by the architects / consultants. Any test carried out in presence of either the architects / consultants or their representative or the inspectors shall constitute a right by them for such tests and the cost involved there on shall be borne by the contractor himself.

When welding is carried out in open air, steps shall be taken to protect the place of welding against wind, rain or moisture, the welding electrodes and parts being welded shall be dry.

Prior to the commencement of the welding, welder has to check the root gaps for all butt welds for single or double ‘V’ as per IS: 823. The welding joints shall be allowed to cool slowly.

For multilayer welding, before welding the following layer, the formerly welded layer shall be cleaned to metal bright by light chipping and wire brushing. Packing strips shall not be allowed i.e., all slag shall be removed.

Only welding generator / rectifier shall be used for welding.

**Welder Qualification:**

2G welding position qualification test will be conducted in presence of Consultant / PMC / Client.

**Electrodes:** Welding electrodes with a suitable coating shall be in accordance with applicable IS and of a recognized quality of reputed manufacturers.

**INSTALLATION**

Above Ground piping – All piping shall be erected as shown in the drawings and in accordance with the specifications so as to conform to the applicable codes and engineering design.

Arrangement drawings shall show general location and should indicate special dimensions, locations of valves, fittings etc wherever critical.

Slopes of piping specified on drawings shall be maintained.

INSIDE SHOP PIPELINE: The compressed air pipeline inside the shops should be laid along the walls with necessary brackets and supports. Adequate pipe supports, anchors and guides for piping shall be provided. The fabrication shall be as per the best engineering practice as laid down in the IS.

**BRACKETS / SUPPORTS:**

All brackets / supports shall be made out of suitable M.S. rolled steel sections, bar and strip with C.I. washers, helical springs, sling eyes, U bolts etc fixed on the walls or hung from the slabs/ roof truss by MS rods / angles including grouting / welding or fixed to special insert plates (already provided in the construction) or fixed to special inserts as the case may be including fasteners, bolts, anticorrosive and color painted etc complete as required and / or by suitable means as per best engineering practice and

2.5 **WELDING INSPECTION:**

All weld joints shall be DP tested after completion of the welding for blow holes, cracks etc.,

2.6 **SOCKET WELD :**

Allowable diameter range:

Threaded ≤ 2” NB

Welded > 2” NB

SIGNATURE OF TENDERER WITH SEAL

EMPLOYER

Page 6 of 13
3. TECHNICAL SPECIFICATIONS:

3.1 PIPES:
   i. Material : Mild Steel
      Material of Construction : As per IS: 1239
      Type : ERW
      Class : Heavy
   ii. Material : Stainless Steel
      Material of Construction : As per ASTM A312 Gr.TP304
      Type : Seamless
      Class : Sch80s

3.2 FLANGES:
   i. Material : Mild Steel
      Material of Construction : As per IS: 1239 Part:II
      Type : SORF
      Standard : As per ANSI B16.5
      Rating : 150 #
   ii. Material : Stainless Steel
      Material of Construction : As per ASTM A240 Gr. F304
      Type : WNRF
      Standard : As per ANSI B16.5
      Rating : 2500 #

3.3 FITTINGS:
   i. Material : Mild steel
      Material of construction : As per IS:1239 Part-II
      Standard : As per ANSI B 16.9
      Class : Heavy
   ii. Material : Stainless Steel
      Material of construction : As per ASTM A182 Gr.F304
      Standard : As per ANSI B 16.9
      Class : Heavy (as per BOQ)

3.4 GASKET:
   Material : Neoprene
   Thickness : 3.0mm
   Standard : As per ANSI B16.21
   Sizes : To match RF 150# and 2500# rating flanges

3.5 BOLTS & NUTS:
   Type : Hexagonal
   Material : Carbon steel / Stainless Steel
   Standard : As per IS:1364 & 1367

3.6 ISOLATION VALVE:
   i. Type : Ball Valve
      Material of construction : Forged carbon steel from 15 to 40 mm NB
                                  Cast carbon steel from 50 to 150 mm NB
      Body : (<40NB) : ASTM A 105
             (>40NB) : ASTM A 216 Gr. WCB
      Ball : AISI 304
      Stem : AISI 304
### Seat & seal
- **Ends**: Flanged to ANSI B16.5, 150#
- **Lever**: Carbon Steel with PVC Sleeve
- **Hydro Test Pressure**
  - **Body**: 30 Kg/cm²
  - **Seat**: 21 Kg/cm²

