



RETURN BIDS TO:
RETOURNER LES SOUMISSIONS À:
Bid Receiving Public Works and Government
Services Canada/Réception des soumissions Travaux
publics et Services gouvernementaux Canada
Pacific Region
401 - 1230 Government Street
Victoria, B.C.
V8W 3X4
Bid Fax: (250) 363-3344

SOLICITATION AMENDMENT MODIFICATION DE L'INVITATION

The referenced document is hereby revised; unless otherwise indicated, all other terms and conditions of the Solicitation remain the same.

Ce document est par la présente révisé; sauf indication contraire, les modalités de l'invitation demeurent les mêmes.

Comments - Commentaires

Vendor/Firm Name and Address
Raison sociale et adresse du
fournisseur/de l'entrepreneur

Issuing Office - Bureau de distribution
Public Works and Government Services Canada -
Pacific Region
401 - 1230 Government Street
Victoria, B. C.
V8W 3X4

Title - Sujet High Precision Cylinder Grinder	
Solicitation No. - N° de l'invitation W3555-179182/B	Amendment No. - N° modif. 002
Client Reference No. - N° de référence du client W3555-179182	Date 2017-03-23
GETS Reference No. - N° de référence de SEAG PW-\$VIC-240-7209	
File No. - N° de dossier VIC-6-39178 (240)	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2017-04-18	Time Zone Fuseau horaire Pacific Daylight Saving Time PDT
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: Hogg(VIC), Mike	Buyer Id - Id de l'acheteur vic240
Telephone No. - N° de téléphone (250) 217-5640 ()	FAX No. - N° de FAX (250) 363-3344
Destination - of Goods, Services, and Construction: Destination - des biens, services et construction:	

Instructions: See Herein

Instructions: Voir aux présentes

Delivery Required - Livraison exigée	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

This amendment has been raised to amend both 1.23.15.1 and 1.23.15.3

Please Delete: Annex A – Requirement in its entirety

Please Insert:

Annex A - Requirement

Overview:

The following is the minimum Government of Canada requirements for one (1) cylindrical grinder unit to be used in the machine shop at Fleet Maintenance Facility CAPE BRETON (FMF CB). This unit is replacing an old cylindrical grinder that is beyond economical repair.

Item	Minimum Mandatory Requirements	Comments	Bid Ref Page #	Pass/ Fail
REGULATORY REQUIREMENTS				
1.0	All electrical equipment supplied under the contract must be certified or approved for use in accordance with the <i>Canadian Electrical Code, Part 1</i> , before delivery, by a certification organization accredited by the Standards Council of Canada.			
UNIT REQUIREMENTS				
1.1	Unit must be a cylindrical grinder.			
1.2	Unit must be able to be manually controlled. Unit must have individual handwheels/levers/controls for fine manual positioning of each axis.			
1.3	Unit must have a distance between centres of at least 400 mm (15.7").			
1.4	Unit must have a swing over the table of at least 200 mm (7.9").			
1.5	Unit's centers must be rated to support a workpiece load of at least 60 kg (132 lbs.).			
1.6	Unit's grinding capacity must be at least 180 mm (7.1") diameter.			
1.7	Unit must have a grinding wheel head with the following specifications:			
1.7.1	• Minimum Feed Increment Input: 0.001 mm/0.00005"			
1.7.2	• Travel by Handwheel: At least 135 mm (5.3")			
1.7.3	• Swivel Angle Range: At least ±30°			
1.7.4	• Spindle Power Rating: At least 2.5 HP (1.87 kW)			
1.7.5	• Two (2) Spindle Speed Settings:			
1.7.5.1	○ Setting #1: Between 2000 RPM to 2300 RPM			
1.7.5.2	○ Setting #2: Between 2301 RPM to 2750 RPM			
1.7.6	• Sliding Seat Adjustment: At least 90 mm (3.5")			
1.7.7	• Rapid Traverse Function			
1.8	Unit must have a grinding wheel with the following specifications:			
1.8.1	• Diameter between 305 mm to 405 mm (12" to 16")			
1.8.2	• Width between 38 mm to 50 mm (1.5" to 2")			
1.8.3	• Wheel Bore Inner Diameter: 127 mm (5")			
1.9	Unit must have a handwheel for the feed of the table with following specifications:			

