



**RETURN BIDS TO:**

**RETOURNER LES SOUMISSIONS À:**

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

Manitoba

**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/Réception des soumissions Travaux publics et  
Services gouvernementaux Canada  
Government of Canada Building  
101 - 22nd Street East  
Suite 110  
Saskatoon  
Saskatche  
S7K 0E1

<b>Title - Sujet</b> CNC Lathe (Computer Numerical Control)	
<b>Solicitation No. - N° de l'invitation</b> W0134-21R012/B	<b>Amendment No. - N° modif.</b> 005
<b>Client Reference No. - N° de référence du client</b> W0134-21R012	<b>Date</b> 2021-06-23
<b>GETS Reference No. - N° de référence de SEAG</b> PW-\$STN-207-5460	
<b>File No. - N° de dossier</b> STN-0-43119 (207)	<b>CCC No./N° CCC - FMS No./N° VME</b>
<b>Solicitation Closes - L'invitation prend fin</b> <b>at - à 02:00 PM</b> Central Daylight Saving Time CDT <b>on - le 2021-06-29</b> Heure Avancée du Centre HAC	
<b>F.O.B. - F.A.B.</b> <b>Plant-Usine:</b> <input type="checkbox"/> <b>Destination:</b> <input checked="" type="checkbox"/> <b>Other-Autre:</b> <input type="checkbox"/>	
<b>Address Enquiries to: - Adresser toutes questions à:</b> Perrin, Melanie	<b>Buyer Id - Id de l'acheteur</b> stn207
<b>Telephone No. - N° de téléphone</b> (306) 491-5871 ( )	<b>FAX No. - N° de FAX</b> (418) 566-6167
<b>Destination - of Goods, Services, and Construction:</b> <b>Destination - des biens, services et construction:</b>	

Instructions: See Herein

Instructions: Voir aux présentes

<b>Delivery Required - Livraison exigée</b>	<b>Delivery Offered - Livraison proposée</b>
<b>Vendor/Firm Name and Address</b> <b>Raison sociale et adresse du fournisseur/de l'entrepreneur</b>	
<b>Telephone No. - N° de téléphone</b> <b>Facsimile No. - N° de télécopieur</b>	
<b>Name and title of person authorized to sign on behalf of Vendor/Firm</b> <b>(type or print)</b> <b>Nom et titre de la personne autorisée à signer au nom du fournisseur/</b> <b>de l'entrepreneur (taper ou écrire en caractères d'imprimerie)</b>	
<b>Signature</b>	<b>Date</b>

**This Amendment is in response to questions for solicitation W0134-21R012/B, CNC Lathe:**

**Question 6.**

Please clarify if the delivery is to the door or floor

**Response 6.**

The delivery must be to the floor or the shop. An amendment to the specification listing has been made. (#39)

**Question 7.**

Please clarify who is responsible for offloading the machine and moving the machine from the truck to the place of installation.

**Response 7.**

Contractor must unload and place machine on the floor of the shop where designated by the shop supervisor. An amendment to the specification listing has been made. (#39)

**Question 8.**

What is the maximum size of the parts that will be used with machine? The Maximum turning length of our offered machine is 340 mm (13"). If for example a part that you have turn on the lathe is 12 " you need to fix it with a tailstock that is located in the opposite side of the main chuck, otherwise the part will swing when turning. Let us know if this option is required.

**Response 8.**

13" is acceptable. Very rarely will the stock being turned be more than 5" long. But there must be provision for the tail stock to hold that 5" piece between centres with a live centre installed in it.

**Question 9.**

With reference to item 35 of compliance table, "*ID Tool/Boring Bar Holder 1-1/4" minimum – x3pcs minimum*", our machine comes with ID Tool/Boring Bar Holder of 1" instead of 1-1/4" . Please confirm if this is acceptable.

**Response 9.**

Unfortunately, no. We have specified this for two reasons:

1. We currently have 3 lathes using 1 1/4" thick boring bars. So we already hold a large number of these in our inventory.
2. On a 5" hole, we require the rigidity to reduce deflection at the bottom (or end) which would otherwise require repeated passes to clear up until a satisfactory standard is reached.

