



RETURN BIDS TO:

RETOURNER LES SOUMISSIONS À:

Réception des soumissions - TPSGC / Bid Receiving -
PWGSC

Voir dans le document/

See herein

NA

Québec

NA

**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 CNC Press-Brake	
Solicitation No. - N° de l'invitation W0138-20C016/A	Amendment No. - N° modif. 003
Client Reference No. - N° de référence du client W0138-20C016	Date 2020-10-27
GETS Reference No. - N° de référence de SEAG PW-\$QCN-041-17999	
File No. - N° de dossier QCN-0-43049 (037)	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM on - le 2020-11-03	Time Zone Fuseau horaire Heure Normale du l'Est HNE
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: Roy, Alain	Buyer Id - Id de l'acheteur qcn037
Telephone No. - N° de téléphone (418) 906-8611 ()	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

**CNC Press-brake
Bagotville, Quebec**

Amendment 003

Included in the present amendment:

- 1. Solicitation closing date extension**
- 2. Questions and Answers 33 to 36**

1. SOLICITATION CLOSING DATE EXTENSION

The solicitation closing date is postponed to November 3, 2020, 2pm, EST.

2. QUESTIONS AND ANSWERS

Question 33:

Could you tell us the reasons why you do not accept hydraulic bending systems?

Answer:

We purchase this press brake for use over a very long period of time, from our knowledge of hydraulics, as we are working a heavy equipment garage, hydraulic systems are subject to more maintenance (Seal change, addition of oil, drying hoses and the pump which can break). A mechanical system requires only periodic lubrication.

We have an unusual use of our machinery, in the industry this type of press brake is used on a regular basis while in our case we can be several months without using the machinery.

When we need to use our tools, we cannot afford maintenance delays, we must react quickly to respond to NORAD operations.

Question 34:

Regarding section 3.1, article 5, minimum slide stroke of 16" and minimum tool-less opening of 20". For the majority of press brake manufacturers, the distance between the opening and the stroke is about 300mm (taking into account the average height of the following elements: die base + clamps + standard die + standard punch).

By asking for a stroke (C) of 16" (400mm) with an opening (E) of 20" (500mm) (E), you end up with a gap of 100mm instead of 300mm. This means that 200mm at the end of the stroke is blocked because once the base/flanges/tools are installed, you will not be able to use this 200mm end of stroke.

You mention flexibility in your addendum you are looking for. Knowing that standard bending machines of this format have strokes (C) in the range of 200 to 250mm and openings (E) in the range of 500 to 550mm, we recommend that you increase the maximum opening without tools in proportion to the increase in stroke desired. And if you allow me, with 16" of stroke (C) on a 250 ton press brake, you will most likely have the press brake of this format with the largest stroke in the province, if not in Eastern Canada. If you don't have any parts that require such a stroke, may I suggest a 12" stroke (C) with an opening (E) without tools / inter / base) of about 24"? You will already be this way at the top of all folding machines in the province, unless you have "very" large and rather complex parts to fold.

Answer:

We are willing to bring flexibility to the slide stroke at 14 inch to accommodate more suppliers, understand that our need for 16 inch is justifiable for the manufacture of pliers and attachments of heavy equipment use for the maintenance of the airfield serving NORAD to be operational.

Question 35

Regarding Section 3.1, Article 8, CNC Controller.

Could you tell us your reasons for not accepting controllers that are Windows-based?

Most major brands of press brake controllers are based on the Windows operating system.

Answer:

We make a modification to section 3.1 article 8:

We accept real-time embedded Windows systems only if: we have access to instant shutdown and a multitasking environment.

Question 36:

To bend 44W 1/2" x 8' long steel, you need at least a 260T metric press. This being said, a 260T press does not meet the dimensional requirements requested in the call for tenders for most models.

Answer:

According to the bending charts as shown below (next page). A standard 24.6 tons per foot is sufficient, so with a minimum of play, a 200 ton press brake would only be required to bend an 8 foot steel plate on a 5 inch radius. This said, a 240 ton press is sufficient for the use we want to make of it.

N° de l'invitation - Solicitation No.
W0138-20C016/A
N° de réf. du client - Client Ref. No.
W0138-20C016

N° de la modif - Amd. No.
003
File No. - N° du dossier
QCN-0-43049

Id de l'acheteur - Buyer ID
qcn041
N° CCC / CCC No. / N° VME - FMS

Thickness of Metal		Width of Female Die Opening																			
		Approximate pressure in tons per linear foot required to make a 90-degree air bend in mild steel (50,000 PSI tensile)																			
		Gauge	Dec.	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	1 5/8"	2"	2 1/4"
20	0.036	2.6	2.2	1.6	1.2	1.0															
18	0.048		3.5	2.8	2.1	1.7	1.3														
16	0.060			5.3	3.7	2.8	2.2	1.7													
14	0.075				5.5	4.6	3.5	3.0	2.5	2.1											
13	0.090					6.4	5.5	4.3	3.6	3.2	2.8										
12	0.105					9.2	6.9	6.2	5.0	4.3	3.9	3.1									
11	0.120						10.1	8.0	7.0	6.1	5.3	4.3	2.9								
10	0.135							10.3	8.7	7.8	6.9	5.7	3.9								
9	0.150								11.9	9.8	8.8	7.0	5.0	3.7							
7	0.180									16.9	13.9	11.2	8.3	6.7	4.9						
5/8"	0.250										27.5	22.1	15.0	11.6	9.6	7.9	6.7				
3/4"	0.312											39.2	26.5	19.3	15	12.5	10.4	7.7			
1/2"	0.375												42.7	31.2	23.8	19.5	16.3	12.4	9.6		
5/16"	0.437														45.5	35.2	28.5	24.4	17.4	15.0	11.5
1/4"	0.500															48.5	39.5	33.2	24.6	19.5	16.1
3/8"	0.625																65.5	57.9	42.8	33.1	27.3
1/2"	0.750																	92.3	68.1	53.0	36.2
3/4"	0.875																		101.1	79.9	52.3
1	1.00																			112.1	90.4

ALL OTHER TERMS AND CONDITIONS REMAIN UNCHANGED.