Item	Minimum Mandatory Requirements	Comments	Bid Ref Page #	Pass/Fail
1.9.1	<ul style="list-style-type: none"> Feed per each handwheel turn must have two (2) steps within the following ranges: 			
1.9.1.1	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Step 1: Between 15 mm/rev to 25 mm/rev (0.6 in/rev to 1.0 in/rev) 			
1.9.1.2	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Step 2: Between 1.5 mm/rev to 2.5 mm/rev (0.06 in/rev to 0.1 in/rev) 			
1.9.2	<ul style="list-style-type: none"> Graduation markings on handwheel must be displayed in inches. Graduation markings on handwheel must be the following for each feed step: 			
1.9.2.1	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Step 1: 0.01" 			
1.9.2.2	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Step 2: 0.001" 			
1.10	Unit must have a handwheel for the feed of the wheel head with following specifications:			
1.10.1	<ul style="list-style-type: none"> Feed per each handwheel turn must be below 2 mm/rev (0.08 in/rev) 			
1.10.2	<ul style="list-style-type: none"> Graduation markings on handwheel must be displayed in inches. Graduation markings on handwheel must be 0.0002". 			
1.11	Unit must have a table with the following specifications:			
1.11.1	<ul style="list-style-type: none"> Swivel Angle Range: Inclusive of -3° through +12° 			
1.11.2	<ul style="list-style-type: none"> Variable Traverse Speed Range: Inclusive of 50 mm/min through 4000 mm/min (2 in/min to 157 in/min) 			
1.11.3	<ul style="list-style-type: none"> Auto-reciprocating stroke: Minimum must be less than 10mm (0.40") 			
1.12	Unit must have a work spindle head with the following specifications:			
1.12.1	<ul style="list-style-type: none"> Center Taper: Morse Taper, must be same as tailstock (1.13.1) 			
1.12.2	<ul style="list-style-type: none"> Swivel Angle Range: Inclusive of +90° through -30° 			
1.12.3	<ul style="list-style-type: none"> Load Capacity of Spindle including Work Holder: At least 15 kg (33 lbs) 			
1.12.4	<ul style="list-style-type: none"> Spindle Power Rating: At least 1 HP (0.75 kW) 			
1.12.5	<ul style="list-style-type: none"> Variable Spindle Speed Range: Inclusive of 15 through 275 RPM 			
1.13	Unit must have a tailstock with the following specifications:			
1.13.1	<ul style="list-style-type: none"> Center Taper: Morse Taper, must be same as work spindle (Item 1.12.1) 			
1.13.2	<ul style="list-style-type: none"> Stroke: At least 19 mm (0.75") 			
1.14	Unit must have a coolant system with a magnetic separator and paper filter.			
1.15	Unit must not exceed the following overall dimensions (including unit's travel envelope and accessory systems/equipment) and weight:			
1.15.1	<ul style="list-style-type: none"> Length: 2500 mm (98.4") 			
1.15.2	<ul style="list-style-type: none"> Depth: 1950 mm (76.7") 			
1.15.3	<ul style="list-style-type: none"> Weight: 2500 kg (5500 lbs.) 			
1.16	Unit must be able to connect to a 480 V, 60 Hz, 3 phase power source. Full load amperage must not exceed 16 Amps. For units requiring other voltages, supplier must supply a suitable transformer.			
1.17	Unit must have a wheel head guard.			
1.18	Unit must be fitted with an 'Emergency Stop' self-locking type button.			
1.19	Unit must have work light to illuminate the workpiece.			

