

**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

Title - Sujet HYDRAULIC CNC PRESS BRAKE		
Solicitation No. - N° de l'invitation 31184-139567/A	Date 2013-12-20	
Client Reference No. - N° de référence du client 31184-139567		
GETS Reference No. - N° de référence de SEAG PW-\$\$HN-442-64271		
File No. - N° de dossier hn442.31184-139567	CCC No./N° CCC - FMS No./N° VME	
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2014-02-04		Time Zone Fuseau horaire Eastern Standard Time EST
F.O.B. - F.A.B. Plant-Usine: <input type="checkbox"/> Destination: <input checked="" type="checkbox"/> Other-Autre: <input type="checkbox"/>		
Address Enquiries to: - Adresser toutes questions à: Hamel, Jean-Yves		Buyer Id - Id de l'acheteur hn442
Telephone No. - N° de téléphone (819) 956-8278 ()	FAX No. - N° de FAX () -	
Destination - of Goods, Services, and Construction: Destination - des biens, services et construction: NATIONAL RESEARCH COUNCIL CANADA BLDG M19 1200 MONTREAL RD OTTAWA Ontario K1A0R6 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

Electrical & Electronics Products Division
11 Laurier St./11, rue Laurier
7B3, Place du Portage, Phase III
Gatineau, Québec K1A 0S5

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

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List of Annexes:

ANNEX A - Statement of Requirement, Pricing and Delivery

PART 1 - GENERAL INFORMATION

1. Security Requirement

There is no security requirement associated with the requirement.

2. Requirement

The contractor must provide the goods and/or services in accordance with the technical requirements and in the quantities stated herein at **ANNEX A - Statement of Requirement, Pricing and Delivery**.

This requirement includes one (1) Piranha AllSteel Press Break (Serial # 95101026) as an optional trade-in.

2.1 Delivery Requirement

Delivery is requested to be completed by 31 March 2014.

3. Debriefings

Bidders may request a debriefing on the results of the bid solicitation process. Bidders should make the request to the Contracting Authority within 15 working days of receipt of the results of the bid solicitation process. The debriefing may be 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* (<https://buyandsell.gc.ca/policy-and-guidelines/standard-acquisition-clauses-and-conditions-manual>) issued by Public Works and Government Services Canada.

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 2003 (2013-06-01) Standard Instructions - Goods or Services - Competitive Requirements, are incorporated by reference into and form part of the bid solicitation.

Subsection 5.4 of 2003, Standard Instructions - Goods or Services - Competitive Requirements, is amended as follows:

Delete: sixty (60) days
Insert: ninety (90) days

1.1 SACC Manual Clauses

SACC Reference	Section	Date
A9033T	Financial Capability	2012-07-16
B1000T	Condition of Material	2007-11-30

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. Enquiries - Bid Solicitation

All enquiries must be submitted in writing to the Contracting Authority no later than seven (7) 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.

4. Applicable Laws

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

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.

5. Improvement of Requirement During Solicitation Period

Should the bidder consider that the specifications or Statement of Work contained in the bid solicitation could be improved technically or technologically, bidders are invited to make suggestions, in writing, to the Contracting Authority named in the bid solicitation. Bidders must clearly outline the suggested improvement as well as the reason for the suggestion. Suggestions that do not restrict the level of competition nor favour a particular bidder will be given consideration provided they are submitted to the Contracting Authority at least seven (7) calendar days before the bid closing date. Canada will have the right to accept or reject any or all suggestions.

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)

Section II: Financial Bid (One hard copy)

Section III: Certifications (One hard copy)

Section IV: Additional Information (One hard copy)

Prices should appear in the financial bid only. No prices should be indicated in any other section of the bid.

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.

In April 2006, Canada issued a policy directing federal departments and agencies to take the necessary steps to incorporate environmental considerations into the procurement process Policy on Green Procurement

(<http://www.tpsgc-pwgsc.gc.ca/ecologisation-greening/achats-procurement/politique-policy-eng.html>). To assist Canada in reaching its objectives, bidders are encouraged to:

- 1) use paper containing fibre certified as originating 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.

