



**RETURN BIDS TO:**  
**RETOURNER LES SOUMISSIONS À:**

**Bid Receiving - PWGSC / Réception des  
soumissions - TPSGC**  
**11 Laurier St./ 11 rue, Laurier**  
**Place du Portage, Phase III**  
**Core 0A1 / Noyau 0A1**  
**Gatineau, Québec K1A 0S5**  
**Bid Fax: (819) 997-9776**

**REQUEST FOR PROPOSAL**  
**DEMANDE DE PROPOSITION**

**Proposal To: Public Works and Government  
Services Canada**

We hereby offer to sell to Her Majesty the Queen in right of Canada, in accordance with the terms and conditions set out herein, referred to herein or attached hereto, the goods, services, and construction listed herein and on any attached sheets at the price(s) set out therefor.

**Proposition aux: Travaux Publics et Services  
Gouvernementaux Canada**

Nous offrons par la présente de vendre à Sa Majesté la Reine du chef du Canada, aux conditions énoncées ou incluses par référence dans la présente et aux annexes ci-jointes, les biens, services et construction énumérés ici sur toute feuille ci-annexée, au(x) prix indiqué(s).

**Comments - Commentaires**

<b>Title - Sujet</b> Calibration line for extruding PVC	
<b>Solicitation No. - N° de l'invitation</b> 31026-135191/A	<b>Date</b> 2013-11-22
<b>Client Reference No. - N° de référence du client</b> 31026-135191	
<b>GETS Reference No. - N° de référence de SEAG</b> PW-\$\$PV-929-63959	
<b>File No. - N° de dossier</b> pv929.31026-135191	<b>CCC No./N° CCC - FMS No./N° VME</b>
<b>Solicitation Closes - L'invitation prend fin</b> <b>at - à 02:00 PM</b> <b>on - le 2014-01-06</b>	<b>Time Zone</b> <b>Fuseau horaire</b> Eastern Standard Time EST
<b>F.O.B. - F.A.B.</b> <b>Plant-Usine:</b> <input type="checkbox"/> <b>Destination:</b> <input checked="" type="checkbox"/> <b>Other-Autre:</b> <input type="checkbox"/>	
<b>Address Enquiries to: - Adresser toutes questions à:</b> Martin, Doug	<b>Buyer Id - Id de l'acheteur</b> pv929
<b>Telephone No. - N° de téléphone</b> (819) 956-4037 ( )	<b>FAX No. - N° de FAX</b> (819) 956-3814
<b>Destination - of Goods, Services, and Construction:</b> <b>Destination - des biens, services et construction:</b> NATIONAL RESEARCH COUNCIL CANADA 75 BOUL.DE MORTAGNE VIA LAUZON BOUCHERVILLE Quebec J4B6Y4 Canada	

**Instructions: See Herein**

**Instructions: Voir aux présentes**


**Vendor/Firm Name and Address**

**Raison sociale et adresse du  
fournisseur/de l'entrepreneur**

**Issuing Office - Bureau de distribution**

Scientific, Medical and Photographic Division / Division de  
l'équipement scientifique, des produits photographiques et  
pharmaceutiques  
11 Laurier St./ 11 rue, Laurier  
6B1, Place du Portage  
Gatineau, Québec K1A 0S5

<b>Delivery Required - Livraison exigée</b> See Herein	<b>Delivery Offered - Livraison proposée</b>
<b>Vendor/Firm Name and Address</b> <b>Raison sociale et adresse du fournisseur/de l'entrepreneur</b>	
<b>Telephone No. - N° de téléphone</b> <b>Facsimile No. - N° de télécopieur</b>	
<b>Name and title of person authorized to sign on behalf of Vendor/Firm</b> <b>(type or print)</b> <b>Nom et titre de la personne autorisée à signer au nom du fournisseur/ de l'entrepreneur (taper ou écrire en caractères d'imprimerie)</b>	
<b>Signature</b>	<b>Date</b>

<div>  <div>Public Works and Government Services Canada</div> </div>		Travaux publics et Services gouvernementaux Canada		Document No.31026-135191/A		Part - Partie 1 of - de 2		See Part 2 for Clauses and Conditions Voir Partie 2 pour Clauses et Conditions	
Item Article	Description	Dest. Code Dest.	Inv. Code Fact.	Qty Qté	U. of I. U. de D.	Unit Price/Prix unitaire FOB/FAM		Delivery Req. Livraison Req.	Del. Offered Liv. offerte
						Destination	Plant/Usine		
1	Calibration line for extruding PVC profiles	31026	31026	1	Each	\$	XXXXXXXXXXXX	See Herein	
2	Transport costs	31026	31026	1	Each	\$	XXXXXXXXXXXX	See Herein	

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## PART 1 - GENERAL INFORMATION

### 1. Security Requirement

There is no security requirement associated with the requirement.

### 2. Requirement

The National Research Council (NRC) Canada has a requirement for the supply of **“Calibration line for extruding PVC profiles”**.

