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Bid Receiving Public Works and Government
Services Canada/Réception des soumissions/Travaux
publics et Services gouvernementaux Canada
See herein for bid submission
instructions/

Voir la présente pour les
instructions sur la présentation
d'une soumission

NA
Ontario

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
Ontario Region
10th Floor, 4900 Yonge Street
Toronto
Ontario
M2N 6A6

Title - Sujet CNC Electric Press Brakes	
Solicitation No. - N° de l'invitation W3474-211541/A	Amendment No. - N° modif. 002
Client Reference No. - N° de référence du client A12F-0155RP01	Date 2020-10-22
GETS Reference No. - N° de référence de SEAG PW-\$TOR-015-7978	
File No. - N° de dossier TOR-0-43048 (015)	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2020-11-09	
Time Zone Fuseau horaire Eastern Daylight Saving Time EDT	
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: Abela, Aaron	Buyer Id - Id de l'acheteur tor015
Telephone No. - N° de téléphone (416) 262-6212 ()	FAX No. - N° de FAX () -
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

Solicitation Amendment No. 002 is being issued to address the following:

- A) Amend Annex "A" Requirement, Item 5 – Motor Capacity**
- B) Amend Annex "A" Requirement, Item 11 – Back Gauge**
- C) Amend Annex "E" Mandatory Technical Evaluation Criteria, Item 3 – Motor Capacity**
- D) Amend Annex "E" Mandatory Technical Evaluation Criteria, Item 9 – Back Gauge**
- E) Question and Answer**

A) At Annex "A" Requirement, Item 5 – Motor Capacity

Delete: Motor Capacity: no less than 20 horse power (HP)

Insert: Motor Capacity: no less than 10 horse power (HP) where .5 Hp per servo-motor minimum

B) At Annex "A" Requirement, Item 11 – Back Gauge

Delete: Back Gauge: no less than 5-axis independent finger back gauge
Front to back positioning range (X axis) 0" minimum to 48" maximum
Positioning accuracy: +/- 0.0002" maximum
Positioning repeatability: +/- 0.002" max

Insert: Back Gauge:

One solid back gauge unit in/out – X axis – 11" min
Back Gauge Unit up/down – R1/R2 – 0" from bed top to 10" min.
Two Back Gauge Fingers – left/right – Z1/Z2 – min spread between fingers 28"
One Back Gauge Finger – forward/backward 2" min – Delta X

OR

Two separate back gauge units – in/out
Each unit goes up/down, left/right/ fingers forward and backward
This configuration must be equivalent to the one solid back gauge capability

C) At Annex "E" Mandatory Technical Evaluation Criteria, Item 3 – Motor Capacity

Delete: Motor Capacity: no less than 20 horse power (HP)

Insert: Motor Capacity: no less than 10 horse power (HP) where 5 HP per servo-motor minimum

D) At Annex "E" Mandatory Technical Evaluation Criteria, Item 9 – Back Gauge

Delete: Back Gauge: no less than 5-axis independent finger back gauge
Front to back positioning range (X axis) 0" minimum to 48" maximum
Positioning accuracy: +/- 0.0002" maximum
Positioning repeatability: +/- 0.002" max

Insert: Back Gauge:

One solid back gauge unit in/out – X axis – 11" min
Back Gauge Unit up/down – R1/R2 – 0" from bed top to 10" min.
Two Back Gauge Fingers – left/right – Z1/Z2 – min spread between fingers 28"
One Back Gauge Finger – forward/backward 2" min – Delta X

OR

Two separate back gauge units – in/out
Each unit goes up/down, left/right/ fingers forward and backward
This configuration must be equivalent to the one solid back gauge capability

C) Questions and Answers

Q1: Page 14 – 4.5 – Motor Capacity: no less than 20 HP minimum?

No 40 ton press brake, mechanical, hydraulic or electric will have that much horsepower. An electric brake will use perhaps 5 HP for each of the two servo-motors = 10 HP.

A1: Reference above sections.

Q2: Page 15 – 4.11 – Back Gauge: no less than 5-axis independent finger back gauge?

There are two different types of back gauges available:

1. One solid back gauge unit in/out – X axis
Back Gauge Unit up/down – R
Two Back Gauge Fingers – left/right – Z1,Z2
One Back Gauge Finger – forward/backward 2" – Delta X
OR
2. Two separate back gauge units – in/out
Each unit goes up/down, left/right/ fingers forward and backward.

Both are considered 5 axes but the second one is called independent Back gauge units – each unit – 5 axes.

Which one are you requesting?

A2: Reference above sections.

Q3. Page 15 – 4.2.6 – Hydraulic, electric or manual (quick tool clamping)

We can offer manual with quick manual clamping or hydraulic – please advise which you require?

On a 4' to 5' electric press brake, we recommend manual quick clamps, not hydraulic clamping – not unless operator is changing tooling constantly through the day. Why put hydraulics on an electric brake???

A3: Since we are a prototype/short series job shop hydraulic or electric clamping is preferred.

Q4: Page 16 – 4.3.21 – Ram Tilt

Electric press brakes do not have ram tilt – hydraulic brakes do?

A4: Independently controlled drive (Y1 and Y2) to correct deviation in the bend angle on the length of the bend is acceptable.

ALL OTHER TERMS AND CONDITIONS REMAIN THE SAME