Section I: Technical Bid (Two (2) hard copies)

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

1.1 Equivalent Products

1. Products that are equivalent in form, fit, function and quality to the item(s) specified in the bid solicitation will be considered where the Bidder:
 - (a) designates the brand name, model and/or part number of the substitute product;
 - (b) states that the substitute product is fully interchangeable with the item specified;
 - (c) provides complete specifications and descriptive literature for each substitute product with the bid;
 - (d) provides compliance statements that include technical specifics showing the substitute product meets all mandatory performance criteria that are specified in the bid solicitation; and
 - (e) clearly identifies those areas in the specifications and descriptive literature that support the substitute product's compliance with any mandatory performance criteria.
2. Products offered as equivalent in form, fit, function and quality will not be considered if:
 - (a) the bid fails to provide all the information requested to allow the Contracting Authority to fully evaluate the equivalency of each substitute product; or
 - (b) the substitute product fails to meet or exceed the mandatory performance criteria specified in the bid solicitation for that item.
3. In conducting its evaluation of the bids, Canada may, but will have no obligation to, request bidders offering a substitute product to demonstrate, at the sole cost of bidders, that the substitute product is equivalent to the item specified in the bid solicitation.

Section II: Financial Bid (One (1) hard copy)

Bidders must submit their financial bid in accordance with the Basis of Payment. The total amount of Applicable Taxes must be shown separately.

1.2 Exchange Rate Fluctuation

The requirement does not offer exchange rate fluctuation risk mitigation. Requests for exchange rate fluctuation risk mitigation will not be considered. All bids including such provision will render the bid non-responsive.

Section III: Certifications (One (1) hard copy)**1.3 Certifications**

Bidders must submit the certifications required under Part 5.

Section IV: Additional Information (One (1) hard copy)**1.4 Additional Information****1.4.1 Delivery Proposed**

While delivery is requested as indicated above, the best delivery/installation/removal of the Press Brake machines as applicable that could be offered should be indicated in **ANNEX A - Statement of Requirement, Pricing and Delivery.**

1.4.2 Contractor Representatives

Name and telephone number of the person responsible for :

General enquiries

Name: _____
Telephone: _____
Facsimile: _____
E-mail: _____

Delivery follow-up

Name: _____
Telephone: _____
Facsimile: _____
E-mail: _____

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1.4.3 After Sales Service

Canada requests that the Bidder provides the names, addresses and telephone numbers of their dealers and/or agents authorized to provide after sales service, maintenance and warranty repairs, and a full range of repair parts for the equipment offered. The Bidder should show the distance between the delivery location and the authorized dealer and/or agent and the delivery location, which should not be more than 100 kilometres.

Distance between the delivery location and the dealer and/or agent: _____ km

Name: _____

Address: _____

Telephone: _____

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.
- (b) An evaluation team composed of representatives of Canada will evaluate the bids.

Evaluation Criteria

All bids must be completed in full and provide all of the information requested in the bid solicitation to enable full and complete evaluation.

1.1 Technical Evaluation

1.1.1 Mandatory Technical Criteria

The following Mandatory requirements must be submitted with the bid for evaluation

Technical compliance (description of items from **ANNEX A - Statement of Requirement, Pricing and Delivery** herein);
Bids must be submitted for all destinations per item.

1.2 Financial Evaluation

The Bid price will be determined by processing the items at **ANNEX A - Statement of Requirement, Pricing and Delivery** as follows:

1.2.1 Pricing Basis

The bidder must quote firm unit prices in Canadian dollars, DDP Delivered Duty Paid (destination), Applicable Taxes extra, as applicable. Freight charges to destination and all applicable Custom duties and Excise taxes must be included.

The bidder may submit a firm unit price for the trade-in, including the cost of pick-up, as detailed in **ANNEX A - Statement of Requirement, Pricing and Delivery**.

The bid price will be determined on an aggregate basis (Items 001, 002, 003 and 004) by subtracting the proposed trade-in value at item 004, if applicable, from items 001, 002 and 003 at **ANNEX A - Statement of Requirement, Pricing and Delivery**. If no trade in value is proposed, the aggregate pricing will be determined by the lowest priced bid received for items 001, 002 and 003 only.