The National Research Council (NRC) Canada has a requirement for the supply of “Calibration line for extruding PVC profiles”.

The line will be installed on a 20 mm laboratory twin-screw extruder (manufacturer Labtech Engineering Company Ltd., model no. LTE20-40) already owned by NRC.

The desired calibration line shall consist of two (2) PVC profile extrusion dies with a hollow cavity on the inside, and stainless steel wet and dry calibrators to ensure that the PVC profiles are the right shape.

The calibration line must also include a vacuum calibration table for wet and dry calibration and a fly-knife cutter. The calibration line will be used to test new materials for industrial applications, specifically in the automotive and construction industries, accordance with the mandatory specifications detailed at Annex “A”.

Installation, training and manuals included.

### 3. Debriefings

After contract award, bidders may request a debriefing on the results of the bid solicitation. Bidders should make the request to the Contracting Authority within 15 working days of receipt of notification that their bid was unsuccessful. The debriefing may be provided in writing, by telephone or in person.

## PART 2 - BIDDER INSTRUCTIONS

### 1. Standard Instructions, Clauses and Conditions

All instructions, clauses and conditions identified in the bid solicitation by number, date and title are set out in the Standard Acquisition Clauses and Conditions Manual issued by Public Works and Government Services Canada (PWGSC). The Manual is available on the PWGSC Website:

<https://buyandsell.gc.ca/policy-and-guidelines/standard-acquisition-clauses-and-conditions-manual>

Bidders who submit a bid agree to be bound by the instructions, clauses and conditions of the bid solicitation and accept the clauses and conditions of the resulting contract.

The following are incorporated by reference into and form part of the bid solicitation.

**The 2003 ( 2012-11-19) Standard Instructions - Goods or Services - Competitive Requirements,**

### 2. Submission of Bids

Bids must be submitted only to Public Works and Government Services Canada (PWGSC) Bid Receiving Unit by the date, time and place indicated on page 1 of the bid solicitation.

### 3. Applicable Laws

Any resulting contract must be interpreted and governed, and the relations between the parties determined, by the laws in force in Ontario.

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Bidders may, at their discretion, substitute the applicable laws of a Canadian province or territory of their choice without affecting the validity of their bid, by deleting the name of the Canadian province or territory specified and inserting the name of the Canadian province or territory of their choice. If no change is made, it acknowledges that the applicable laws specified are acceptable to the bidders.

#### **4. Enquiries - Bid Solicitation**

All enquiries must be submitted in writing to the Contracting Authority no later than ten (10) calendar days before the bid closing date. Enquiries received after that time may not be answered.

Bidders should reference as accurately as possible the numbered item of the bid solicitation to which the enquiry relates. Care should be taken by bidders to explain each question in sufficient detail in order to enable Canada to provide an accurate answer. Technical enquiries that are of a proprietary nature must be clearly marked "proprietary" at each relevant item. Items identified as "proprietary" will be treated as such except where Canada determines that the enquiry is not of a proprietary nature. Canada may edit the questions or may request that the Bidder do so, so that the proprietary nature of the question is eliminated, and the enquiry can be answered with copies to all bidders. Enquiries not submitted in a form that can be distributed to all bidders may not be answered by Canada.

## PART 3 - BID PREPARATION INSTRUCTIONS

### 1. Bid Preparation Instructions

Canada requests that bidders provide their bid in separately bound sections as follows:

**Section I: Technical Bid (two (2) hard copies), consisting of technical brochures/literature to verify compliancy and test data, if applicable**

**Section II: Financial Bid (one (1) hard copy)**

**Section III: Certifications (one (1) hard copy)**

#### ***Prices must appear in the financial bid only.***

No prices must be indicated in any other section of the bid.

Bidders are requested to submit one quotation document with prices, and a second quotation document with prices removed.

Canada requests that bidders follow the format instructions described below in the preparation of their bid:

- (a) use 8.5 x 11 inch (216 mm x 279 mm) paper;
- (b) use a numbering system that corresponds to the bid solicitation;
- (c) include the certifications as a separate section of the bid.
- (d) In April 2006, Canada issued a policy directing federal departments and agencies to take necessary steps to incorporate environmental considerations into the procurement process Policy of Green Procurement ( <http://www.tpsgc-pwgsc.gc.ca/ecologistation-greening/chats-procurement/politique-policy-eng.html> ). To Assist Canada in reaching its objectives, bidders are encouraged to:

1) use 8.5. X 11 inch ( 216 mm X 279 mm ) paper containing fibre certified as origination from a sustainably-managed forest and /or containing minimum 30% recycled content; and

2) use an environmentally-preferable format including black and white printing instead of colour printing, printing double sided/duplex, using staples or clips instead of cerlox, duotangs or binders.

#### **1.1 Section I: Technical Bid**

In their technical bid, bidders should explain and demonstrate how they propose to meet the requirements and how they will carry out the Work.

