

Metal Blanking & Cupping Machine

SI.No	Nomenclature & Specification	A/U	Qty
(a)	(b)	(c)	(d)
	Metal Blanking & Cupping Machine with all standard and additional accessories as per specificaiton below:	No	01
1.	Quantity:		01 No
2.	a. Model:		H type Press
3.	Country of Origin and Assemble:		Group- B
4.	Country of Manufacturer:		Group- B
5.	Name of Manufacturer:		Aomate /World Press Group/Zhejiang Red Flag Machinery Co., Ltd, China/ Equivalent reputed machine manufacturer.
6.	Name of Principal:		To be mentioned
7.	Purpose: This machine is used for the blanking and cupping of 7.62×39 mm case cup from GMCS strip in coil form of thickness 3.1 mm (As per BOF sample & drawing). Complete video clip showing its working principal to be submitted with the technical offer.		
8.	Input Material: GMCS strip in coil form		
	a) Material Thickness:		3.1 mm
	b) Width:		140-0.5 mm
	c) Reel Inner Diameter:		508 mm
	d) Reel Outer Diameter:		(1000~1100) mm
	e) Weight:		Approximately (500~800) KG
9.	Output Material: Case Cup: (As per BOF sample & drawing)		
	a) Length:		11.7 mm
	b) Outer Dia:		15.02 ~ 15.15 mm
	c) Wall Thickness Difference:		≤0.10 mm (at portion 7 mm from the head)
10.	Specification:		
	a. Cup to be used for Calibe		7.62x39 mm (Ball T-56)
	b. Stroke Length		80 mm
	c. No of Stroke/min		80 (Minimum)
	d. Production Rate (Pcs/min)		560 (Minimum)
	e Capacity		80 Ton (Minimum)
	f. Power Supply		380VAC + 10% voltage, 50 Hz
	g. Phase		3 (Three) five- wire system
	h. Lubricating & Cooling system: Along with integral lubrication system, the machine must have lubrication and cooling system of tools, die, punch and the tools. The system to be centralized automatically controlled.		
	j. Feeding and Extraction System: Machine should have automatic strip feeding and extracting system: 2 in 1 straighter and de-coiler.		
	(a) Two-in-One Machine Parameters		
	(i) Power:		To be mentioned
	(ii) Voltage		To be mentioned
	(iii) Material Thickness		0.35-3.2 mm

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	(iv) Coil Inner Diameter (I.D.)			φ460-φ530 mm	
	(v) Leveling Speed			To be mentioned	
	(vi) Maximum Material Weight			1000 Kg	
	(vii) Machine Weight			To be mentioned	
	Heavy duty rack.				
	(b) Receiving Rack Parameters				
	(i) Power			To be mentioned	
	(ii) Voltage			To be mentioned	
	(iii) Transmission			To be mentioned	
	(iv) Material Thickness			0-2.0 mm	
	(v) Coil Inner Diameter (I.D.)			φ450-φ520 mm	
	(vi) Maximum Material Weight			500 Kg	
	(vii) Machine Weight			To be mentioned	
	(c) NC feeder machine/ Servo machine			To be mentioned	
	k. Control System requirements:				
	(i) PLC control system will have to be incorporated.				
	(ii) Should be able to display operation and fault information.				
	(iii) Should be able to display product count.				
	(iv) Should have formidable data storage capacity.				
	(v) Touch screen with English character display, simple and easy to understand.				
	l. Overall dimension (L×W×H) mm			To be mentioned	
	m. Net Weight (Kg)			To be mentioned	
	n. Year of Manufacture to be embossed in the main body:			To be complied	
	p. After blanking and cupping operation the percentage of webbing/perforated strip should not more than 24% of strip.				
11.	Optional equipment (if any) required to complete the process			To be mentioned in detail	
12.	Latest Feature/ Technology (If available)			To be mentioned	
13.	Main Machine:				
	a. Basic machine with all standard accessories and attachment are to be provided (With feeding & receiving device).				
	b. List of Tools, Die, and Punch that is fitted with the machine to be provides.				
	c. Automatic Voltage Regulator (AVR) if required to be provided with the machine and synchronized with the supplied machine.				
14.	Operation Description: The blanking machine is composed of a 2-in-1 uncoiler & straighter, a servo feeding machine, a closed double slider press, precision stamping dies, a waste collection system, a cooling and lubrication system, a control system and other equipment and services. The blanking machine is a cup blanking automatic production line. The product processing realizes the functional of automatic feeding of raw materials, automatic processing and automatic collection of waste materials.				
15.	Spares, Accessories and Consumable Items:				
	(a) Required spares, accessories and consumables (Tools, Die, Punch, Gauges, etc.) Lubricating oil, Coolant, Filter, etc. for 5.00 million productions for each machine will be supplied with the machine mentioning price, part number, brand, material & drawing.				
	(b) 2 set gauges for each machine will be provided with the machine mentioning price, part No, brand, material & drawing.				
	(c) Configuration of the H-type blanking and Cupping machine equipment:				
	No	Name	Requirements	Quantity	
	(1)	Loading and unloading equipment	Random	2 sets	
	(2)	Equipment lubrication system	Install on the discharging	2 sets	
	(3)	Saponification liquid cooling system	Random	2 sets	
	(4)	Installation shock absorption device	Connect to the blanking	2 sets	
	(5)	Mold lighting lamp	Install on the discharging	2 sets	
16.	Port of Shipment:			Group 'B' (As per country of origin)	
17.	Country of Origin of all major components: Group- B Countries			To be mentioned	
	a. Main Motor, b) Major Mechanical, Electrical & Electronics Part.				
	c. Any other major component.				

