



RETURN BIDS TO:

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Bid Receiving - PWGSC / Réception des soumissions -
TPSGC

11 Laurier St. / 11, rue Laurier

Place du Portage, Phase III

Core 0B2 / Noyau 0B2

Gatineau, Québec K1A 0S5

Bid Fax: (819) 997-9776

**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

Electrical & Electronics Products Division
L'Esplanade Laurier
East Tower, 4th floor,
Ottawa
Ontario
K1A 0S5

Title - Sujet CNC Milling Machine CNC Milling Machine	
Solicitation No. - N° de l'invitation 23240-210542/A	Amendment No. - N° modif. 002
Client Reference No. - N° de référence du client 23240-210542	Date 2020-11-25
GETS Reference No. - N° de référence de SEAG PW-\$\$HN-331-79314	
File No. - N° de dossier hn331.23240-210542	CCC No./N° CCC - FMS No./N° VME
Solicitation Closes - L'invitation prend fin at - à 02:00 PM Eastern Standard Time EST on - le 2021-01-04 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: Turner, Louie	Buyer Id - Id de l'acheteur hn331
Telephone No. - N° de téléphone (613) 297-3769 ()	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 No. - N° de l'invitation
23240-210542/A
Client Ref. No. - N° de réf. du client
23240-210542

Amd. No. - N° de la modif.
002
File No. - N° du dossier
hn331.23240-210542

Buyer ID - Id de l'acheteur
hn331
CCC No./N° CCC - FMS No./N° VME

Amendment #2 is issued to revise Annex A - Specifications and Annex B - Technical Evaluation

All other terms and conditions remain the same.

Annex A - Specifications

MANDATORY SPECIFICATIONS: 3 AXIS CNC TOOLROOM MILLING MACHINE WITH 4TH AXIS CAPABILITY

The research facilities at CanmetMining – Engineering Technical Services have a need for a 3 axis cnc machine tool with 4th axis capability. The machine must meet or exceed all of the listed criteria. Please review the mandatory specifications below and provide specific page numbers and supporting technical documentation to verify this.

3 AXIS CNC BED MILL TECHNICAL SPECIFICATIONS

<i>SPECIFICATION</i>	<i>Mandatory</i> M	<i>Desirable</i> D	SUPPLIER DESCRIPTION OF COMPLIANT FEATURE OR SPECIFICATION INCLUDING REFERENCE MATERIAL
MACHINE CAPACITY: X axis travel => 59" (1498.6mm) Y axis travel => 29" (736.6mm) Z axis travel => 26" (660.4mm) Table size => 66"x23" (1676.4mm x 584.2mm) Allowable table load => 3306.9lbs (1500kg) T slot size .71" (18mm)	M M M M M M		
MACHINE SPINDLE: Spindle nose to table =<3.150" (80mm) => 29.921" (760mm) Spindle taper = Cat 40 taper Spindle speed => 8000 rpm AC spindle motor =>11/15 kw	M M M M M		

AUTOMATIC TOOL CHANGER: ATC type = carousel Number of tools => 20 Tool shank = CT 40 Pull stud = MAS 60 deg Retention Knob CT-flange 40 Taper Max tool diameter => 3.5" (80mm) Max tool length => 4.724" (120mm) Max tool weight => 15 lbs (7kg)	M M M M M M M		
CNC MOTION: XYZ rapid traverse rate => 24 m/min XYZ max feed rate => 7.6 m/min Positioning accuracy =< .01/300 mm Repeatability =< +/-0.01 mm Axis thrust force X/Y,Z => 3000/4000 lbs (1360/1800 kg)	M M M M M		
GENERAL MACHINE REQUIREMENTS: Machine Height =< 101.96" (2590 mm) Floor Space Required (W x D) =< (4500 x 4300 mm) Machine Weight => 13889 lbs (6300kg) Coolant flood system Fluorescent lamps	M M M M 	D	

<p>ELECTRICAL SPECIFICATION (S):</p> <p>575 V, 3 phases, 60 cycles on site, supplier must provide any transformer(s) required.</p> <p>Main feed and sub feed to the machine will be carried out by NRCan (Natural Resources Canada) electrical department. The supplier will be responsible for the Final Hook Up.</p> <p>Machine and control must be certified by an organization accredited by the Standards Council of Canada (SCC) to meet local electrical code.</p>	<p>M</p> <p>M</p> <p>M</p>		
<p>WARRANTY:</p> <p>One year parts and labor on machine, power supply, control and coolant supply unit.</p> <p>Supplier will provide technical support and service during normal working hours for the duration of the warranty period.</p> <p>Warranty will begin on the day that the machine and control are installed (fully operational)</p> <p><i>Travel costs for all warranty service included in warranty.</i></p>	<p>M</p> <p>M</p> <p>M</p> <p>M</p>		
<p>MANUAL (S):</p> <p>Two sets of all Safety, Operating and Maintenance manuals are required.</p>	<p>M</p>		
<p>TRAINING:</p> <p>On site training for a min of two (2) days for a group of two (2) employees.</p>	<p>M</p>		