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2. Basis of Selection

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 on an aggregate basis (Items 001, 002, 003 and 004 as applicable) (Less items 005 to 032) will be recommended for award of a contract.

PART 5 - CERTIFICATIONS

Bidders must provide the required certifications and documentation to be awarded a contract.

The certifications provided by bidders to Canada are subject to verification by Canada at all times. Canada will declare a bid non-responsive, or will declare a contractor in default, if any certification made by the Bidder is found to be untrue whether during the bid evaluation period or during the contract period.

The Contracting Authority will have the right to ask for additional information to verify the Bidder's certifications. Failure to comply with this request will also render the bid non-responsive or will constitute a default under the Contract.

1. Mandatory Certifications Required Precedent to Contract Award

1.1 Code of Conduct and Certifications - Related documentation

By submitting a bid, the Bidder certifies that the Bidder and its affiliates are in compliance with the provisions as stated in Section 01 Code of Conduct and Certifications - Bid of Standard Instructions 2003. The related documentation therein required will assist Canada in confirming that the certifications are true.

1.2 Federal Contractors Program for Employment Equity - Bid Certification

By submitting a bid, the Bidder certifies that the Bidder, and any of the Bidder's members if the Bidder is a Joint Venture, is not named on the Federal Contractors Program (FCP) for employment equity "[FCP Limited Eligibility to Bid](http://www.labour.gc.ca/eng/standards_equity/eq/emp/fcp/list/inelig.shtml)" list (http://www.labour.gc.ca/eng/standards_equity/eq/emp/fcp/list/inelig.shtml) available from [Human Resources and Skills Development Canada \(HRSDC\)](#) - [Labour's](#) website.

Canada will have the right to declare a bid non-responsive if the Bidder, or any member of the Bidder if the Bidder is a Joint Venture, appears on the "[FCP Limited Eligibility to Bid](#)" list at the time of contract award.

PART 6 - RESULTING CONTRACT CLAUSES

1. Security Requirement

There is no security requirement associated with the requirement.

2. Requirement

The contractor must provide the goods and/or services in accordance with the technical requirements and in the quantities stated herein at **ANNEX A - Statement of Requirement, Pricing and Delivery**.

The contractor must also take away (If applicable) one (1) Piranha AllSteel Press Break (Serial # 95101026) as a trade-in.

2.1 SACC Manual Clauses

SACC Reference	Section	Date
B1501C	Electrical Equipment	2006-06-16
B7500C	Excess Goods	2006-06-16

2.2 Optional Goods and/or Services (Items 005 to 032)

The Contractor grants to Canada the irrevocable option to acquire the goods, services or both described at **ANNEX A - Statement of Requirement, Pricing and Delivery** of the Contract under the same conditions and at the prices stated in the Contract. The option may only be exercised by the Contracting Authority and will be evidenced, for administrative purposes only, in whole or in part, through a contract amendment.

The Contracting Authority may exercise the option to acquire any or all of items 005 to 032 within twelve (12) months after contract award by sending a written notice to the Contractor.

For items 005 to 028, the Bidder must provide, on Canada's request, one or more of the following price support, if applicable:

- (i) a current published price list indicating the percentage discount available to Canada; or
- (ii) copies of paid invoices for the like quality and quantity of the goods, services or both sold to other customers; or
- (iii) a price breakdown showing the cost of direct labour, direct materials, purchased items, engineering and plant overheads, general and administrative overhead, transportation, etc., and profit; or
- (iv) price or rate certifications; or
- (v) any other supporting documentation as requested by Canada.

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*

(<https://buyandsell.gc.ca/policy-and-guidelines/standard-acquisition-clauses-and-conditions-manual>) issued by Public Works and Government Services Canada.

3.1 General Conditions

2010A (2013-04-25), General Conditions - Goods (Medium Complexity), and sections 05, 06, 16, 20 and 28 of 2010C (2013-06-27), General Conditions - Services (Medium Complexity) apply to and form part of the Contract.

4. Term of Contract

4.1 Delivery Date

All the deliverables must be received on or before _____ (Delivery as offered and as accepted will be inserted at contract award).