The following applies to the Requirement and bidders must provide the following information in the bid where applicable:

##### **1.1.1 Product(s) Offered ( To be completed by bidder )**

Indicate the make and model of the product(s) offered:

Name of Manufacturer: \_\_\_\_\_

Model/Part Number: \_\_\_\_\_

**1.1.2 Point of Manufacture/Shipping** ( To be completed by bidder )

The Bidder must state the point of manufacture/shipping of goods:

Location: \_\_\_\_\_ Postal Code: \_\_\_\_\_

**1.1.3 Delivery** ( To be completed by bidder )

Delivery is requested by 01 March 2014, the best delivery that could be offered by the Bidder is \_\_\_\_\_.

**Delivery is Mandatory by March 28, 2014.**

**Installation** ( To be completed by bidder )

On-site installation must be provided and shall be carried out by a qualified service technician.

State your best installation schedule. Installation must be carried out within five ( 05 ) calendar days of delivery and be completed within \_\_\_\_\_ ( \_ \_ ) calendar days.

**Documentation** ( To be completed by bidder )

Operator and Service Manuals must be supplied with the equipment.

Operational manuals in English available. \_\_\_\_\_ Yes.

Service manuals in English available. \_\_\_\_\_ Yes.

Operational manuals in French available. \_\_\_\_\_ Yes.

Service manuals in French available. \_\_\_\_\_ Yes.

**Training** ( To be completed by bidder )

On-site user training must be provided for up to three ( 03 ) users in French or English,. All costs associated with the on-site training must be included in the price.

On-site training will be completed within five( 05 ) calendar days of installation. Provide complete details of training e.g. duration, scope, etc.,

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**Service** ( To be completed by bidder )

Technical support must be available in French or English by email, telephone or online from 8:00 a.m. to 8:00 p.m. (Eastern Time) from Monday to Friday, except on statutory holidays.

Response for service shall be within 24 hours or less.

On-site repairs and troubleshooting must be provided on the NRC site within five (5) calendar days following a service call.

Also, provide the following with your bid:



a) Location of available service facilities (after sales service and repair). List the service facilities closest to the destination.

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b) Locations of available replacement parts from consumables to major components.

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c) Response time re: service calls, and escalation schedule, i.e. (how many days with no resolution to a problem until a more experienced person is called in, and from which location).

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e) List the frequency of routine maintenance visits provided by a qualified service technician during the warranty period, if applicable and included in the price.

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#### 1.1.4 Contacts

Bidders are requested to provide the following:

Information pertaining to Part 6, Resulting Contract Clauses. 5.3 Contractor's Representative.

#### 1.2 Section II: Financial Bid

Bidders must submit their financial bid in accordance with the Basis of Payment. The total amount of Goods and Services Tax (GST) or Harmonized Sales Tax (HST) is to be shown separately, if applicable.

### PART 4 - EVALUATION PROCEDURES AND BASIS OF SELECTION

#### 1. Evaluation Procedures

- (a) Bids will be assessed in accordance with the entire requirement of the bid solicitation including the technical and financial evaluation criteria herein; and
- (b) An evaluation team composed of representatives of Canada will evaluate the bids.

All proposals submitted shall be completed in full and provide all of the information requested in the Request for Proposal (RFP) package to enable a full and complete evaluation. If the requirement is not addressed in the bidder's proposal, the proposal will be considered incomplete or non-responsive and will be rejected. The onus is on the bidder to provide all the information necessary to ensure a complete and accurate assessment.

## 2 Factors for Evaluation

1. **PRICING BASIS (MANDATORY):** Prices must be firm.
2. **BID VALIDITY PERIOD (MANDATORY):** Offers are to remain open for a period of not less than ninety (60) days from the date of closing of this Request for Proposal.
3. **ABILITY TO MEET THE TECHNICAL REQUIREMENT (MANDATORY):**

a) For Items Defined by Specifications:

The bidder MUST cross reference the mandatory technical criteria contained herein to their proposal providing clear indication where a bid does NOT conform to the specifications. If no exceptions are taken to the specifications, Canada will assume the bidder's complete compliance in their assessment of the offer and in any subsequent contract award.

b) Provision of Supporting Technical Documentation:

Supporting technical documentation for the stores offered shall be provided with the bid at time of bid closing. Technical brochures or technical data MUST be provided to verify compliancy to the technical mandatory specifications

4. **COMPLIANCE WITH THE TERMS AND CONDITIONS OF THIS REQUEST FOR PROPOSAL (MANDATORY)**
5. **FOR CANADIAN SUPPLIERS ONLY:** Please note that the requirements of the Federal Contractors Program for Employment Equity may apply - see herein. (MANDATORY if applicable)

### 3. Basis of Selection

1. A bid must comply with the requirements of the bid solicitation and meet all mandatory technical evaluation criteria to be declared responsive. The responsive bid with the lowest evaluated price, including options, will be recommended for award of a contract.
2. The lowest evaluated price will be established using the following criteria:
  - a) Prices will be evaluated in Canadian Funds including any applicable Excise Taxes and Canadian Customs Duty (if applicable) and excluding the Goods and Services Tax (GST) or Harmonized Sales Tax (HST). For evaluation purposes, bids received in a foreign currency will be converted to Canadian funds using the appropriate rate of exchange using the rate quoted by the Bank of Canada as being in effect on date of bid closing;
  - b) Prices will be evaluated on a "DDP Destination" basis, unless otherwise specified.

