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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
TPSGC/PWGSC
601-1550, Avenue d'Estimauville
Québec
Québec
G1J 0C7

Title - Sujet Presse-plieuse CNC	
Solicitation No. - N° de l'invitation W0138-20C016/A	**Amendment No. - N° modif.** 001
Client Reference No. - N° de référence du client W0138-20C016	**Date** 2020-10-13
GETS Reference No. - N° de référence de SEAG PW-$QCN-041-17999	
File No. - N° de dossier QCN-0-43049 (041)	**CCC No./N° CCC - FMS No./N° VME**
Solicitation Closes - L'invitation prend fin **at - à** 02:00 PM **on - le** 2020-10-29	**Time Zone** **Fuseau horaire** Heure Avancée de l'Est HAE
F.O.B. - F.A.B. **Plant-Usine:** ☐ **Destination:** ☑ **Other-Autre:** ☐	
Address Enquiries to: - Adresser toutes questions à: Cloutier, Annabelle	**Buyer Id - Id de l'acheteur** qcn041
Telephone No. - N° de téléphone (418) 654-6227 ( )	**FAX No. - N° de FAX** (418) 648-2209
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**	

Canada

CNC Press-brake
Bagotville, Quebec

Amendment 001

Included in the present amendment:

1. Solicitation closing date extension
2. Replacement of Annex ''A'' – Requirement
3. Replacement of Annex ''C'' - Table of mandatory technical evaluation criteria
4. Questions and answers 1 to 30

SOLICITATION CLOSING DATE EXTENSION

The solicitation closing date is postponed to **October 29 2020**, 2pm, EDT.

REPLACEMENT OF ANNEX ''A'' – REQUIREMENT

For Annex ''A'', please apply the following changes:

DELETE: entirely Annex "A" - Requirement

ADD: Annex "A" – Requirement, which can be found on page **9 to 12** of this amendment

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REPLACEMENT OF ANNEX ''C'' – TABLE OF MANDATORY TECHNICAL EVALUATION CRITERIA

For Annex ''C'', please apply the following changes:

DELETE: entirely Annex "C" - Table of mandatory technical evaluation criteria

ADD: Annex "C" – Table of mandatory technical evaluation criteria, which can be found on page **13** of this amendment.

QUESTIONS AND ANSWERS

Question 1.
Requirement, Section 3.1, Article 1), 3), 4):

Tonnage, dimensions, motor, amperage: why specify minimums or maximums? I can understand a space constraint and electricity consumption, but I believe that specifying "minimum" for these items is only intended to reduce the number of potential bidders.

Answers: See the amended Requirement.

Question 2.
Requirement, Section 3.1, Article 2)

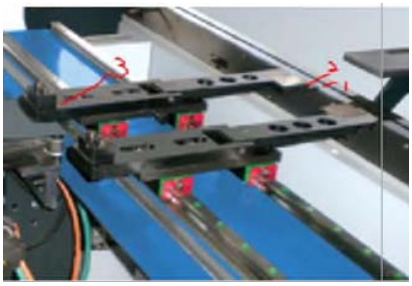
Run of the X backstops. The requirements are 40'' to 48". Is 1000MM (39.4") acceptable?

Answers: It is acceptable.

Question 3.
Requirement, Section 3.1, Article 2)

Run of the X backstops - total displacement. Tower back gauge are more convenient because they support the material. We suggest that you specify a tower back gauge (see photo, three point of support in red). Our folder are standardly equipped with a tiered stop with possible support at 39,3 inches.

Do you accept tower back gauge?



Answers: Yes, we accept tower back gauge.

Question 4.
Requirement, Section 3.1, Article 2)

Run of the R backstops - 13 to 20". The press-brake on the market usually have 7 to 10 inches of vertical running, which is more than enough to cover the entire range of standard dies as well as complex parts. Runs of 13 to 20" are in the field of press-brake of 700 tons or more where the matrix heights are more variable.

Do you accept a 7 to 10 inch for the run of the R backstops?

Answers: We can accept a 6'' to 15'' for the run of the R backstops.

Question 5.
Requirement, Section 3.1, Article 3)

The requested length is between 145" and 150". The length of our product is 150" with the security system and 152" with the removable panels. Is this acceptable?

For the width, you ask for between 75" and 80". The width of our product is 77" without support and 110" with the removable plate holder. Is this acceptable?

Answers: See the amended Requirement.

