

# THE TRICHUR CO OPERATIVE SPINNING MILLS LTD

Vazhani P O, Wadakkanchery, Thrissure

## LIST OF PRESENT RUNNING MACHINES for DISMANTLING, SHIFTING, RE-ERECTON,OVERHAULING OF THE EXISTING SPINNING MACHINES

### SCOPE OF WORK

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| <b>S No:1</b>  | Department  | : | <b>BLOW ROOM</b>   |
|                | Details of Machineries are to be overhauled (no shifting) | : | GBR- 1 No, BEATER – 2 Nos, CONDENSOR – 1 No including lattices, calendar rollers, lap delivery mechanism etc   |
|                | Scope of work   | : | Overhauling and Fine tuning the machine including internal electrical panel and connection work.   |
| <b>S No:2</b>  | Department  | : | <b>CARDING</b>   |
|                | Details of Machineries shifted, re erected & overhauling  | : | TRUMAC DK 780 CARDS -4 Nos   |
|                | Scope of work   | : | Dismantling the Machines, move to the proposed area and re erect without damaging the body of machine. Dynamic balancing of Cylinders of DK 780 cards. Servicing of all spares and changing the damaged spares including bearings. Re mounting work of Cylinder, Doffer wires. Flat mounting and licker – in will be done by the Mills. Change the required spares as per the instruction from the mills Technical Department. Overhauling of Machines. Setting of the machine is to be done, to get 85 % nep removal efficiency. Restarting the machines. Fine tuning the machine to get good working performance and below 4.5% 5yard sliver CV%. Including internal electrical panel and connection work. Required greasing has to be done. |
| <b>S No: 3</b> | Department  | : | <b>DRAWING</b>   |

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|                | Details of Machineries to be shifted and re erected | : | 1 No LR RSB 851 Draw frames   |
|                | Scope of work                                       | : | Dismantling of the machines. Move and Re erect of in the proposed place as per machinery layout. Change the required spares as per the instruction from the mills Technical Department. Overhauling of Machines. Setting of the machine. Restarting the machines. Fine tuning the machine to get good working performance and 1.25% 1 yard sliver CV% in breaker delivery and 0.5% 1yard sliver CV% for finisher delivery. Calibration of Auto leveling in RSB Draw frame and A% should be corrected as STD. Including internal electrical panel and connection work. Required greasing has to be done.   |
| <b>S No: 4</b> | Department  | : | <b>SIMPLEX MACHINES</b>   |
|                | Details of Machineries to be shifted and re erected | : | 4 Nos of LR make LF 1400 Model Simplex machines. Which is now having 120 per spindles per machine and this has to convert 144 spindles per machines as 3 machines and 96 spindles per machine as one machine by taking spindles from other machines.  |
|                | Scope of work                                       | : | Dismantling of the machines. Move the machines and Re erect the machines in the proposed place as per new machinery lay out. Change the required spares as per the instruction from the mills Technical Department. Overhauling of Machines. Top arm setting is to be done. Top arm complaints should be corrected by changing required spares. Truing of bottom roller should be done as per the STD tolerance. Flyer leveling and Bobbin rail leveling is to be done. Re starting the machines. Fine tuning the machine to get good working performance. Breaks per 100 spindle hrs should be fine tuned for below 4.0 and below 1.250% of 15 yard roving CV% .Stretch of the roving should be corrected for 0.5%. Building |

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|                |   |   | mechanism fine tuning should be done. Including internal electrical panel and connection work. Required greasing has to be done.  |
| <b>S No: 5</b> | Department                                    | : | <b>RING FRAMES</b>  |
|                | Details of Machineries shifted and re erected | : | 13 Nos of LR make LR G5/1 Model Ring frames ( Total 13104 spindles, 1008 spindles per machine). This Machines have to convert 1152 spindles per machine and will become 11 machines + one Machine of 432 spindles. Initially the machines having 1008 spindles per machine have to shift and to be started. Then after the completion of 8 machines and arrival of extra accessories of extension of the machines, these 8 machines are to be extended to 1152 spindles per machine. Finally one machine of 432 spindles is to be erected. Required greasing has to be done.  |
|                | Scope of work                                 | : | Dismantling of the machines. Move the machines and Re erect the machines in the proposed place as per new machinery lay out. Change the required spares as per the instruction from the mills Technical Department. Overhauling of Machines. Top arm setting is to be done. Top arm, Top arm loading complaints should be corrected by changing required spares. Gear end servicing and additional gearbox, delayed drafting gear box servicing is to be done. Variable speed system servicing should be done. Rings and spindles changing are to be done if necessary. Spindle, Lappet, ANBC Rings centering should be done. Ring rail, Lappet rail leveling is to be done. Re starting the machines. Fine tuning the machine to get good working performance. Breaks per 100 spindle hrs should be fine tuned for below 8.0 and below 2.0 % of yarn CV%. Cop Building mechanism fine tuning is to be done to get the cop content at standard level. All the |

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|                |   |   | bearing has to be checked and to be replaced if damaged. Including internal electrical panel and connection work. Required greasing has to be done.   |
| <b>S No: 6</b> | Department                                    | : | <b>Double sided reels</b>   |
|                | Details of Machineries shifted and re erected | : | 15 Nos of Double Sided Reels.   |
|                | Scope of work                                 | : | Dismantling of the machines. Move the machines and Re erect the machines in the proposed place as per new machinery lay out. Change the required spares as per the instruction from the mills Technical Department. Overhauling of Machines. Including internal electrical panel and connection work. Required greasing has to be done. |

Before submitting the tender, **there will be a pre bid meeting as per the Tender notification** which confirms the actual gravity and scope of work so that the bidder can quote their competitive rate.

After confirming tender, the Service Contractor/Technician should be inspect the machinery and prepare the minimum spare list required for shifting and overhauling the machines with the consultation of Mill Technicians and MD.

**For Trichur Cooperative Spinning Mills Ltd**

**Managing Director**

**Accepted By**

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