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3. Requests for Exchange Rate Fluctuation Protection and/or Progress Payments will not be considered.

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## PART 5 - CERTIFICATIONS

### Certifications with the Bid

In order to be considered for contract award, a bidder whose bid is technically and financially responsive, must meet the following conditions:

### Code of Conduct Certifications - Certifications Required Precedent to Contract Award

Bidders should provide, with their bids or promptly thereafter, a complete list of names of all individuals who are currently directors of the Bidder.

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Family Name

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Given Name(s)

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Family Name

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Given Name(s)

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Family Name

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Given Name(s)

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Family Name

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Given Name(s)

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Family Name

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Given Name(s)

If such a list has not been received by the time the evaluation of bids is completed, the Contracting Authority will inform the Bidder of a time frame within which to provide the information.

Bidders must submit the list of directors before contract award, failure to provide such a list within the required time frame will render the bid non-responsive.

The Contracting Authority may, at any time, request that a Bidder provide properly completed and Signed Consent Forms (Consent to a Criminal Record Verification form - PWGSC-TPSGC 229)

( <http://www.tpsgc-pwgsc.gc.ca/app-acq/forms/documents/229.pdf> ), for any or all individuals named in the aforementioned list within a specified delay.

Failure to provide such Consent Forms within the delay will result in the bid being declared non-responsive.

### Federal Contractors Program for Employment Equity - Certification

#### Federal Contractors Program for Employment Equity - over \$25,000 and below \$200,000

Organizations that are subject to the Federal Contractors Program for Employment Equity (FCP-EE) but that have been declared ineligible to receive government contracts of goods and services over the threshold for solicitation of bids as set out in the Government Contract Regulations (GCRs) (currently \$25,000, including all applicable taxes) by the Department of Human Resources and Skills Development (HRSD), either as a result of a finding of non-compliance by HRSD, or following their voluntary withdrawal from the FCP-EE for a reason other than a reduction in their workforce, have been advised by HRSD that as a consequence of this action they are no longer eligible to receive any government contract over this threshold. Consequently, their certificate numbers have been cancelled and their names have been

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placed on HRSD's List of Ineligible Contractors. Bids from such organizations will be considered non-responsive.

The Bidder certifies that it has not been declared "ineligible" by HRSD to receive government contracts over the GCRs threshold for solicitation of bids (currently \$25,000, including all applicable taxes) as a result of a finding of non-compliance, or as a result of having voluntarily withdrawn from the FCP-EE for a reason other than a reduction in their workforce.

The Bidder acknowledges that the Minister shall rely on this certification to award the Contract. Should a verification by the Minister disclose a misrepresentation on the part of the Bidder, the Minister shall have the right to treat any contract resulting from this bid as being in default, and to terminate it pursuant to the Default provisions of the Contract.

Signature of authorized representative: \_\_\_\_\_. Date: \_\_\_\_\_

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## PART 6 - RESULTING CONTRACT CLAUSES

### 1. Security Requirement

There is no security requirement associated with the requirement.

### 2. Requirement

The National Research Council (NRC) Canada has a requirement for the supply of "Calibration line for extruding PVC profiles" .

The line will be installed on a 20 mm laboratory twin-screw extruder (manufacturer Labtech Engineering Company Ltd., model no. LTE20-40) already owned by NRC.

The desired calibration line shall consist of two (2) PVC profile extrusion dies with a hollow cavity on the inside, and stainless steel wet and dry calibrators to ensure that the PVC profiles are the right shape.

The calibration line must also include a vacuum calibration table for wet and dry calibration and a fly-knife cutter. The calibration line will be used to test new materials for industrial applications, specifically in the automotive and construction industries, accordance with the mandatory specifications detailed at Annex "A".

Installation, training and manuals included.

### 3. Standard Clauses and Conditions

All clauses and conditions identified in the Contract by number, date and title are set out in the Standard Acquisition Clauses and Conditions Manual issued by Public Works and Government Services Canada (PWGSC). The Manual is available on the PWGSC Website: <http://sacc.pwgsc.gc.ca/sacc/index-e.jsp>.

#### 3.1 General Conditions

2010A ( 2012-11-19) General Conditions - Goods (Medium Complexity), apply to and form part of the Contract.

### 4. Term of Contract

The contract will be force until all warranty and or optional provisions of this agreement are expired

#### 4.1 Delivery Date

Delivery must be completed on or before *(to be filled in at contract award)*.