Question 6.
Requirement, Section 3.1, Article 4)

Motor. Requirements are 25 to 30 HP. Is 18.5KVA (24.8HP or 25.2HP mechanical) acceptable?

Answers: It is acceptable.

Question 7.
Requirement, Section 3.1, Article 4)

Motor. Why are you asking for a minimum of 25HP?

Answers: We are looking for a mechanical press, we have estimated that a 24,8HP or higher power engine is needed. We will need that power to work on heavy machinery equipment like snowplow. The press will need to handle parts that are 8' long by ½''.

Question 8.
Requirement, Section 3.1, Article 4)

Amperage. Requirements are 40 to 60 amps. Is 32 amps acceptable? Less amperage will result in lower energy consumption.

Answers: It is acceptable.

Question 9.
Requirement, Section 3.1, Article 5)

In the French version, you have translated "slide stroke" for "Coup des diapositives". Instead it should be translated as "Course du belier". That said, a race from 16,15'' to 20,15'' is possible however you will pay an important extra to get it.

Answers: See the amended Requirement.

Question 10.
Requirement, Section 3.1, Article 5)

Distance between walls: a minimum of 102" might make sense in the sense that you want, for example, to bend 8" between the studs with a 3' game on either side. However the maximum 104" doesn't really matter as long as you specify the total folding length. Could you remove the maximum 104"?

Answers: Yes, we can remove the maximum 104''.

Question 11.
Requirement, Section 3.1, Article 5)

Maximum opening without tools: maximum opening is often a source of dispute since it may or may not include the matrix base, the inters (tightening brake). I would specify the opening as follows: Minimum 20" between the top of the matrix base (seat of the 4-sided matrix) and and the underside of the folding ram (high European fixation). I would not specify a maximum and I assure you that at 20", you have plenty of space.

Do you have drawings that require a 24" opening?

Answers: See the amended Requirement.

Question 12.
Requirement, Section 3.1, Article 5)

Throat. Why weaken the frame for 20"? How long are your folding parts?

Answers: If the break press is well built it should not be weaken because of a 20 inches throat. We need a versatile machine for our diverse needs.

Question 13.
Requirement, Section 3.1, Article 6)

Y1/Y2 axes fast approach: these descent speeds are not representative of the majority of machines on the market. The more standard speeds are at the 5.0"/sec level.

Answers: See the amended Requirement.

Question 14.
Requirement, Section 3.1, Article 6)

Axis speed. Y1/Y2 axes while braking.The requirements are between 0.33"/sec and 0.36"/sec. Is 0.39"/sec acceptable?

Answers: Yes 0.39'' / sec is acceptable.

Question 15.
Requirement, Section 3.1, Article 6)

Y1/Y2 axes return: These speeds are not representative of the majority of machines on the market. In our opinion, at 4.5" /second, you have a more standard speed at the market and there is no impact at the folding level. I would not specify a maximum.

Answers: See the amended Requirement.

Question 16.
Requirement, Section 3.1, Article 6)

X axes: These speeds are not representative of the majority of machines on the market. Most machines are at 12'' or 16'' per second. Between 20'' and 22'' per second, it limits your options to very few press-brake on the market.

Is 12'' to 16''/second acceptable?

Answers: We are accepting 12'' to 22''/sec.

Question 17.
Requirement, Section 3.1, Article 7)

4 Axes CNC does not include the axis of the crowning system. It would be best for you to specify this way, to avoid confusion: CNC 4-1 axes (Y1-cylinder left, Y2-cylinder right, X-front/recoil of the stop, R-climb-descent of the stop, V-bombing).

Answers: See the amended Requirement.

Question 18.
Requirement, Section 3.1, Article 8)

The specifications are not accurate enough. You might just as much end up with:
A- 2D controller without graphics.
B- 2D graphic controller
C- C- Controller 2D (piece) /3D (visualization in perspective)
D- D- 3D controller (piece) / 3D full graphic (3D visualization)

And offline software
A- 2D demo software
B- 2D software full version
C- 3- Full version 3D software with the ability to import drawings in .iges, .step, .dxf, etc.

If you plan to program by machine, you only need A1 or A2 if you plan to program simple parts at a workstation but this is only a small possibility. And if you plan to import drawing files and plan complicated parts to fold, then you need to specify D3.

Answers: See the amended Requirement.

Question 19.
Requirement, Section 3.1, Article 9)

The first two statements ensure that you acquire a precise Synchro press-brake with a well-guided ram. The third statement is only a feature of the design at the level of the building that does not matter in terms of use.