### ii. Type
- **Stop Valve**

#### Material of construction
- **Body**: Brass / Bronze
- **Spindle**: Stainless steel
- **Hand wheel**: Aluminium alloy
- **O-ring**: Nitrile
- **Backup ring**: PTFE
- **Ends**: < 15NB, Socketwelded
  - 15NB, Flanged to ANSI B16.5, 2500#

#### Valve operating pressure
- 250bar

### 3.7 PRESSURE GAUGE:

#### i. Type
- **Bourdon tube Pressure gauge**
- **Dial size**: 100 MM
- **Range**: 0-10kg/cm²
- **Mounting**: Direct Mounting
- **Housing**: Weather proof housing
- **Pointer**: Micro type adjustable pointer
- **Case**: Stainless Steel
- **Connection**: ½” BSP Bottom connection

#### ii. Type
- **Bourdon tube Pressure gauge**
- **Filling**: Glycerin
- **Dial size**: 100 MM
- **Range**: 0-21kg/cm², 0-40kg/cm², 0-70kg/cm², 0-160kg/cm², 0-280kg/cm²
- **Mounting**: Direct Mounting
- **Housing**: Weather proof housing
- **Pointer**: Micro type adjustable pointer
- **Case**: Stainless Steel
- **Connection**: ½” BSP Bottom connection

### 3.8 PRESSURE REGULATOR:

#### i. Location
- **Filling station**
- **Type**: Pilot operated
- **Size**: 15NB
- **Inlet Pressure**: 250barg
- **Outlet Pressure range**
  - a. 25-100barg
  - b. 100-150barg
  - c. 150-200barg
  - d. 200-250barg
- **Flow rate**: 150nCu.m/hr (approximately)
- **Material of construction**
  - **Body & trim**: AISI 304
  - **Seal**: Fluoroelastomers
  - **Seat**: PTFE

#### ii. Location
- **Shop 204A (Building 20/1)**
- **Type**: Pilot operated
- **Size**: As per BOQ
- **Inlet Pressure**: 250barg
- **Outlet Pressure range**: 150-200barg
Flow rate : 20nCu.m/hr  
Material of construction : Body & trim : AISI 304  
Seal : Fluoroelastomers  
Seat : PTFE

iii. **Location** : Shop 204B (Building 21/1)  
Type : Pilot operated  
Size : As per BOQ  
Inlet Pressure : 250barg  
Outlet Pressure : 65barg  
Flow rate : 30nCu.m/hr  
Material of construction : Body & trim : AISI 304  
Seal : Fluoroelastomers  
Seat : PTFE

iv. **Location** : Shop 204B (Building 21/1)  
Type : Pilot operated  
Size : As per BOQ  
Inlet Pressure : 250barg  
Outlet Pressure range : 10-18barg  
Flow rate : 100nCu.m/hr  
Material of construction : Body & trim : AISI 304  
Seal : Fluoroelastomers  
Seat : PTFE

v. **Location** : Shop 204A (Building 20/1)  
Type : Pilot operated  
Size : As per BOQ  
Inlet Pressure : 250barg  
Outlet Pressure range : 15-25barg  
Flow rate : 170nCu.m/hr  
Material of construction : Body & trim : AISI 304  
Seal : Fluoroelastomers  
Seat : PTFE

### 3.9 SAFETY RELIEF VALVE:

<table>
<thead>
<tr>
<th>Location</th>
<th>Filling Station</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type</td>
<td>Self-actuating, full lift, spring loaded</td>
</tr>
<tr>
<td>Discharge</td>
<td>Angle</td>
</tr>
<tr>
<td>Bonnet</td>
<td>Closed</td>
</tr>
<tr>
<td>Set Pressure</td>
<td>As given in BOQ</td>
</tr>
<tr>
<td>Pressure Rating</td>
<td>As given in BOQ</td>
</tr>
<tr>
<td>End Connection</td>
<td>Flanged, as per ANSI B 16.5</td>
</tr>
</tbody>
</table>