#### 4.1.2 Shipping Instructions

##### 4.1.2. Shipping Instructions - Delivery at Destination

1. Shipment shall be consigned to the destination specified, and delivered:

DDP Delivered Duty Paid Boucherville, Quebec Incoterms 2000.

2. The Contractor will be responsible for all delivery charges, administration, costs and risk of transport and customs clearance, including the payment of customs duties and taxes.

**5. Authorities****5.1 Contracting Authority**

The Contracting Authority for the Contract is:

**Doug Martin, Supply Specialist ( PV )**

Public Works and Government Services Canada

Acquisitions Branch

Commercial Consumer Products Directorate

11 Laurier Street, ( 44 ) 6A2, Phase III

Place du Portage, Hull, Quebec, K1A 0S5

Telephone: (819) 956 4037

Facsimile: (819) 956-3814

E-mail address: **doug.martin@pwgsc.gc.ca**

The Contracting Authority is responsible for the management of the Contract and any changes to the Contract must be authorized in writing by the Contracting Authority. The Contractor must not perform work in excess of or outside the scope of the Contract based on verbal or written requests or instructions from anybody other than the Contracting Authority.

**5.2 Technical Authority (to be filled in only at contract award)**

The Technical Authority for the Contract is:

The Technical Authority named above is the representative of the department or agency for whom the Work is being carried out under the Contract and is responsible for all matters concerning the technical content of the Work under the Contract. Technical matters may be discussed with the Technical Authority, however the Technical Authority has no authority to authorize changes to the scope of the Work. Changes to the scope of the Work can only be made through a contract amendment issued by the Contracting Authority..

**5.3 Contractor's Representative**

**Contractor's Representative** ( To be completed by bidder )

The telephone number of the person responsible for :

**General enquiries**

Name: \_\_\_\_\_ Telephone No. \_\_\_\_\_

Facsimile No. \_\_\_\_\_ E-mail address: \_\_\_\_\_

**Delivery Follow-up**

Name: \_\_\_\_\_ Telephone No. \_\_\_\_\_

Facsimile No. \_\_\_\_\_ E-mail address: \_\_\_\_\_

## 6. Payment

### 6.1 Basis of Payment - Firm Price

1. In consideration of the Contractor satisfactorily completing all of its obligations under the Contract, the Contractor shall be paid a firm price of **\$ XX.XX** ( to be filled in at contract award) Goods and Services Tax or Harmonize Sales Tax extra, if applicable.
2. No increase in the total liability of Canada or in the price of the Work resulting from any design changes, modifications or interpretations of the Specifications, will be authorized or paid to the Contractor unless such design changes, modifications or interpretations have been approved, in writing, by the Contracting Authority prior to their incorporation in the Work.

### 6.2 Single Payment

Canada will pay the Contractor upon completion and delivery of the Work in accordance with the payment provisions of the Contract if:

- (a) an accurate and complete invoice and any other documents required by the Contract have been submitted in accordance with the invoicing instructions provided in the Contract;
- (b) all such documents have been verified by Canada;
- (c) the Work delivered has been accepted by Canada.

## 7. Invoicing Instructions

### Invoicing Instructions

The Contractor must submit invoices in accordance with the information required in **Section 10, 2010A ( 2012-11-19) General Conditions - Goods or Services ( Medium Complexity)**.

Original copy to **consignee** with one copy to the **Contracting Authority**.

Name: Doug Martin  
Public Works and Government Services Canada  
Acquisition Branch, CASMS  
Telephone: (819) 956-4037  
Facsimile: (819) 956-3814  
E-Mail address: doug.martin@pwgsc.gc.ca

**The Invoice contact for the Contract is:** ( To be filled in at time of contract award )

## 8. Certifications

Compliance with the certifications provided by the Contractor in its bid is a condition of the Contract and subject to verification by Canada during the entire contract period. If the Contractor does not comply with any certification or it is determined that any certification made by the Contractor in its bid is untrue, whether made knowingly or unknowingly, Canada has the right, pursuant to the default provision of the Contract, to terminate the Contract for default.

### 8.2 SACC Manual Clauses

A2000C	Foreign Nationals (Canadian Contractor)	06/06/16
A2001C	Foreign Nationals (Foreign Contractor)	06/06/16
A9131C	Controlled Goods Production	08/12/12



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B1501C	Electrical Equipment	06/06/16
B7500C	Excess Goods	06/06/16
C0100C	Discretionary Audit - Commercial Goods and/or Services	07/05/25
D2001C	Labelling	07/11/30
D9002C	Incomplete Assemblies	07/11/30

## 9. Applicable Laws

The Contract must be interpreted and governed, and the relations between the parties determined, by the laws in force in Ontario.

## 10. Priority of Documents

If there is a discrepancy between the wording of any documents that appear on the list, the wording of the document that first appears on the list has priority over the wording of any document that subsequently appears on the list.