Some manufacturers have slides on the inside, others on the outside and even a mixture of both. All designs are the same. The important thing is the 8 points.

Can you remove that criterion and keep the 8 point?

Answers: Yes.

Question 20.
Requirement, Section 3.1, Article 10)

There are mechanical, hydraulic, and even hybrid crowning system on the market. Many manufacturers of much more expensive press brake offer hydraulic systems that are commonly considered to be significantly superior. Why exclude a number of bidders by not accepting hydraulics? We suggest that you only indicate that you want the crowning system to be controlled by the CNC.

Answers: We will stay with the mechanical system.

Question 21.
Requirement, Section 3.1, Article 11)

All front supports are removable and adjustable. That's about all that matters. The capacity of 300kg each is very high here. Do you plan to support very heavy parts on a 240-ton folder? We have provided support arms of this capacity on folds of 400 tons or more, on request. They are standard on 600 tons and more. They are also cumbersome. And if you have a crane nearby, you can easily use it for the few times you have heavy equipment to fold.

The attached system requested limits you to bending 1/2'' steel anyway (matrix aperture - 8 times the thickness). So if you don't plan very heavy parts, you should select only "removable, adjustable in height and moving on a linear rail for fast positioning." The height is always suitable for the folder, no need to specify race. Nor do you need to specify the design as mentioned in this part of your statement: "... mounted on a guidance system ... ». This is too specific to a particular design and only aims to limit your choices unnecessarily.

Answers: See the amended Requirement.

Question 22.
Requirement, Section 3.1, Article 12)

The European and American compatibility aspect is only a good thing for you if you are currently using a press brake with American tools and want to reuse some tools on the new press. If not, you are much better off ordering a European Quick Clamping type only. In terms of attachment to the dies, the 13mm groove is only required if you reuse American tools that you currently have. If you're equipping this new press brake, you don't need it.

So two suggestions: If you reuse American tools: "Attachment for fast (with lever) universal type punches (European and American) and matrix base for European dies 60mm wide, with groove for American tooling (key 0.500 x 0.625 inches) in the center. If you don't reuse your old tools: "Fast-type European punch attachment (with lever) and matrix base for European dies 60mm wide.

Answers: We can change it to the following: "Fast-type European punch attachment (with lever) and matrix base for European dies 60mm wide.''

Question 23.
Requirement, Additional requirements for the backstop, Section 3.1.2:

This is in my opinion superfluous as information since certain points are generic on the one hand (point 1 and 2), either irrelevant (point 4, since you do not ask for the Z1-Z2 axes on the stop), or specific to a particular design that has only the characteristic of being different and not better. Most press-brake on the market are equipped with a stop with steel structure, which are significantly more resistant to impacts, which can be common on a 240-ton press-brake.

Answers: See the amended Requirement.

Question 24.
Requirement, Additional requirements for the backstop, Section 3.1.2.3:

What is the advantage? Only a manufacturer is able to respond to this point. Aluminium is less solid than steel. It is not faster or more accurate. Can you remove that criteria?

Answers: See the amended Requirement.

Question 25.
Requirement, Additional requirements for the backstop, Section 3.1.2.5:

Since when do we need precision for the R axis? Can you remove that criteria?

Answers: The criteria is removed.

Question 26.
Requirement, Additional requirements for the backstop, Section 3.1.2.5:

The required positioning accuracy is 0.0004". Is 0.0010'' acceptable?

Answers: The criteria is removed.

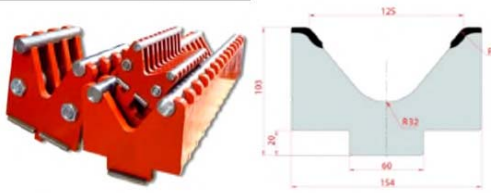
Question 27.
Requirement, Section 3.2:

Point 1 and 2:
We suggest you ask for 4 sections of 835mm - 1 x 805mm sectioned (pre-cut) if you plan to fold 10' length regularly. This will prevent you from handling cut sections frequently (less setup time). This applies to points 1 and 2 only.