DELIVERY / INSTALLATION:			
Delivery before March 31, 2021.	M		
Upon delivery machine must be fully operational within 10 business days.	M		
Supplier is responsible for unloading and delivery of machine from loading dock to placement in shop site.	M		
The supplier will be responsible for complete installation, levelling, final electrical hook up. All inspection and testing including Electrical certification.	M		
Supplier will ensure machine (or partially disassemble) to pass through a 93" x 103" (2362mm x 2616mm) (W x H)	M		
Bidders must perform a mandatory onsite inspection to ensure delivery and installation is possible due to space restrictions of transporting machine from loading dock to the shop and in the shop. (Refer to note 5 in section 1 of solicitation)	M		

Annex B - Technical Evaluation

MANDATORY SPECIFICATIONS: 3 AXIS CNC TOOLROOM MILLING MACHINE WITH 4TH AXIS CAPABILITY

The research facilities at CanmetMining – Engineering Technical Services have a need for a 3 axis cnc machine tool with 4th axis capability. The machine must meet or exceed all of the listed criteria. Please review the mandatory specifications below and provide specific page numbers and supporting technical documentation to verify this.

3 AXIS CNC BED MILL TECHNICAL SPECIFICATIONS

<i>SPECIFICATION</i>	<i>Mandatory</i> <i>M</i>	<i>Desirable</i> <i>D</i>	Pass/Fail
MACHINE CAPACITY: X axis travel => 59" (1498.6mm) Y axis travel => 29" (736.6mm) Z axis travel => 26" (660.4mm) Table size => 66"x23" (1676.4mm x 584.2mm) Allowable table load => 3306.9lbs (1500kg) T slot size .71" (18mm)	M M M M M M		
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AUTOMATIC TOOL CHANGER: ATC type = carousel Number of tools => 20 Tool shank = CT 40 Pull stud = MAS 60 deg Retention Knob CT-flange 40 Taper Max tool diameter => 3.5" (80mm) Max tool length => 4.724" (120mm) Max tool weight => 15 lbs (7kg)	M M M M M M M		
CNC MOTION: XYZ rapid traverse rate => 24 m/min XYZ max feed rate => 7.6 m/min Positioning accuracy =< .01/300 mm Repeatability =< +/-0.01 mm Axis thrust force X/Y,Z => 3000/4000 lbs (1360/1800 kg)	M M M M M		
GENERAL MACHINE REQUIREMENTS: Machine Height =< 101.96" (2590 mm) Floor Space Required (W x D) =< (4500 x 4300 mm) Machine Weight => 13889 lbs (6300kg) Coolant flood system Fluorescent lamps	M M M M	D	

<p>ELECTRICAL SPECIFICATION (S):</p> <p>575 V, 3 phases, 60 cycles on site, supplier must provide any transformer(s) required.</p> <p>Main feed and sub feed to the machine will be carried out by NRCan (Natural Resources Canada) electrical department. The supplier will be responsible for the Final Hook Up.</p> <p>Machine and control must be certified by an organization accredited by the Standards Council of Canada (SCC) to meet local electrical code.</p>	<p>M</p> <p>M</p> <p>M</p>		
<p>WARRANTY:</p> <p>One year parts and labor on machine, power supply, control and coolant supply unit.</p> <p>Supplier will provide technical support and service during normal working hours for the duration of the warranty period.</p> <p>Warranty will begin on the day that the machine and control are installed (fully operational)</p> <p><i>Travel costs for all warranty service included in warranty.</i></p>	<p>M</p> <p>M</p> <p>M</p> <p>M</p>		
<p>MANUAL (S):</p> <p>Two sets of all Safety, Operating and Maintenance manuals are required.</p>	<p>M</p>		
<p>TRAINING:</p> <p>On site training for a min of two (2) days for a group of two (2) employees.</p>	<p>M</p>		

DELIVERY / INSTALLATION:			
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Bidders must perform a mandatory onsite inspection to ensure delivery and installation is possible due to space restrictions of transporting machine from loading dock to the shop and in the shop. (Refer to note 5 in section 1 of solicitation)	M		