- (a) the Articles of Agreement;
- (b) **2010A ( 2012-07-16) General Conditions - Goods or Services ( Medium Complexity);**
- (c) Annex "A", Requirement;
- (d) Annex "B", Basis of Payment;
- (e) Annex "C", Drawings
- (d) the Contractor's bid dated \_\_\_\_\_ as clarified on \_\_\_\_\_ " **or** ", as amended on \_\_\_\_\_

**Annex "A" Requirement*****Mandatory Specifications for the "High-Pressure Reactor System":***

Bidder must complete the following statement of compliance.

The Bidder shall indicate compliance to each item. Failure to comply with the mandatory system specifications will render your proposal non-responsive, and no further consideration will be given.

Your quote must include and list all of the components necessary to meet these mandatory specifications.

Bidders must ensure that adequate literature/technical brochure(s) are submitted at time of bid closing to support compliance with all mandatory technical criteria.

**1.0 Purpose**

National Research Council Canada (NRC) wishes to acquire a calibration line for extruding PVC profiles. The line will be installed on a 20 mm laboratory twin-screw extruder (manufacturer Labtech Engineering Company Ltd., model no. LTE20-40) already owned by NRC.

The desired calibration line must consist of two (2) PVC profile extrusion dies with a hollow cavity on the inside, and stainless steel wet and dry calibrators to ensure that the PVC profiles are the right shape.

The calibration line must also include a vacuum calibration table for wet and dry calibration and a fly-knife cutter. The calibration line will be used to test new materials for industrial applications, specifically in the automotive and construction industries.

**2.0 Extrusion tools****2.1 Extrusion dies**

**2.1.1** The tools must consist of two (2) extrusion dies.

Page Reference in supplied documentation : \_\_\_\_\_

**2.1.2** The two (2) extrusion dies must be compatible with a Labtech Engineering Company Ltd. laboratory twin screw extruder (model LTE20-40) and must be capable of extruding polymers such as rigid and flexible PVC, PP, PE, PLA, PBS, PHA, and PS.

Page Reference in supplied documentation : \_\_\_\_\_

**2.1.3** The two (2) extrusion dies must be designed in accordance with the drawings provided in Appendices D-1 and D-2.

Page Reference in supplied documentation : \_\_\_\_\_

**2.1.4** The two (2) extrusion dies must be capable of being adapted to the head of the extruder swing gate, as shown in Appendix D-3.

Page Reference in supplied documentation : \_\_\_\_\_

**2.1.5** The two (2) extrusion dies must be made of stainless steel.

Page Reference in supplied documentation : \_\_\_\_\_

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**2.1.6** The two (2) extrusion dies must be equipped with thermocouples that are compatible with a DME temperature controller.

Page Reference in supplied documentation : \_\_\_\_\_

**2.1.7** The two (2) extrusion dies must be usable when working with an extruder with a maximum flow rate of 20 kg/hour.

Page Reference in supplied documentation : \_\_\_\_\_

## **2.2 Two (2) dry vacuum calibrators**

**2.2.1** Each extrusion die must be equipped with a dry calibrator to be used with the vacuum calibration table as described in Section 2.5.

Page Reference in supplied documentation : \_\_\_\_\_

**2.2.2** The design of the dry calibrators must conform to the drawings provided in Appendices D-1 and D-2.

Page Reference in supplied documentation : \_\_\_\_\_

**2.2.3** The components of the calibrators that will come into contact with the polymer must be made of stainless steel and the components that will not come into contact with the polymer must be resistant to corrosion by HCl and other acids.

Page Reference in supplied documentation : \_\_\_\_\_

**2.2.4** The upper and lower parts of the calibrator must be connected with hinges for opening the calibrator.

Page Reference in supplied documentation : \_\_\_\_\_

**2.2.5** The calibrators must be water cooled.

Page Reference in supplied documentation : \_\_\_\_\_

**2.2.6** The fasteners must be in SI units. The threads on the water and air pipes and flow control valves must comply with North American standards (NPT-National Pipe Thread).

Page Reference in supplied documentation : \_\_\_\_\_

## **2.3 Auxiliary vacuum tank and cooling fixtures**

**2.3.1** The calibration table must be equipped with an auxiliary vacuum tank for wet calibration of profiles.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.2** The auxiliary tank must be installed and operate with the vacuum calibration table and its components described in Section 2.5.

Page Reference in supplied documentation : \_\_\_\_\_

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**2.3.3** The auxiliary vacuum tank must measure 3 feet in length (tolerance  $\pm$  6 inches).

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.4** The auxiliary vacuum tank must be equipped with a minimum of two (2) vacuum air intakes installed in the tank and mounted with a pressure gauge and preset pressure relief valve.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.5** The auxiliary vacuum tank must be equipped with a minimum of four (4) water inlets installed and controlled using valves.