5. Authorities

5.1 Contracting Authority

The Contracting Authority for the Contract is:

Jean-Yves Hamel

Supply Officer

Public Works and Government Services Canada

Acquisitions Branch

Logistics, Electrical, Fuel and Transportation Directorate

"HN" Division

7B3, Place du Portage, Phase III

11 Laurier Street

Gatineau, QC, K1A 0S5

Telephone : (819) 956-8278

Facsimile : (819) 953-4944

E-mail : JeanYves.Hamel@pwgsc-tpsgc.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

The Technical Authority for the Contract is:

Name: will be inserted at contract

Title: will be inserted at contract

Telephone: will be inserted at contract

Facsimile: will be inserted at contract

E-mail: will be inserted at contract

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

Name and telephone number of the person responsible for:

General Enquiries

Name: will be inserted at contract
Telephone: will be inserted at contract
Facsimile: will be inserted at contract
E-mail: will be inserted at contract

Delivery Follow-up

Name: will be inserted at contract
Telephone: will be inserted at contract
Facsimile: will be inserted at contract
E-mail: will be inserted at contract

6. Payment

6.1 Basis of Payment

In consideration of the Contractor satisfactorily completing all of its obligations under the Contract, the Contractor will be paid firm unit prices as specified in the contract. Customs duties are included and Applicable Taxes are extra.

Canada will not pay the Contractor for any design changes, modifications or interpretations of the Work, unless they have been approved, in writing, by the Contracting Authority before their incorporation into the Work.

6.2 Limitation of Price

SACC Manual clause C6000C (2011-05-16) Limitation of Price

6.3 Multiple Payments

SACC Manual clause H1001C (2008-05-12) Multiple Payments

6.4 Trade-in (If applicable)

The Piranha AllSteel Press Break to be traded in will be retained by Canada until exchanged for the new Press Break. No adjustment will be made to the trade-in allowance to allow for depreciation arising out of normal wear and tear on the used Piranha AllSteel Press Break between the time of its appraisal and the time the used Piranha AllSteel Press Break is exchanged. The Contractor must, immediately upon taking possession of the used Piranha AllSteel Press Break, report in writing any significant change in the condition of the used Piranha AllSteel Press Break to the Contracting Authority.

6.5 SACC Manual Clauses

SACC Reference	Section	Date
G1005C	Insurance	2008-05-12

7. Invoicing Instructions

1. The Contractor must submit invoices in accordance with the section entitled "Invoice Submission" of the general conditions. Invoices cannot be submitted until all work identified in the invoice is completed.

2. Invoices must be distributed as follows:

- (a) one (1) copy must be forwarded to the consignee.
- (b) The original and one (1) copy must be forwarded to the following address for certification and payment.

National Research Council Canada
ASPM Material Management
Bldg. M-22
1200 Montreal Road
Ottawa, Ontario, K1A 0R6
Attention: will be inserted at contract

- (c) One (1) copy must be forwarded to the Contracting Authority identified under the section entitled "Authorities" of the Contract.

Department of Public Works and Government Services
"HN" Division
7B3 Place du Portage, Phase III
11 Laurier Street
Gatineau, QC, K1A 0S5
Attention: Jean-Yves Hamel

8. Certifications

8.1 Compliance

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 term of the Contract. 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.

9. Applicable Laws

The Contract must be interpreted and governed, and the relations between the parties determined, by the laws in force in will be inserted at contract.

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 (2013-04-25) General Conditions - Goods (Medium Complexity);
- (c) 2010C (2013-06-27) General Conditions - Services (Medium Complexity);
- (d) **ANNEX A - Statement of Requirement, Pricing and Delivery;**
- (e) the Contractor's bid dated will be inserted at contract

11. SACC Manual Clauses

SACC Reference	Section	Date
A9039C	Salvage	2008-05-12
A9068C	Government Site Regulations	2010-01-11

12. SACC Manual Clauses (Delivery)

SACC Reference	Section	Date
D2000C	Marking	2007-11-30
D2001C	Labelling	2007-11-30
D9002C	Incomplete Assemblies	2007-11-30

12.1 Shipping Instructions - Delivery at Destination

Goods must be consigned to the destination specified in the Contract and delivered:

Delivered Duty Paid (DDP) (Ottawa, Ontario) Incoterms 2000 for shipments from a commercial contractor.

