TECHNICAL SUBMITTAL

Background. Pennsylvania Correctional Industries, a Bureau of the Pennsylvania Department of Corrections is establishing a Heavy-Duty Vehicle Refurbishing Plant within the confines of SCI-Forest located in Marienville, Pennsylvania.

I-1. Requirements.

A. Specific Requirements. Offerors shall submit the technical specifications/detailed descriptions of the supplies stated below that are proposed in response to this RFP. Documentation related to specific requirements must be provided with the response. The Selected Offeror must be able to supply all items as requested.

a. Supplies:

Item 1: One (1) New 132 TON Hydraulic Ironworker with Dual Operator Stations

Features:
- Dual hydraulic cylinders for dual operators with two moveable foot pedals.
- Five workstations: punch, plate shear, angle shear, bar shear, notcher and press brake attachment.
- Hydraulic material hold down at shear stations
- Oversize tables with quick adjust material stops
- Electronic stroke control
- Swing away material stripper
- Quick release coupler for each tool changeover
- Electric back gauge
- Material waste bins
- Safety interlock switches
- Halogen workstation light
- 15HP, 220V 3-phase operation

Punch:
- Punch Tonnage- 132
- Punching Thickness- 1.125” x 1.062”
- Punching Diameter- 2” x .625”
- Throat Depth- 16”
- Stroke Length- 0” to 3”
- Cycles/Minute- 30@15mm
- Working Height up to Die- 41.3”

Flat Bar Shear:
- Flat Bar Shearing- 18.1” x .75”
- Blade Length- 18.3”
- Angle Flange Trim- 4”
- Working Height- 30.3”

Angle Shear:
- Capacity 90 Deg.- 6” x 6” x .6”
- Working Height- 39”

Bar Shear:
- Round- 1.75”
- Square- 1.75” x 1.75”

Notching:

- Rect. Notcher (W x D x T) – 2” x 3.5” x .5”
- Working Height- 41.3”

Other Information:
- Motor- 15HP
- Weight- 9,460 lbs.
- L x W x H- 85.5” x 44” x 80.7”
- Oil Capacity- 64 Gal.

Please provide pricing in the Cost Submittal, not this Technical Response, for each of the following optional features:
- Extended warranty
- On-site training
- Off-site training

Make/Model Number: BAILEIGH/SW-132 or approved equal.

Item 2: One (1) New 13’ X 3/4” 40 Ton Hydraulic Shear

Standard Features:
- Steel interlocked construction
- Clevis mounted swivel bearings to allow for unrestricted movement of cylinders
- Twin precision lead screws mounted in a heavy-duty steel frame.
- Must meet construction requirements of ANSI B11.1.
- Safeguards covering all moving parts and areas of potential hazard.
- Industrial PC based Windows operating system, 22” flat panel color display with touchscreen operator interface.
- Touchscreen Shear Control (TSC) Features
- Combined control for shear and gage functions
- Pedestal mounted
- Industrial PC based
- Windows operating system
- 22” flat panel color display
- Touchscreen operator interface
- Cycle selector-Off/Jog/Single Stroke/Continuous
- Single Step/Auto Sequence
- Maximum cuts per step 99
- Maximum steps per program 99
- Stroke counter
- Batch counter
- Setup notes
- Spreadsheet tab
- Main drive Start/Stop
- Solid state drive
- USB convenience outlet
- Ethernet convenience outlet
- Inch or Metric unit display
- English/Spanish language display
- Material library
- Programmable backgage
- Programmable rake
- Programmable cut length
- Programmable knife clearance (option 250)

Machine Features

- 48” range power backgage
- Steel frame construction
- 60 IPM backgage speed
- Manual knife clearance (250)
- Dovetail slots in shear table
- Hand slots in shear table
- Automatic lubrication to the backgage screws and ram guides
- Decimal table scales
- Manifold hydraulic system with cartridge valves
- Hardened piston rods
- Hydraulic holddowns
- Dual Holddowns on left end
- Dual Holddowns on both ends (375-750)
- Automatic pullback of backgage angle
- Guarded footswitch
- Precision knife straightener
- Knife change fixture (mounts to backgage)
- Scrap chute
- Side gage
- Cushion Clamp Holddown (ON/OFF)
- One set of knives (4-edge)
- ANSI B11.4 and OHSA construction compliance
- Holddown and knife guards
- Power swing-up backgage (375-750)
- Ball transfers in shear table, spring loaded (500-750)
- One (1) Operation, Maintenance and Safety manual, (Red) USB flash drive
- One (1) Operation and Safety Manual, (Blue) Hard copy
- UL 508A Listed Industrial Control Panel
- TEFC type motor
- Paint – Laser Gray with red cylinder covers
- LED work light – front
- FMA Company Membership (1 year)