**2.3.6** The auxiliary vacuum tank and its components that will come into contact with the polymer must be made of stainless steel and the components that will not come into contact with the polymer must be resistant to corrosion by HCl and other acids.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.7** The cover of the auxiliary vacuum tank must be transparent and mounted onto the basin with hinges.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.8** The auxiliary vacuum tank must be equipped with multiple drains for water discharge, controlled by shutoff ball valves.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.9** The auxiliary vacuum tank must be equipped with multiple cooling fixtures for each profile and must be designed in accordance with the drawings provided in Appendices D-1 and D-2. The tank must also be equipped with a minimum of 10 rails for mounting the cooling fixtures inside the tank, including cooling at the inlet and outlet of the tank.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.10** The auxiliary vacuum tank must be equipped with a minimum of 32 water spray nozzles installed on the sides and bottom of the tank.

Page Reference in supplied documentation : \_\_\_\_\_

**2.3.11** The fasteners must be in SI units. The threads on the water and air pipes and flow control valves must comply with North American standards (NPT-National Pipe Thread).

Page Reference in supplied documentation : \_\_\_\_\_

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## 2.4 Fly-knife cutter

**2.4.1** The calibration line must be equipped with a fly-knife cutter with a minimum profile cutting capacity of 3.5 inches of exterior diameter.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.2** The cutting speed must be at least 600 cuts per minute.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.3** The fly-knife cutter must be equipped with a servo motor to activate the cutting blade.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.4** The cutter frame must have locking rubber caster wheels and must be capable of being anchored to the ground with a minimum of four (4) anchor screws installed under the frame.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.5** The cutting operation must be capable of being performed from right to left.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.6** The fly-knife cutter must be equipped with a control panel and an electronic screen providing a real-time reading of the length of the cut.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.7** The fly-knife cutter must be equipped with push buttons for manual cutting and for resetting the number of cuts, a selector for activating/deactivating the servo motor, and a counter that can be reset after the total number of cuts.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.8** Must be equipped with a cut length control with an encoder of 600 ppr minimum and cable included.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.9** The fly-knife cutter must be equipped with a servo motor to guide the cutting blade.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.10** The fly-knife cutter must be equipped with a shield that fully covers the blade and is equipped with a lock switch.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.11** The fly-knife cutter must be equipped with knife guards on each side of the cutting blade.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.12** Both ends of the cutting blade guard port must be equipped with lock switches. The blade guards must be designed so as to prevent the operator's hands from reaching the blade when the equipment is on. The guard at the cutting blade must be fitted with a chute to allow small parts to fall through immediately after cutting. (The design must be approved by NRC prior to manufacturing.)

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.13** The fly-knife cutter must be equipped with an electrical control panel with a safety disconnect switch.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.14** The fly-knife cutter must be equipped with an emergency shut-off button on the operator's control panel.

Page Reference in supplied documentation : \_\_\_\_\_

**2.4.15** The fasteners must be in SI units.

Page Reference in supplied documentation : \_\_\_\_\_

## **2.5 Vacuum calibration table and water supply system**

**2.5.1** The vacuum calibration table must be equipped with a step with a minimum width of 8 inches and must be removable. The dimensions of the calibration table, including the step, must not exceed 8 feet long  $\pm$  6 inches by 4.5 feet wide  $\pm$  3 inches by 5 feet high  $\pm$  6 inches, due to space constraints.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.2** The water supply system must be equipped with a minimum of two (2) separate supply lines (one [1] line for the auxiliary vacuum tank and one (1) line for dry calibration), each with a minimum of 10 valves.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.3** The water supply system must be equipped with a pump with a minimum capacity of 220 L/min to send water from the tank to the water supply lines and must be equipped with a recirculation system with a heat exchanger.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.4** The vacuum air supply system must be equipped with a vacuum pump and a vacuum supply line with 10 valves connected to the auxiliary vacuum tank and the dry calibrator.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.5** The precision of calibration table movements must be manually adjustable on the X, Y and Z axes with full motorization and automatic inversion.

Page Reference in supplied documentation : \_\_\_\_\_

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**2.5.6** The table must be equipped with a reservoir installed on the frame of the machine and with a surface basin. Both must be made of stainless steel and connected via a drain.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.7** The reservoir must be equipped with a solenoid valve for controlling the water level and a basket water filter strainer (filter bag included) with a bypass valve for maintenance.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.8** The components of the vacuum calibration table that will come into contact with the polymer must be made of stainless steel and the components that will not come into contact with the polymer must be resistant to corrosion by HCl and other acids.

**2.5.9** Calibration must be capable of being performed from right to left.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.10** The vacuum calibration table must be equipped with a removable control panel that can be accessed by the operator at chest height. The panel must be equipped with an emergency shut-off button, on/off push buttons for the pumps and a selector for forward/rear table motion.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.11** The frame and components that could corrode must receive one coat of primer and corrosion-resistant paint. The colour of the equipment must conform to the colour sample provided by NRC before manufacturing begins.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.12** The calibration table must be equipped with an electrical control panel with a safety disconnect switch.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.13** The frame of the vacuum calibration table must have locking rubber caster wheels and must be capable of being anchored to the ground with a minimum of four (4) anchor screws installed under the frame.