**Question 10.**

Regarding 4" 3 jaw chuck which is fine however it is also specifying a 5C Collet Chuck.

Are you looking for both as typically once a hydraulic 3 jaw or collet chuck is mounted it remains mounted. Not a simple task to be switching from one to the other.

**Response 10.**

We did not request a hydraulic holding capability in our specifications. Many of our parts are manufactured as a "one-off" type of deal. While we have manufactured a number of oversized "blanks" in the sizes we most often require with the secondary CNC operations being carried out by computer, we still need to manually insert a "stock" oversized part since we would only do one or two that that exact specification and the next one would be different.

**Question 11 :**

A 5C collet chuck is only 1 1/16" and a 4" 3 jaw chuck is only 1.25" Can you confirm the maximum size(diameter) of bar material to be machined that will be used in the lathe?

**Response 11 :**

1.25" material will be maximum.

**This Amendment is being raised to make the following changes:**

**Delete:                    Annex A – Requirement, Amendment 1 in its entirety; and**

**Insert:                    Annex A – Requirement, Amendment 2**

**Delete:                    Annex C – COMPLIANCE MATRIX – MINIMUM MANDATORY PERFORMANCE SPECIFICATIONS, Amendment 1 in its entirety; and**

**Insert:                    Annex C – COMPLIANCE MATRIX – MINIMUM MANDATORY PERFORMANCE SPECIFICATIONS, Amendment 2**

**The changes in the specification list are highlighted in Annex A – Requirement, Amendment 2 and in Annex C – COMPLIANCE MATRIX – MINIMUM MANDATORY PERFORMANCE SPECIFICATIONS, Amendment 2**

*All other terms and conditions remain the same.*

## **ANNEX A – REQUIREMENT, Amendment 2**

### **1. Purpose**

The Department of National Defence (DND) 4 Wing Cold Lake, 1 Air Maintenance Squadron (1 AMS) Machine Shop requires the supply and delivery of one (1) hazardous material CNC Lathe (Computer Numerical Control). The procurement of this operationally essential machine will significantly improve 1 AMS Machine Shop's capability to produce Beryllium Copper (BeCu) parts in a controlled and safe environment.

### **2. Background**

The current conventional engine lathes are not made to contain the airborne particulates of BeCu. Consequently, the BeCu is spread all over the shop environment and can also pose a risk for contamination outside the shop and at home. At the moment, all lubricant in the lathe needs to be drained, and lathe cleaned each time we machine BeCu. It produces a lot of hazardous waste and requires excessive man hours and resources.

CNC Lathes allow for the precise manufacturing of metal parts. Once programmed, the machine will automatically produce a part through high speed rotation and milling of the metal. The machines allow for drawings to be inputted as well as for the programmer to manual design the part directly on the CNC lathes interface screen.

### **3. Terminology**

BeCu – Beryllium Copper is a toxic compound that, when in a fine particulate form, can cause adverse respiratory reactions in sensitive individuals.

CNC Lathe – Computer Numerical Controlled lathes are programmable machines that allow for the precise machining of metal components through software inputs (Computer Assisted Drawings, manual inputs, etc).

### **4. Mandatory Requirements**

Contractor must provide on-site training for the machine and controller within 4 weeks or a mutually agreed upon time between the Contractor and the technical authority, after installation at the customer facility.

Installation, leveling and commissioning of the machine is required and must be carried out by factory trained and certified personnel.

Contractor must respond to service calls within 48 hours or at a mutually agreed upon time between the Contractor and the technical authority.