Point 3 and 4 :
For items 3 and 4, folding 44W steel, 1/2' thickness ("Tensile strength" ranging from 65,000 to 85,000 psi), with a 125mm matrix and a 10mm punch, you are at 106 tons per meter of required resistance. Most punch adapters and most punches and dies of this ability have a strength of 100 tons/meter. We suggest, therefore, to minimize the risk of damage to punches, or matrix, or adapters or ram from your folder, to ask for a low friction matrix (shafts) that reduces the required tonnage by 10% (see equipment in red). You can also widen the matrix however it is already very wide if you consider a 60mm wide seat (see left). Therefore, a more rigid matrix configuration, if you want our opinion, and that would not cost you more, would be a "matrix base for European dies of 60mm and 90mm wide. All manufacturers offer this type of base and for a 125mm matrix or more, this is highly recommended.

Low friction matrixes also have the advantage of being lighter to handle, more resistant (tons per meter), mark less material as well. We have hundreds of them in use in the provinces, manufactured in Europe, customers are "very very" satisfied (multiple references to support, we have exclusive distribution in Canada).

We also offer more durable punch adapters (150 tons per meter instead of 100 tons per meter). It is also for European tools. In a case like yours it would be a clear asset and an insurance policy against human errors of programming or manipulation. Rectifying a folding press ram can cost up to $7,000 or $8,000. All rams of folders at this level of investment are made from structural steel.



Answers: See the amended Requirement.

Question 28.
Requirement, Section 3.3.1:

There are several organizations authorized to electrically certify imported equipment. Intertek and CSA are two. We use QPS more frequently, which is just as valid as accreditation. I am of the opinion that you should specify: "electrical certification carried out by an organization accredited by the Building Authority." This way you are 100% covered and do not limit your options.

Answers: The machine must be certified CSA and Intertek or QPS.

Question 29.
Requirement, Section 3.3.6:

There are different safety laser brands, some have even more than three beams and are more convenient for you in folding boxes for example. I suggest you specify as: "Multiple beam laser safety system protecting the danger zone under the punch, accredited in Canada"

Answers: See the amended Requirement.

Question 30.
Requirement, Section 3.3.7:

I have never seen this system on any machine and do not understand the operation. Could you elaborate further? I do not understand how a lighting prevents the movement of the ram?

Can you remove that criteria?

Answers: We can remove that criteria.

ALL OTHER TERMS AND CONDITIONS REMAIN UNCHANGED

ANNEX A – REQUIREMENT

Title: CNC Press-brake

1. REACH

1.1 Purpose: The 3 MSS material section wish to purchase a CNC press-brake including its installation and training.

1.2 Context: The material section require the press-brake to increase its productivity by improving the quantity and precision of replacement parts produce by the section. Also, it would eliminate the need for sub-contracting.

2. APPLICABLE DOCUMENTS

2.1 N.A.

3. REQUIREMENTS

3.1 Technical criteria – The press-brake must meet the following criteria:

1.	**BENDING CAPACITY**	Imperial tonnage	Minimum 240 T
		Overall bending length	Minimum 120” Maximum 130”
2.	**BACKSTOPS**	Type (X R)	2 axes
		Run of the X backstops (Tower back gauge is accepted)	Minimum 39.4” Maximum 48”
		Run of the R backstops	Minimum 6’’ Maximum 15”
3.	**DIMENSIONS (ALL INCLUDED)**	L x W x H (Length x Width x Height)	Maximum 152” x 110” x 135”
		Working height	Minimum 36’’ Maximum 42”
4.	**MOTOR**	Main	Minimum 24.8 HP
		Voltage	575v/3ph OR 600v/3ph
		Amperage	Minimum 32 amps
5.	**FRAME**	Distance between walls	Minimum 102,0’’
		Slide stroke	Minimum 16’’

		Max opening without tools	Minimum 20'' between the top of the matrix base (seat of the 4-sided matrix) and the underside of the folding ram (high European fixation).
		Throat	Minimum 20''
6.	**AXIS SPEED**	Y1/Y2 axes fast approach	5,0'' - 9,0''/ sec
		Y1/Y2 axes while braking	0,33'' - 0,39'' / sec
		Y1/Y2 axes return	Minimum 4.5'' / sec
		X axis	12,0'' - 22,0/ sec
		R axis	16,0'' - 18,0'' / sec
7.	**CONFIGURATION**	CNC 4+1 axes (Y1-cylinder left, Y2-cylinder right, X-front/recoil of the stop, R-climb-descent of the stop, V-bombing).	
8.	**CNC CONTROLLER**	15″ touchscreen minimum and a controller with a firmware that is not windows based, full offline software - Full version 3D software with the ability to import drawings in .iges,	
9.	**SLIDER**	8-point guidance	
10.	**CROWNING SYSTEM**	CNC controlled system, Mechanical system, without hydraulics, Solid table without opening in its center.	
11.	**FRONT SUPPORTS**	Removable, adjustable in height and moving on a linear rail for fast positioning.	
12.	**TOOL ATTACHMENT SYSTEM**	Fast-type European punch attachment (with lever) and matrix base for European dies 60mm wide.	