Page Reference in supplied documentation : \_\_\_\_\_

**2.5.14** The fasteners must be in SI units. The threads on the water and air pipes and flow control valves must comply with North American standards (NPT-National Pipe Thread).

Page Reference in supplied documentation : \_\_\_\_\_

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### 3.0 Deliverables

**3.1** A calibration line for extruding PVC profiles that includes two (2) extrusion dies, two (2) dry vacuum calibrators, one auxiliary vacuum tank and cooling fixtures for each profile, and a vacuum calibration table as described in specifications 2.1.1 to 2.5.14.

Page Reference in supplied documentation : \_\_\_\_\_

**3.2** Two (2) copies of the technical documentation explaining the operation and maintenance of the equipment must be provided, electrical plans in French or English, in hard copy or electronic format.

Page Reference in supplied documentation : \_\_\_\_\_

**3.3** A set of tools specific to the reactor and its components must be provided.

Page Reference in supplied documentation : \_\_\_\_\_

**3.4** The calibration sheets for the temperature sensors must be provided on delivery.

Page Reference in supplied documentation : \_\_\_\_\_

**3.5** A list of spare parts required during normal operations must be provided.

Page Reference in supplied documentation : \_\_\_\_\_

**3.6** The bidder must provide two (2) additional blades for the fly-knife cutter.

Page Reference in supplied documentation : \_\_\_\_\_

**3.7** Software configuration equipment if applicable.

Page Reference in supplied documentation : \_\_\_\_\_

**3.8** Calibration sheets for the servo motor(s).

Page Reference in supplied documentation : \_\_\_\_\_

**3.9** The specifications must be accepted by NRC before equipment is put into production as described in specifications 2.1.1 to 2.5.14. The bidder or contractor must provide drawings and general information (hard copy or electronic format).

Page Reference in supplied documentation : \_\_\_\_\_

**3.10** All safety or warning labels must be written in French and English or be illustrated with pictograms.

Page Reference in supplied documentation : \_\_\_\_\_

**3.11** Before the equipment manufacturing begins, NRC will provide a sample of the desired colour.

Page Reference in supplied documentation : \_\_\_\_\_



**3.12** All safety-related items must be painted to ANSI Z 535.1 1998, *Safety color code (Provided by National Electrical Manufacturers Association, Tel. 703-841-3200 or fax 703-841-3300).*

Page Reference in supplied documentation : \_\_\_\_\_

**3.13** For all electrical components, equipment must be certified by the Canadian Standards Association (**CSA**) or by Underwriters Laboratories Inc. for the Canadian market (**cUL**).

Page Reference in supplied documentation : \_\_\_\_\_

#### **4.0 General information and services provided by NRC**

**4.1** Plumbing and electrical connections will be done by NRC. The bidder or contractor must contact the project manager appointed by NRC within 10 calendar days following receipt of the contract to inform the project manager of the services (water, air, electricity) required.

#### **4.2 Available voltages:**

- 208 V / 3 phases / 60 Hz

- 120 V / 1 phase / 60 Hz Any other voltage, if necessary, will be obtained using a transformer provided by the bidder or contractor.

**4.3** The compressed air service available at NRC is 620 kPa (90 psi).

**4.4** The temperature of the cooling water is  $\pm 20^{\circ}\text{C}$ .

**4.5** The distance between the ground and the centre of the Labtech twin-screw extruder quill is 42 inches.

**4.6** The final dimensions of the profiles are less important than matching the final shape of the profiles. See Appendices D-1 and D-2.

#### **5.0 Delivery and installation**

**5.1** The extrusion line and its components as described in specifications 2.1.1 to 2.5.14 will be delivered to National Research Council Canada, 75 Boulevard de Mortagne, Boucherville, Quebec, Canada, J4B 6Y4.

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**Annex “B” Basis of Payment**

	Description	Qty	Unit Price (\$) <b>CAD</b>	Total Price (\$) <b>CAD</b>
<b>A</b>	<b>Extrusion tools</b> Including dies, dry vacuum calibrators, auxiliary vacuum tank and cooling fixtures. Described in Annex A, Items 2.1, 2.2 and 2.3, and Annex D – Mandatory technical specifications, Requirement: 01	<b>1</b>		
<b>B</b>	<b>Fly-knife cutter</b> Described in Annex A, Item 2.4 – Mandatory technical specifications, Requirement: 01	<b>1</b>		
<b>C</b>	<b>Vacuum calibration table</b> Described in Annex A, Item 2.5 – Mandatory technical specifications, Requirement: 01	<b>1</b>		
<b>D</b>	<b>Installation and setup of tools</b> Described in Annex A, Item 3.13 – Deliverables, Requirement: 01	<b>1</b>		
<b>E</b>	<b>Transportation costs</b> Described in Annex A, Item 3.18 – Deliverables, Requirement: 01	<b>1</b>		
	<b>Total (A+B+C+D+E+F):</b>			