### 3.10 PRESSURE REGULATING STATION:

- **a. PRS** : 250barg to 150barg (Location: On branch line to Phase-II & III buildings)  
- **b. PRS** : 150barg to 42barg (Location: On branch line to Shop 204A; 20/1 building)  
- **c. PRS** : 150barg to 30barg (Location: On branch line to Shop 204B; 21/1 building)  
- **d. PRS** : 150barg to 18barg (Location: On branch line to Shop 203; 1/1 building)  

Pressure regulating station consisting of  
(a) Isolation valve  
(b) Pressure regulator  
(c) Pressure gauge  
(d) Safety relief valve
Isolation Valve:

Type: Ball Valve
Material of construction:
- Forged stainless steel from 15 to 40 mm NB
- Cast stainless steel from 50 to 150 mm NB
Body:
- (<40NB): ASTM A 182 Gr.F304
- (>40NB): ASTM A 351 Gr.CF3
Ball: AISI 304
Stem: AISI 304
Seat & seal: PTFE
Ends: Flanged to ANSI B16.5
Lever: Carbon Steel with PVC Sleeve
Valve operating pressure: 250bar; 150bar; 42bar; 30bar, 18bar

Pressure Regulator:

Type: Pilot operated
Inlet Pressure:
- a. 250barg
- b. 150barg
- c. 150barg
- d. 150barg
Outlet Pressure range:
- a. 150barg
- b. 42barg
- c. 30barg
- d. 18barg
Flow rate:
- a. 380nCu.m/hr
- b. 180nCu.m/hr
- c. 120nCu.m/hr
- d. 2nCu.m/hr
Material of construction:
- Body & trim: AISI 304
- Seal: Fluoroelastomers
- Seat: PTFE

Pressure gauge:

Type: Bourdon tube Pressure gauge
Filling: Glycerin
Dial size: 100 MM
Size:
- a. 0-160kg/cm², 0-280kg/cm²
- b. 0-70kg/cm², 0-160kg/cm²
- c. 0-40kg/cm², 0-160kg/cm²
- d. 0-21kg/cm², 0-160kg/cm²
Mounting: Direct Mounting
Housing: Weather proof housing
Pointer: Micro type adjustable pointer
Case: Stainless Steel
Connection: ½" BSP Bottom connection

Safety Relief Valve:

Type: Self-actuating, full lift, spring loaded
Discharge: Angle
Bonnet: Closed
Set Pressure:
- a. 151barg
- b. 43barg
- c. 31barg
- d. 19barg
Pressure Rating:
- a. 1500#
b. 300#
c. 300#
d. 300#

Material of construction : Body & trim : Stainless steel 316
Seal : BUNA-N Elastomer
Seat : PTFE

End Connection : Flanged, as per ANSI B 16.5

3.11 DRIP-LEG DRAIN:

Inlet Port : 1/2” BSP Female.
Max. Pressure : 10 Kg/cm², 250 Kg/cm²
Body : Carbon Steel
Bowl : Transparent Polycarbonate bowl.
Draining : Automatic

3.12 QUICK FIX COUPLING:

i. Quick Release Coupling size : As per BOQ
Construction : Poppet Type
Mounting (Ends) : Threaded
Material : Body : Brass with Nickel Plating
Spring : Spring steel
Ball : SS 304
Seal : NBR

Working pressure : 8 kg/cm²
Check valves : Single check valve in socket, with heavy duty Sleeve with NBR Rubber Seal.
End Connections : Socket : Threaded & Plug
 materially – MS with Zinc Plating)
Plug : Feasible for Rubber hose pipe connection.

ii. Quick Release Coupling size : As per BOQ
Construction : Poppet Type
Mounting (Ends) : Threaded
Material : Body : Stainless Steel 304
Spring : Spring steel
Ball : SS 304
Seal : Viton

Working pressure : 250 kg/cm²
Check valves : In socket as well as in plug, with heavy duty Sleeve with Viton Seal.
End Connections : Socket : Threaded & Plug
( material – Stainless steel)
Plug : Feasible for Rubber hose pipe connection.