Item	Minimum Mandatory Requirements	Comments	Bid Ref Page #	Pass/Fail
1.20	Unit must have a 2-axis digital read-out system with the following specifications:			
1.20.1	<ul style="list-style-type: none"> Digital read-out units must be able to be displayed in imperial (inches) and metric (millimeters and/or microns) 			
1.20.2	<ul style="list-style-type: none"> Display Resolution: 0.001 mm/0.00005" 			
1.21	Operating instruction labels must be clearly identified and printed in English.			
1.22	Any pinch points, hazard areas, operator safety concerns, and moving components must be identified and clearly labelled in English.			
TOOLING REQUIREMENTS				
1.23	Unit must come with the following tooling, at a minimum:			
1.23.1	<ul style="list-style-type: none"> Internal Grinding Attachment – Qty. 1 			
1.23.2	<ul style="list-style-type: none"> Carbide Tipped Work Centers – Qty. 2 			
1.23.3	<ul style="list-style-type: none"> 3-Jaw Scroll Chuck with Reversible Jaws – Between 115 mm (4.5") to 140 mm (5.5") Diameter Capacity – Qty. 1 			
1.23.4	<ul style="list-style-type: none"> Adjustable Independent 4-Jaw Chuck – Between 150 mm (5.5") to 216 mm (8.5") Diameter Capacity – Qty. 1 			
1.23.5	<ul style="list-style-type: none"> Wheel Flanges and Balancing Weights – Qty. 6 			
1.23.6	<ul style="list-style-type: none"> Set of Cam Lock type Work Driving Dogs – Qty. 1 			
1.23.7	<ul style="list-style-type: none"> Diamond Tool Holder for Internal and External Grinding Wheel (Table Mounted Type) – Qty. 1 			
1.23.8	<ul style="list-style-type: none"> Tailstock-mounted Diamond Tool Holder – Qty. 1 			
1.23.9	<ul style="list-style-type: none"> Table-mounted Diamond Tool Holder – Qty. 1 			
1.23.10	<ul style="list-style-type: none"> Wheel Balancing Stand and Arbor – Qty. 1 			
1.23.11	<ul style="list-style-type: none"> Angle Trimming Device – Qty. 1 			
1.23.12	<ul style="list-style-type: none"> Radius Trimming Device – Qty. 1 			
1.23.13	<ul style="list-style-type: none"> 3-Point Steady Rest – Qty. 1 			
1.23.14	<ul style="list-style-type: none"> 2-Point Steady Rest (Long Bar Grinding Type) – Qty. 2 			
1.23.15	<ul style="list-style-type: none"> Collet Sizes 			
1.23.15.1	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Collet Chuck 			
1.23.15.2	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Imperial Collets: Ranging from 1/8" diameter through to 1" diameter with 1/32" increments. 			
1.23.15.3	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Metric Collets: Ranging from 3 mm diameter through to 26 mm diameter with 1mm increments. 			
1.23.15.4	<ul style="list-style-type: none"> <ul style="list-style-type: none"> Compatible collet chuck(s) for all supplied collets. 			
1.24	All supplied tooling must be compatible with the supplied unit.			
ADDITIONAL REQUIREMENTS				
1.25	The unit must be shipped on a truck that can be offloaded using a forklift or overhead crane. Forklift pockets or crane lifting points must be clearly identified and accessible.			
1.26	The supplied unit must include maintenance and operation manuals for the as built unit. Manuals must be provided in hard copy and digital format (PDF format on CD or DVD only). Manuals must be published in English. A minimum of two (2) hard copies and one (1) digital copy of the manual must be provided. Manuals must include vendor recommended installation instructions/drawings, maintenance schedules, hydraulic schematics, electrical schematics, and spare parts list.			

Solicitation No. - N° de l'invitation
W3555-179182/B
Client Ref. No. - N° de réf. du client
W3555-179182

Amd. No. - N° de la modif.
002
File No. - N° du dossier
VIC-5-39178

Buyer ID - Id de l'acheteur
vic240
CCC No./N° CCC - FMS No./N° VME

Item	Minimum Mandatory Requirements	Comments	Bid Ref Page #	Pass/ Fail
1.27	Supplier must provide technical support via phone and email within 12 months after delivery.			
1.28	The supplied unit must include full parts and labour warranty for a minimum of 12 months.			
1.29	Supplier must provide the make and model of the proposed equipment.			

All other terms and conditions remain unchanged