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18	<p>Stage Inspection and Pre-Shipment Inspection at Supplier's Site:</p> <p>(1) Pre-Shipment Inspection (PSI):</p> <p>(a) PSI will be carried out under BOF arrangement by 3 (Three) persons for 5 (Five) working days (excluding journey period). All cost of the PSI to be borne by BOF. In case of PSI, manufacturer / principal will provide all kinds of testing facilities and allied materials during inspection free of cost. Following to be provided by the supplier to the PSI team :</p> <p>(i). All the necessary facilities, consumable and non-consumable items, tools, gauges, instruments, required components and any other items required for operational test/inspection team are to be arranged by the supplier without extra cost.</p> <p>(ii) Interpreter detailed by supplier for the PSI team should be competent enough to interpret the technical terms (as applicable).</p> <p>(iii) Supplier to provide necessary secretarial support (typing, printing facilities etc.) to the PSI team.</p> <p>(iv) All internal movement arrangement and cost related to the inspection will be borne by the supplier.</p> <p>(b) Supplier must submit details plan of PSI (Modus Operandi).</p>																															
19.	<p>Installation & Post Installation Requirement at BOF:</p> <p>(1) Installation Requirement at BOF:</p> <p>a. It is the responsibility of supplier to fully integrate and commission the machine at BOF's identified site/ room. Machine installation and commissioning is to be provided by the technical expert of machine manufacturer from same country or at least same group of countries at BOF site.</p> <p>b. BOF shall only provide utility service up to near proximity. All other related equipment, connections and fittings or any related things required for successful installation and running of the machine will be provided by the supplier.</p> <p>c. Supplier shall bring all necessary calibration standards and calibration equipment for ensuring the machines accuracy with valid traceability certificates at BOF site.</p> <p>d. Amount of installation, commissioning, trial run, trial production & training must be mentioned separately by the manufacturer. After installation and commissioning of the machine, trial run, trial production followed by operational and maintenance training of BOF personals by the technical expert of machine manufacturer from same country or at least from same group of countries at BOF site to be provided. The training should cover complete operation, application, software usage (if required) in all aspects of measurement and data analysis, part programming for required samples, calibration, basic & preventive maintenance and troubleshooting etc. Supplier must submit day wise local training plan along with the offer. Following information must be given as below:</p> <table border="1" data-bbox="430 1706 1564 2136"> <thead> <tr> <th>Ser</th> <th>Items</th> <th>Responsible (Supplier/BOF)</th> <th>Cost</th> <th>Duration</th> </tr> <tr> <th>(a)</th> <th>(b)</th> <th>(c)</th> <th>(d)</th> <th>(e)</th> </tr> </thead> <tbody> <tr> <td>1.</td> <td>Site Preparation</td> <td>BOF and Supplier</td> <td rowspan="5">To be mentioned</td> <td rowspan="5">To be mentioned</td> </tr> <tr> <td>2.</td> <td>Installation & Commissioning</td> <td>Supplier</td> </tr> <tr> <td>3.</td> <td>Trial Run</td> <td>Supplier</td> </tr> <tr> <td>4.</td> <td>Trial Production</td> <td>Supplier</td> </tr> <tr> <td rowspan="2">5.</td> <td>Functional Training</td> <td>To be mentioned</td> </tr> <tr> <td>Repair & Maintenance Training</td> <td>To be mentioned</td> </tr> </tbody> </table> <p>(2) Post Installation Requirement at BOF:</p> <p>a. Machine installation and commissioning is to be provided by the Supplier at BOF site (within 60 days) after receiving machine by BOF.</p> <p>b. After installation and commissioning of the machine trial production and trial run (minimum 10 working days) excluding installation and commissioning period) by the Supplier's Technical team at BOF site to be provided.</p> <p>(3) Software and License:</p> <p>If any software update, license key is required for the machine, supplier must provide this for machine's lifetime free of cost. Remote or system locking of the machine using software and password is not allowed. If done so, BOF will have the authority to reject the machine. A PLC backup along with operating software must be supplied with the machines. PLC must be keyword/password free.</p>	Ser	Items	Responsible (Supplier/BOF)	Cost	Duration	(a)	(b)	(c)	(d)	(e)	1.	Site Preparation	BOF and Supplier	To be mentioned	To be mentioned	2.	Installation & Commissioning	Supplier	3.	Trial Run	Supplier	4.	Trial Production	Supplier	5.	Functional Training	To be mentioned	Repair & Maintenance Training	To be mentioned		
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20.	After Sales Support:		
	a. Supplier should guarantee the availability of spares, software/ firmware updates and additional add-on modules for at-least 10 (Ten) years from date of expiry of warranty.		
	b. Customer support facility shall be made available for at least 5 (Five) years after expiry of the guarantee period.		
	c. Online help support for system Queries/ Application support.		
	d. Service facilities and personnel availability.		
	e. Service personnel to attend any fault within 3 (Three) days after receipt of the information, whenever called for.		
21.	Warranty:		
	a. The machine shall have warranty for a minimum period of 12 months or more after commissioning for defect free operation and specified accuracies at our site.		
	b. Any defect observed during the warranty period shall be replaced/repared free of cost with minimum down time (30 days). All the software updates during the warranty period shall be supplied, installed and trained to our personnel on real time basis at free of cost.		
22.	Condition:		
22.1	Adaptation Physical Visit: After signing of the contract within 60 days the OEM representative will visit BOF to discuss installation, commissioning and other technical details of the machine as per the contract. No change in the financial offer and proposal for changing OEM will be accepted at this stage. It is preferable that visit is conducted by the OEM representative who all will install the machine.		
22.2	Turn Key Project: The contract will be considered as a Turn Key Project. The OEM has to ensure installation, trial run, trial production, training and sustainable production.		
22.3	50% of the payment will be made after shipment clearance of the machine via PSI & another 50% will paid after as follows (20% will be paid after complete installation, 10% after complete training and 20% after trail run production).		
22.4	The machine must be brand new, free from any defect or damage.		
22.5	02xMachine drawings and designs must be supplied during the Adaptation Physical Visit.		
22.6	02 x Operators manual/ programming manual in English language must be supplied with the machine.		
22.7	02 x Maintenance/ repair manual in English must be supplied with machine.		
22.8	The manufacturer must provide verified complete drawing (02 x hard copies and soft copies in dwg/step/stl file) of tools, dies, punches, gauges and special parts of the machine.		
22.9	Supplier should submit original leaflet/ Brochure with the offer.		
22.10	Lowest bidder will be selected basing on price against clause 13 & 15.		