Item #	Performance Specification
	<b>CAPABILITIES</b>
1	Repeatability (X/Z) $\pm 0.0002"$ or better
2	8 Station Automatic Tool Turret Minimum
3	Rigid Tapping
4	Spindle Bore Diameter of 1.5" Minimum, Spindle nose must hold 5C collets
5	4" 3-Jaw Chuck Minimum
6	Built-in Work Light Side
	Discharge Chip Conveyor
7	Automatic Parts Catcher
8	Must include 5C Collet holder and set of collets 3/32" – 1" w/ drawbar
9	<b>MOTOR</b>
10	Machine must run on 208/240V, Three-Phase, 60Hz power internal power only, (External transformers <b>NOT</b> accepted).
11	8HP Main Spindle Motor Minimum
12	Spindle Speed of 4000RPM Minimum
	<b>FEATURES</b>
13	Must be fully enclosed with capability within the system to connect to the building exhaust system
14	Cast Iron Base
15	2-axis (X,Z) Minimum
16	One Piece slant bed
17	Coolant Pump and Tank, Minimum 1HP / 35-Gallon tank
18	Coolant Filtration system (Magnetic Separation is <b>NOT</b> Accepted).
19	16" bed w/ 8" tool travel in both X-Z Axis Minimum
	<b>COMPUTER PROGRAM PACKAGE (Including SOFTWARE)</b>
20	FANUC or FAGOR style Controller
21	Constant Surface Speed
22	G-Code Compatible
23	Multiple Tool Offsets
24	Tool Nose Radius Compensation
25	Tool Life Management
26	Live Tool Machining Capability
27	Alarm Display
28	Machine Help Display – Self Diagnostics

29	USB port for file transfer
30	Onboard Program Storage
31	Inch/Metric Switchable
32	Minimum 2 MB of memory
33	Must have a 32-bit multiprocessor continuous-path control or better
34	Tool Pre-setting system
	<b>OTHER REQUIREMENTS</b>
35	Minimum Tool Holders to be included in purchase: Boring Bar Sleeves – x1 Set X Axis Live Tool Holder – x1 Z Axis Live Tool Holder – x1 OD Tool Holder ¾" minimum – x3pcs minimum ID Tool/Boring Bar Holder 1-1/4" minimum – x3pcs minimum  Live tool programming is required
36	Operating and Maintenance Manuals – hardcopy or electronic are acceptable
37	Minimum 5 Year Parts and Labour warranty
38	Live center tail stock with programmable position required
39	The Contractor is responsible to deliver the lathe to the shop at the place of installation as directed by the supervisor.

## 5. Service and Replacement Parts

The supplier must provide service and replacement parts within 10 business days of notification of any defect.

## 6. Delivery Address

Department of National Defence 4 Wing Cold Lake  
Cold Lake AB T9M 2C6

\*Refer to the Compliance Matrix for the complete performance specifications and instructions that must be satisfied in order for a bid to be deemed responsive.

## **Annex C - COMPLIANCE MATRIX – MINIMUM MANDATORY PERFORMANCE SPECIFICATIONS, Amendment 2**

### **Instructions to Bidders**

1. A complete list of the mandatory evaluation criteria are detailed in the Compliance Matrix below.
2. Bids which fail to meet all of the mandatory evaluation criteria will be declared non-responsive.
3. Bidders should demonstrate their understanding of the requirements contained in the bid solicitation and explain how they meet each mandatory evaluation criteria. Bidder should demonstrate their capability in a thorough, concise and clear manner.
4. The technical bid should address clearly and in sufficient depth the points that are subject to the evaluation criteria against which the bid will be evaluated. Simply repeating the statement contained in the bid solicitation or stating, without any substantiating information, that a bidder is compliant will not be sufficient.
5. Substantiating information may include, but is not limited to, specification sheets, technical brochures, photographs or illustrations. If published supporting technical documentation is not available, the Bidder should prepare a written narrative complete with a detailed explanation of how its bid demonstrates technical compliance. All substantiating information should be provided with the bid at solicitation closing date. It is the Bidders responsibility to ensure that the submitted supporting technical documentation provides detail to demonstrate that the proposed product(s) meet the requirements of the evaluation criteria.
6. If the supporting documentation referenced above has not been provided at bid closing, the Contracting Authority will notify the Bidder that they must provide supporting documentation within two (2) business days following notification. Failure to comply with the request of the Contracting Authority within that time period, will deem the bid non-responsive and the bid will be given no further consideration.
7. In order to facilitate the evaluation of the bid, Canada requests that bidders address and present the topics in the order of the evaluation criteria, and include a grid in their proposal, containing the information which demonstrates how the bidder meets each evaluation criteria. Alternatively, and to avoid any duplication, bidders may also refer to the different sections of their bids by identifying the specific paragraph and page number where the subject topic has already been addressed.
8. Bidders must address any concerns with the performance specifications in written detail to the Contracting Authority before bid closing as outlined in the Request for Proposal (RFP) document.