3.1.2 Additional requirements for the backstop:

1. Servo motor movement on both axes.
2. X axis mounted on linear guides and ball screws.
3. R axis mounted on linear guides fixed on cast aluminum or Steel block.
4. The backstop must be guaranteed against the need for recalibration for one year.

3.2 Tooling requirements included. The proponent must include the following tooling:

1. 4 sections of 835mm - 1 x 805mm sectioned (pre-cut)
2. Matrix base for European dies of 60mm and 90mm wide for a 125mm matrix or more.

3.3 Security requirements. The proponent must comply with the following requirements:

1. Certified CSA and Intertek or QPS.
2. 100% compliant to CSA norm Z142.10.
3. One three-position pedal with emergency stop.
4. Side panels with safety switches.
5. Infrared curtains to the rear.
6. Multiple beam laser safety system protecting the danger zone under the punch, accredited in Canada.
7. Safety management system that harmonizes all safety and redundancy components.

3.4 Specific requirements and customer support: The proponent will comply with the following services requirements and guarantees:

1. The purchase includes delivery, unloading and installation of the press brake.
2. The power supply will be done by members of DND within 30 days of installation;
3. On-site installation, start-up and verification of the system must be provided and performed by a qualified contractor's service technician within 30 calendar days of electrical connection;
4. The manufacturer will provide a minimum warranty of 12 months (for parts, labor and transport).
5. The manufacturer will provide telephone or email feedback on requests within a maximum period of 74 hours. This service include :
    a. Determining the nature of the problem and resolve the problem free of charge;
    b. Collaborating with DND to identify the problem and the timeframe for the repairs,
    c. Explain the problems and identify the steps to solve them.

4. TRAINING AND DOCUMENTATION

Operational and technical training must be given in French by a qualified technician in the workplace within 30 days of installation.

1. The training of 8 hours for 6 people will focus on the implementation, configuration, operation, and preventive maintenance.
2. The coordination of the training session will have to be done with the technical authority where the machine is installed.

3. A hard copy of the following documents must be delivered with the machine in French and / or English (preferably in both languages):

    a) Operating manual for the press brake and all its components.
    b) Security procedures.
    c) Preventive maintenance manual.
    d) Troubleshooting procedures.

If the contractor delivered documentations in only one of the language, he must accepted to give DND the rights to translate the documentations in the other language.

5. UNLOADING AND HANDLING OF DELIVERED PARTS

1. The contractor will be responsible for the shipping, unloading and handling all the parts, who must be brought inside the building where the press is located.

2. The contractor must be able to unload the parts where there won't be an access to an hydraulic unloading. The contractor must also have the required personnel to unload the parts without help from the federal employees.

3. Please note that no floor damage can occur during the handling and installing of the press. Any holes required for the installation of the press won't be considered as damage.

ANNEX C – TABLE OF MANDATORY TECHNICAL EVALUATION CRITERIA

REF. 4.1.1 Technical Evaluation

The technical evaluation will be based on the mandatory technical criteria detailed below.

Bidders must demonstrate each of these mandatory technical criteria with documents and/or brochures and/or technical drawings, which must be submitted with their proposal.

Bidders should complete the grid below and include it with their proposal.

TABLE OF MANDATORY TECHNICAL EVALUATION CRITERIA		
Mandatory Technical Evaluation Criteria **CNC PRESS-BRAKE:**		**Bidder's Specification** (Bidder should indicate the reference to the technical documentation included in the Bid to indicate where is the exact information. Title of documents, as well as page and paragraph numbers).
1	Bending capacity, imperial tonnage : Minimum : 240 T	_____ _____
2	Bending capacity, overall bending length : Minimum: 120'' Maximum : 130''	_____ _____
3	Dimensions all included (Length x Width x Height) : Maximum : 150'' x 110'' x 135''	_____ _____
4	Motor, main : Minimum : 24,8 HP	_____ _____
5	CNC controller : THE CRITERIA WILL NOT BE EVALUATED	_____ _____