12.2 Shipping - Scheduling

The contractor must deliver/install/remove the goods as applicable to Ottawa, Ontario at the address below:

National Research Council - Design and Fabrication Services
1200 Montreal Road
Bldg. M4
Ottawa, Ontario
K1A 0R6
Phone: will be inserted at contract

13. Inspection and Acceptance

The Technical Authority is the Inspection Authority. All reports, deliverable items, documents, goods and all services rendered under the Contract are subject to inspection by the Inspection Authority or representative. Should any report, document, good or service not be in accordance with the requirements of **ANNEX A - Statement of Requirement, Pricing and Delivery** and to the satisfaction of the Inspection Authority, as submitted, the Inspection Authority will have the right to reject it or require its correction at the sole expense of the Contractor before recommending payment.

14. After Sales Service

Name: _____
Address: _____
Telephone number: _____

This after sales service must be available during normal business hours, Monday to Friday between 08:00 to 16:00 EST. Response time for on site technical support should not exceed two (2) business days following request. Any repairs should be completed within thirty (30) calendar days.

ANNEX A - Statement of Requirement, Pricing and Delivery

Hydraulic CNC Press Brake

Statement of Requirement

Summary :

This specification is for the purchase of a Computer Numerical Control (CNC) Hydraulic Press Brake to replace existing equipment and to increase fabrication capabilities in order to better support the National Research Council of Canada (NRC) researchers, especially the work from the Automobile & Surface Transportation Portfolio.

Press Brake Requirement (Item 001):

Mechanical and Physical Specifications

- The Press Brake must have heavy-duty, all steel frames with deep ram and bed design. Frame members should be stress relieved during fabrication. The throat must be reinforced with thick steel plating to minimize deflection.
- The Press Brake must have a working length envelop of 10 Feet minimum.
- For longer life of usage, the Press Brake Piston Rods must be hardened or nitride coated.
- The Press Brake must have a working capacity of 170 tons or better.
- The Press Brake forming dies must be "American Style" in order to maintain standardization of equipment within the workshop.
- The Press Brake must have a quick tool clamping system such as a bolt on ram nose.
- The Press Brake ram nose design must have a full-length die slot with a Crosswise "C " slot.
- The machine must have a Micro crowned bed that can compensate for bending loss or tool ware.
- Desired heavy-duty block size should be: at least 3.5 inches wide X 3 inches high by the length of the bed.
- Ram of the Press Brake must have a repeatability tolerance of +/- .0005 inch or better.
- The Press Brake must have Dies Alignment and Bump Bending capabilities for step forming a large radius. The ram must have true programmable tilt Y1, Y2 with angle correction that is independently programmed. It is desirable that the ram nose tilt at +/- 0.5 inches off the centerline of the machine (Y1 & Y2 axis).

- The Press Brake must have a 3 axis, heavy duty, CNC programmable back gauge with a repeatability of +/- 0.001 inches or better. (X is the depth axis, R is the vertical axis).
- The Press Brake programmable back gage must have independently controlled back stops (Or fingers) to allow R axis rotation of the part.
- The Press Brake must have heavy-duty front sheet support between 18 and 30 inches deep to provide additional material support during bending or forming of large parts.

CNC Controller Specifications

- The CNC controller must allow the operator to create programs from the shop floor by inputting forming parameters. It is highly desirable to have a controller with a touchscreen interface (With at least a 15" color LCD monitor) for shop floor programming.
- The control must have a solid-state hard drive with at least 4GB of memory.
- Operator controls must have Offset & Stroke adjustment capabilities.
- The CNC controller must have automated tool load calculations to protect dies.
- The CNC controller must have Ethernet capabilities.
- The CNC controller must have ladder diagram feature to access the PLC for monitoring and troubleshooting purposes.
- For each forming modes, the CNC controller must allow activation of the ram reversal (turn ON or OFF).
- The CNC controller must feature detail job set up screens and a graphic tool library (Can be either in the controller or in the software detailed below).