Terms & Conditions

1. A principal/manufacture can submit **only one offer through one local agent** for any individual item. Offers through multiple local agents by same principle/manufacture will be **treated as rejected**.
2. To ensure unhindered LC handling the principal must provide a certificate to confirm that their LC operating bank has RMA (Relationship Management Agreement) with the local scheduled Banks of Bangladesh.
3. Supplier must **clearly mention** (in the technical offer) that as principal/manufacture they poses necessary **export permit** from the concern ministry or Chamber of Commerce of their country. They must also submit a certificate in this regards as per the attached specimen format at **Annex F**.
4. Payment Terms and Performance Guarantee (PG) Submission (for Foreign Currency Only) :
 - i. 60% LC value will be paid after shipment, another 20% LC Value will be paid on successful installation of the machine including operating software and remaining 20% LC value will be paid after final acceptance of the item by BOF inspecting authority (if PSI carried out).
 - ii. 50% LC value will be paid after shipment, another 30% LC Value will be paid on successful installation of the machine including operating software and remaining 20% LC value will be paid after final acceptance of the item by BOF inspecting authority (if PSI not carried out).
 - iii. Before signing the contract, Performance Guarantee (PG) @ 10% of total LC value is to be submitted by the Principal in favour of Commandant, Bangladesh Ordnance Factories, Gazipur Cantonment, Gazipur through any scheduled Bank located in Bangladesh (As per the format at Annex E).
 - iv. A separate certificate should be provided by the principal originally signed (Computerized or digitally edited signature will not be accepted) stating that they are aware of the requirement of the PG and if the contract is awarded they will be bound to provide the PG as per the format at Annex D, otherwise administrative action will be taken against the principal and local agent.
5. The stores should be supplied to BOF at supplier's cost.
6. If the supplier fails to deliver the stores as per the specification and terms of the contract within the stipulated period, the followings will be applicable:
 - a. Cancellation of the contract and/or,
 - b. Decision at the discretion of BOF.
7. BOF is the authority in all matters pertaining to Inspection. Any verdict by the inspection team regarding rejection, acceptance, and /or deviation of machine involving price reduction will be treated as final and will not be subject to arbitration.
8. The Supplier must submit the following attested documents with the schedule :
 - a. Trade License.
 - b. Tin Certificate.
 - c. Up to date VAT Registration certificate.