

Annexure-II

**SCOPE OF WORK**

TECHNICAL SPECIFICATION FOR DESIGN, MANUFACTURE & SUPPLY OF LACQUER BAKING OVEN FOR SHELL & LID INCLUDING CONVEYING MECHANISM WITH AUTOMATIC ENTRY / EXIT CONVEYORS FOR INTERNALLY COATED MILD STEEL SHELL & LID OF 210 LTR DRUM & ERECTION, COMMISSIONING OF THE SAME AT OUR UPCOMING VADODARA PLANT LOCATED WITHIN 50 KM RADIUS FROM VADODARA RAILWAY STATION. OVEN CONSISTE OF TWO ROWS OF VERTICALLY SHELL CARRYING CONVEYORS OF CRATE CHAIN TYPE CONSTRUCTION & ONE ROW OF VERTICALLY LID CARRYING CONVEYOR OF WICKET TYPE CONSTRUCTION. OTHER DETAILS ARE AS GIVEN BELOW

**OVEN DETAILS FOR DRUM SHELL - QTY 1 No**

**General Specification:**

Capacity (Output):	240 drum Shells / Hour
Normal Baking temperature (Effective Metal temperature):	220 - 230°C
Max. Air Temperature inside oven:	250°C
Fuel:	LDO/HSD/PNG

**Dimensions of drums**

**Shell:**

Nominal Drum Volume:	200 - 250 ltrs
Drum Shell Height:	800 mm up to 1050 mm
Drum Shell Diameter:	500 - 620 mm
Drum Shell Max. Weight:	up to 19 kg
Drum Shell Nominal Weight:	11 to 16 kg
Material thickness:	0.6 - 1.25 mm

**Conveyor details:**

Number of Drum Shells in 1 row transverse to the conveyor:	2
Distance of the centre axes of the drums (in conveying direction):	700 mm
Distance of the centre axes of the drums (in rectangular direction):	700 mm
Mode of Shell Travel:	Vertical
Speed of the conveyor system:	To match the output rate
Height above floor of the conveyor system:	800 mm Approx.

# CORRIGENDUM

Balmer Lawrie & Co. Ltd.  
SBU: Industrial Packaging

Tender No. 0100PM0981 dated 23.12.2017

## Heating Tunnel

Hot air generator **inner most shell** to be made out of S.S.310 material having thickness 3mm

Total Tunnel length (heating zone): Bidder to work out as per output rate and baking cycle time.

Total Drying time (come-up time  
plus baking time):

20 min at 240 drum Shells/hour

Number of heating zones:  
Schedule.

As per Bidder's design For given Baking

## OVEN DETAILS FOR DRUM ENDS ( TOPS/ BOTTOMS): Qty. 1 No

Capacity (Output):

480 Drum Ends/Hour

Normal Baking Temperature:  
(Effective Metal Temperature)

220 - 230°C

Fuel:

LDO/ HSD / PNG

Max. Baking Temperature:

250°C

Total Drying time (come-up time  
plus baking time):

20 min at 480 drum Ends/Hour

## End dimensions:

Outside diameter of drum ends:

420 - 630 mm ( Approx.)

Weight per Drum End:

3.5 kg (Approx.)

Thickness of drum end :

0.6 – 1.5 mm

Max. depth of Drum End:

32 mm ( Approx.)

## Conveyor details:

Number of Drum Ends/wicket Conveyor:

1

Pitch of Wicket conveyor: As per Bidder's design to match output rate and baking cycle.

Mode of Lid Travel : Vertical

**Heating Tunnel** : Tunnel length (Heating Zone): Bidder to work out as per Output rate and baking cycle time -

Total Baking time (come-up time plus baking  
time) at a speed of 480 drum ends/hr:

20 min

**Entry & Exit Conveyors** - To match the smooth movement /transfer of drum shells & lids.