Important Note : One sample has to be approved from M/s HAL prior to bulk supply.
## 4. LIST OF APPROVED MAKES:

<table>
<thead>
<tr>
<th>S.NO.</th>
<th>DESCRIPTION</th>
<th>MAKE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>PIPES - MS</td>
<td>TATA / JINDAL</td>
</tr>
<tr>
<td>2</td>
<td>PIPE FITTINGS – MS</td>
<td>BHARAT FORGE / SANGHI IMPEX / METAL UDYOG</td>
</tr>
<tr>
<td>3</td>
<td>ISOLATION VALVE</td>
<td>AUDCO/ HALE HAMILTON / PARKER/SWAGELOK</td>
</tr>
<tr>
<td>4</td>
<td>PRESSURE GAUGE</td>
<td>H-GURU / WIKA</td>
</tr>
<tr>
<td>5</td>
<td>PRESSURE REGULATOR</td>
<td>HALE HAMILTON / PARKER / SWAGELOK</td>
</tr>
<tr>
<td>6</td>
<td>PRESSURE REGULATING STATION</td>
<td>HALE HAMILTON / PARKER</td>
</tr>
<tr>
<td>7</td>
<td>SAFETY RELIEF VALVE</td>
<td>HALE HAMILTON / PARKER / SWAGELOK</td>
</tr>
<tr>
<td>8</td>
<td>GASKET</td>
<td>CHAMPION</td>
</tr>
<tr>
<td>9</td>
<td>QUICK FIX COUPLINGS</td>
<td>PARKER / TECHNO DRIVE (PNEUMAX) / PIONEER / SPIRAX / JANATICS or Equivalent</td>
</tr>
<tr>
<td>10</td>
<td>DRIP LEG DRAIN</td>
<td>PARKER / NORGREN / SPIRAX / JANATICS</td>
</tr>
<tr>
<td>11</td>
<td>BOLTS / NUTS</td>
<td>SKANDA / ZION / TVS / or equivalent.</td>
</tr>
</tbody>
</table>
Hindustan Aeronautics Ltd
Aircraft Division, Nasik

To: M/s EPIL

Date: 26/09/2015

Site Office, HAL Factory.

Sub: Clarifications pertaining to works related to Su30 ROH packages III.
Ref: Contract No. NK/FW/CAP-ROH-622/10-11 Package III
: EPIL letter nos. NSK/PMD/681/02 Dt. 18/08/2015
: Reply from Semac consultant referred to EPIL letter.

Kind Attention: Shri Sanjay Rawool – AGM (M/s EPIL)

Dear Sir,

Referring to queries raised through above letter by EPIL; following clarifications may please be noted:

1. Pressure regulators:
   Spring loaded type regulators from approved makes as per BOQ i.e. Hale Hamilton/Parker/Swagelok can be preferred and hence are approved because of their simplicity of design, ease of operation as springs of various rates can be adjusted to provide different outlet pressures, relatively small size hence requires less space and easy for installation, easy to operate, easy to replace and maintain, low running and maintenance cost and also have good stability.

2. Material of construction for valves and PR:
   Please note that the specifications for performance and materials standards specified in technical specs and BOQ are the recommended quality standards. However vendors can consider units (standardized as per OEM) i.e. items having better performance and materials which supersede tech specs and BOQ specifications. However these should be substantiated with documents like OEM catalogues etc.

3. Safety Relief Valves – as per approved makes as per BOQ and M/s Fainger Leser (which is reputed manufacturer of SRV's worldwide) approved for size which the approved makes do not manufacture.

Through M/s Semac Ltd.

SN Chaudhary
Mgr. (Maint)

Gopal Kulkarni
CM (Maint)

Cc: DGM (A.S.) – for kind information please.
: M/s Semac Ltd. - for information and necessary action please.
: FNCS – o/c