Bending & Unfolding Software Specifications

- The CNC software must have import capabilities of common file formats such as: *.stp, *.step, *.igs, *.iges. It is also desirable to import video files.
- The CNC controller forming modes must allow control of the following parameters: Angle, Position, Absolute Relative Position and Tonnage.
- The CNC software must have a 3D visual aid option to check bending sequence simulation and check for tool and machine interference.
- The programming software must be capable of creating 2D flat pattern from 3D CAD models using the following format: *.sat, *.stp, *.step, *.ipt, *.igs and *.iges.

Electrical and Safety Specifications

- The press brake must connect to power source of 600 volts, 3 phases, 60 Hz. The supplier must provide a transformer kit as required.
- All electrical systems shall be CSA or ULC (Or equivalent) approved or must be approved by the Ontario Electrical Safety Authority (ESA)
- The Press Brake must meet CSA Z142-10 Machine & Control Compliance (Or equivalent) and have the following features:
 - Capacity Plate
 - CSA approved Hydraulics Package
 - Interfacing for Presence Sensing Device
 - Infrared Light Curtain
 - Safety Blocking Device and Guarding Interlocks
 - End Guards and Rear Guarding with Interlocks
- The Press brake must have a pedestal foot switch and a two hands control.

Commissioning

The Press Brake manufacturer must support the Design and Fabrication Services (DFS) by providing pre-installation information, installation of the Press Brake, machine start-up and demonstration including:

- Installation information regarding lifting
- Service connections and equipment preparation
- Machine Levelling and inspection
- Machine testing in all modes
- Demonstrate machine to DFS selected Resources (Bend test piece as per DFS drawings specifications)

Manuals and Documentation

- All documentation must be in English and in .pdf format.
- The following documentation must be supplied (Proprietary information excluded):
 - Operator's manual;
 - Operation & safety manual;
 - Maintenance, Service and part manuals;
 - Electrical schematics & Drawings. Electronic format (AutoCAD or pdf) on B size sheets (11"x17") is preferred.
- Accuracy test sheet (Manufacturing specifications)

Training (Item 002)

Provide onsite instruction regarding operation of the Press Brake, maintenance and safety to DFS selected Personnel in English for 6 persons. Training must be at a minimum 2 days.

Labor (Installation and/or removal (As applicable)) (Item 003)

As detailed at "Commissioning" above.

Optional Items (Items 004 to 032)

Optional Trade-in (Item 004): Piranha AllSteel Press Break (Serial # 95101026) (See attached pictures)

Manufacturer name: Piranha AllSteel
Model: 9510
Tonnage: 95 Tons
Bed: 10 feet
Machine purchased: 1998
Original Value: \$49,000
Total usage: 1,500 hrs
Various used dies included with the press break
See the following hyperlink for the machine specifications:
<http://www.sterlingmachinery.com/db-files/piranha%20pressbrakes%20brochure.pdf>

Existing issues/concerns - Minor inconsistent back gauge accuracy and repeatability

Optional Software (Item 005)

Off-line operation of the Bending & Unfolding Software. The off-line programming software must have the exact functionalities as the programming software installed on the Press Break CNC controller.

Optional Tooling (Items 006 to 028)

The following tooling (Lower& Upper Dies) (Or Equivalent) must be compatible with the supplied machine

Conventional American Punches:

- Item 006** 1 (one) 88 Degrees Block Punch with 1/32" Radius and 10 feet Long
- Item 007** 1 (one) 88 Degrees Block Punch with 1/16" Radius and 10 feet Long
- Item 008** 1 (one) 88 Degrees Block Punch with 1/8" Radius and 10 feet Long
- Item 009** 1 (one) 88 Degrees Block Punch with 3/16" Radius and 10 feet Long
- Item 010** 1 (one) 88 Degrees Block Punch with 1/4" Radius and 10 feet Long
- Item 011** 1 (one) 85 Degrees Block Punch with 5/16" Radius and 10 feet Long
- Item 012** 1 (one) 85 Degrees Block Punch with 3/8" Radius and 10 feet Long
- Item 013** 1 (one) 85 Degrees Block Punch with 1/2" Radius and 10 feet Long