<b>Requirement:</b>	<b>Manufacturer(s) Offered:</b>	<b>Model Number(s) Offered:</b>
CNC Lathe (Computer Numerical Control)		

Item #	Performance Specification	Status (M) Mandatory	Performance Specification Offered: Bidder should indicate how they meet the performance specification by recording this information in this column	Cross Reference: In this column, Bidders should cross-reference where this performance specification is indicated in their supporting documents
	<b>CAPABILITIES</b>			
1	Repeatability (X/Z) $\pm 0.0002"$ or better	M		
2	8 Station Automatic Tool Turret Minimum	M		
3	Rigid Tapping	M		
4	Spindle Bore Diameter of 1.5" Minimum, Spindle nose must hold 5C collets	M		
5	4" 3-Jaw Chuck Minimum	M		
6	Built-in Work Light	M		
	Side Discharge Chip Conveyor	M		
7	Automatic Parts Catcher	M		
8	Must include 5C Collet holder and set of collets 3/32" – 1" w/ drawbar	M		
9	<b>MOTOR</b>	M		
10	Machine must run on 208/240V, Three-Phase, 60Hz power internal power only, (External transformers <b>NOT</b> accepted).	M		
11	8HP Main Spindle Motor Minimum	M		
12	Spindle Speed of 4000RPM Minimum	M		
	<b>FEATURES</b>	M		
13	Must be fully enclosed with capability within the system to connect to the building exhaust system	M		
14	Cast Iron Base	M		
15	2-axis (X,Z) Minimum	M		
16	One Piece slant bed	M		
17	Coolant Pump and Tank, Minimum 1HP / 35-Gallon tank	M		
18	Coolant Filtration system (Magnetic Separation is <b>NOT</b> Accepted).	M		
19	16" bed w/ 8" tool travel in both X-Z Axis Minimum	M		
	<b>COMPUTER PROGRAM PACKAGE (Including SOFTWARE)</b>	M		
20	FANUC or FAGOR style Controller	M		
21	Constant Surface Speed	M		
22	G-Code Compatible	M		



Solicitation No. - N° de l'invitation  
W0134-21R012/B  
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W0134-21R012

Amd. No. - N° de la modif.  
005  
File No. - N° du dossier  
STN-0-43119

Buyer ID - Id de l'acheteur  
STN207  
CCC No./N° CCC - FMS No./N° VME

23	Multiple Tool Offsets	M		
24	Tool Nose Radius Compensation	M		
25	Tool Life Management	M		
26	Live Tool Machining Capability	M		
27	Alarm Display	M		
28	Machine Help Display – Self Diagnostics	M		
29	USB port for file transfer	M		
30	Onboard Program Storage	M		
31	Inch/Metric Switchable	M		
32	Minimum 2 MB of memory			
33	Must have a 32-bit multiprocessor continuous-path control or better	M		
34	Tool Pre-setting system	M		
	OTHER REQUIREMENTS	M		
35	Minimum Tool Holders to be included in purchase: Boring Bar Sleeves – x1 Set X Axis Live Tool Holder – x1 Z Axis Live Tool Holder – x1 OD Tool Holder ¾" minimum – x3pcs minimum ID Tool/Boring Bar Holder 1-1/4" minimum – x3pcs minimum  Live tool programming is required	M		
36	Operating and Maintenance Manuals – hardcopy or electronic are acceptable	M		
37	Minimum 5 Year Parts and Labour warranty	M		
38	Live center tail stock with programmable position required	M		
39	The Contractor is responsible to deliver the lathe to the shop at the place of installation as directed by the supervisor.	M		