Conventional American Matting V-Die Opening Dies:

- Item 014** 1 (one) 89 degrees, 1/4" V-Die Openings and 10 feet Long
- Item 015** 1 (one) 89 degrees, 3/8" V-Die Openings and 10 feet Long
- Item 016** 1 (one) 89 degrees, 1/2" V-Die Openings and 10 feet Long
- Item 017** 1 (one) 89 degrees, 5/8" V-Die Openings and 10 feet Long
- Item 018** 1 (one) 89 degrees, 3/4" V-Die Openings and 10 feet Long
- Item 019** 1 (one) 89 degrees, 7/8" V-Die Openings and 10 feet Long
- Item 020** 1 (one) 89 degrees, 1-1/8" V-Die Openings and 10 feet Long
- Item 021** 1 (one) 89 degrees, 1-1/4" V-Die Openings and 10 feet Long
- Item 022** 1 (one) 85 degrees, 1-1/2" V-Die Openings and 10 feet Long
- Item 023** 1 (one) 85 degrees, 2" V-Die Openings and 10 feet Long
- Item 024** 1 (one) 85 degrees, 2.5" V-Die Openings and 10 feet Long

Conventional American Punch Sash (Gooseneck):

- Item 025** 1 (one) 88 degrees Punch with 1/32" Radius and 10 feet Long.
The punch must be at least 3" height.

Conventional American Matting Acute angle Punches and Dies (30 degrees):

- Item 026** Set of punch and die for light gauge material forming
(up to 16 gages or better).
1 (one) Upper Die: 30 degrees punch with a 0.031" nose radius by
10 feet long. The punch must be at least 3.5" height with a thickness of
1" minimum.
1 (one) Mating Die: 30 degrees, ½" V-Die Opening by 10 feet long.
- Item 027** Set of punch and die for heavy gauge material forming
(up to 11 gages or better).
1 (one) Upper Die: 30 degrees punch with a 0.062" nose radius by
10 feet long. The punch must be at least 3.5" height with a thickness of
1 ½" minimum.
1 (one) Mating Die: 30 degrees, 1" V-Die Opening by 10 feet long.

Conventional American Hemming Tool Punches and Dies (30 degrees):

- Item 028** 1 (one) Upper Die: 30 degrees punch with a 0.031" nose radius by
10 feet long.
1 (one) Mating Die: 30 degrees die by 10 feet long.

Optional Training (Item 029)

Provide onsite instruction regarding operation of the Press Brake, maintenance and safety to DFS selected Personnel in English for up to 6 persons. Training must be at a minimum 2 days.

Pricing and Delivery

Item 001 Hydraulic CNC Press Brake Firm Quantity: 1 UI: EA

P/N Proposed : _____ Manufacturer Proposed: _____

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Delivery ARO: _____ Weeks.

Item 002 Training Firm Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Delivery ARO: _____ Weeks.

Item 003 Labor Firm Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Delivery ARO: _____ Weeks.

Item 004 Optional Trade-in Optional Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Removal ARO: _____ Weeks.

Item 005 Optional software Optional Quantity: 1 UI: EA

P/N Proposed : _____ Manufacturer Proposed: _____

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Delivery ARO: _____ Weeks.

Optional Tooling (Delivered Duty Paid at Ottawa, Ontario, Canada (Applicable Taxes excluded))

Item 006	Firm unit price of \$ _____
Item 007	Firm unit price of \$ _____
Item 008	Firm unit price of \$ _____
Item 009	Firm unit price of \$ _____
Item 010	Firm unit price of \$ _____
Item 011	Firm unit price of \$ _____
Item 012	Firm unit price of \$ _____
Item 013	Firm unit price of \$ _____
Item 014	Firm unit price of \$ _____
Item 015	Firm unit price of \$ _____
Item 016	Firm unit price of \$ _____
Item 017	Firm unit price of \$ _____
Item 018	Firm unit price of \$ _____
Item 019	Firm unit price of \$ _____
Item 020	Firm unit price of \$ _____
Item 021	Firm unit price of \$ _____
Item 022	Firm unit price of \$ _____
Item 023	Firm unit price of \$ _____
Item 024	Firm unit price of \$ _____
Item 025	Firm unit price of \$ _____
Item 026	Firm unit price of \$ _____
Item 027	Firm unit price of \$ _____
Item 028	Firm unit price of \$ _____

Delivery ARO: _____ Weeks.

Item 029 Optional Training Option Quantity: Up to 2 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Delivery ARO: _____ Weeks.

Item 030 Extended Warranty - 12 Months (In addition to the initial 12 month warranty)
Option Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
(Applicable Taxes excluded).

Item 031 Extended Warranty - 12 Months (In addition to Item 030)
Option Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
Applicable Taxes excluded).

Item 032 Extended Warranty - 12 Months (In addition to Item 031)
Option Quantity: 1 UI: EA

Firm unit price of \$ _____ Delivered Duty Paid at Ottawa, Ontario, Canada
Applicable Taxes excluded).







Press Brake Bending Chart

Tons per linear foot to bend mild steel having max. 60,000 psi tensile strength and max. 36,000 psi yield strength.

Thickness of Metal		Width of V Die Opening																							
Gauge	Inches	1/4 in.	5/16 in.	3/8 in.	7/16 in.	1/2 in.	5/8 in.	3/4 in.	7/8 in.	1 in.	1 1/8 in.	1 1/4 in.	1 1/2 in.	2 in.	2 1/2 in.	3 in.	3 1/2 in.	4 in.	5 in.	6 in.	7 in.	8 in.	10 in.	12 in.	
20	0.0359	3.1	2.3	1.7	1.4	1.1																			
18	0.0478	5.3	4.0	3.0	2.5	2.2	1.7	1.3																	
16	0.0598	9.6	7.1	5.6	4.5	3.8	2.8	2.2	1.8	1.5															
14	0.0747		11.9	9.2	7.6	6.3	4.7	3.5	3.0	2.5	2.1	1.8													
12	0.1046				16.7	13.1	9.7	8.0	6.5	5.6	4.6	4.1	3.2												
11	0.1196					19.2	14.2	11.1	9.0	7.5	6.3	5.5	4.4	2.9											
10	0.1345						18.6	14.5	11.9	9.9	8.5	7.3	5.8	4.0											
3/16	0.1875							27.4	23.1	19.3	16.4	14.3	11.2	7.5	5.7	4.4									
1/4	0.2500									39.4	33.3	29.5	22.7	15.4	11.4	9.0	7.4	6.1							
5/16	0.3125											50.4	39.8	27.0	19.7	15.3	12.7	10.5	7.7						
3/8	0.3750												61.6	42.3	30.9	24.0	19.6	16.3	12.3	9.5					
7/16	0.4375													61.7	45.8	35.4	28.6	24.4	17.3	14.8	11.2				
1/2	0.5000													85.2	63.6	48.8	39.7	33.3	24.6	19.4	15.9	13.1			
5/8	0.6250														110.0	86.2	70.0	58.3	43.1	33.3	27.4	23.3	16.9		
3/4	0.7500																110.0	93.0	68.7	53.5	43.6	36.5	27.1	21.0	
7/8	0.8750																	137.0	104.0	80.7	64.6	52.9	39.7	31.6	
1	1.0000																		143.0	113.0	91.2	76.2	56.3	44.2	

The tonnage indicated in the black boxes are for die openings 8 times the material thickness up to 1/4 in. and 10 times the material thickness above 1/4 in. The inside radius of a right angle bend is approximately equal to the thickness of the material. Bending pressures for other metals, as compared to mild steel on chart, are as follows: soft brass - 50% of pressure shown; soft aluminum - 50% of pressure shown; aluminum alloys heat - treated - same as steel; stainless steel - 50% more than steel; chrome molybdenum - 100% more than steel.

All of the above bending pressures are nominal and represent average conditions. These values are dependent upon the radii of the dies, the yield strength of the material, the tonnage of the material, the direction of the rolling grains, etc.

THEREFORE A SAFETY FACTOR OF AT LEAST 20% SHOULD BE PROVIDED IN SELECTING A PRESS FOR A GIVEN JOB

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DANGER
DISCONNECT POW
BEFORE WORKING