Specifications:

- Mild steel capacity:..... Max-.750”
  ..... Min- 20ga
- Cutting Length:..... 146.5”
- Rake in./ft:..... .188-.75”/ft
- Force tons:..... 37.3
- Hold downs: 15
- Distance under Hold-down:..... 1- ½”
- Gage Range Front:..... 63-1/2”
- Gage Range Back:..... 48”
- Strokes:..... Max 25, Min 5
- Knife Size:..... 1-1/8 x 5 x 48
- Knife Type’ ..... D
- Main Motor: ..... 40 HP, 460/3/60
- Base Weight: ..... Approx.39,600 lbs.
- Dimensions (L x W x H): .....

Please provide pricing in the Cost Submittal, not this Technical Response, for each of the following Squaring Arm and Frontgages optional features:

- 60" hardened insert
- Frontgage support arm, 35" overall length (Includes one disappearing stop for manual setting of frontgage positions)
- Additional Stops for more versatile set-ups:
- Swing stops
- Solid stops
- Disappearing stops for use in dovetail slots in table and frontgage support arms
- Additional pair of knives: Type D
- Additional 3-position footswitch
- Light beam shearing gage to provide a shadow at pass line of knives in order to shear to a scribed line
- CI Firesafe ECO Fluid: In place of standard hydraulic fluid (750HS 12')
- Extended warranty
- On-site training
- Off-site training

Make/Model Number: Cinncinati/750HS x 12 or approved equal.

Item 3: One (1) New 350 Ton x 12' Hydraulic Press brake

Standard Features:

- HMI Control Features
- Industrial PC-based with Windows operating system
- Pendant-mounted swing-arm (from Bed)
- 22" TFT LCD flat panel color display
- Touchscreen operator interface
- Keyboard
- Trackball
- Solid State Hard Drive
- USB Convenience Outlet (1)
- Ethernet convenience outlet
- Inch or Metric unit display
- English / Spanish language display
- Operator station (ON / OFF, optional LEFT / RIGHT)
- Operator controls (ON / OFF)
- Footswitch (ON / OFF, optional LEFT / RIGHT)
- Pre-loaded Wilson and Wila tool files
- Quick Bend mode
- CAD functions
- Manual Bend Sequencing
- Print setup notes and program
- Convert utility for programs
- Batch program operation
- Spreadsheet display of program steps with editing capability
- Management and Diagnostic Features
- Machine strokes
- Parts counter
- Batch counter
- Power on time
- Total cycle time
- Main drive on time
- Parts per minute
- Cycle time per part
- Maintenance messages

- Diagnostic Display Information
- Oil Level and Temperature Sensing
- Backup and Restore Wizard
- Web enabled machine monitoring
- Email notification of machine faults
- Operator adjustable ram control inputs:
- Multiple Step and Repeat
- Forming modes (Angle, Tonnage, Position, Absolute Position)
- Angle Correction Dialog
- Ram Opening
- Guard Mute Position
- Forming and return speeds
- Tool selection for each step
- Speed change position (up and down)
- Ram tilt, total end-to-end 1”
- Dwell time at bottom of stroke (limited)
- Up and down stroke stops (ON / OFF)
- Material Clamp: Pause / Stop (ON / OFF)
- Tonnage reversal auto calculation
- Operator adjustable gage control inputs:
- Flange dimension
- Gage allowance (automatic calculation or manual input)
- Retract distance
- Gage Pause time
- Incremental gage move
- Advanced Flange Correction (with 5 axis backgage)
- Z-axis position auto calculation (with 5 axis backgage)
- Operator Controls
- One (1) footswitch for “STROKE” mode of operation
- One (1) two-hand button operator station for “SETUP” or “STROKE” mode of operation, mounted on HMI control
- Hand/Foot Sequence mode of operation
- Ram Stroke Mode Selector (OFF, SETUP, STROKE)
- Ram Cycle Mode Selector (SINGLE STEP and AUTO SEQUENCE)
- Ram Up button
- Emergency Stop button
- Red and green ram directional lights

Machine Features

- Non-metallic liners for ram guiding surfaces
- Dual English / Metric Rule on ram nose
- Microcrown
- Interlocked frame construction
- Clevis-mounted hydraulic cylinders
- Hardened piston rods
- CINCINNATI Quick Clamp Ram Nose
- Full length die slot in bed top (350 only)
- Full length dovetail slot in front and back of bed
- Crosswise “C” slots in bed top on 24” centers (Auto Crown® may affect location)
- Hydraulic manifold blocks to reduce piping and connections
- Hydraulic oil and oil filters
- Replacement oil filter
- Paint color - Laser Gray

- One Operation, Safety and Maintenance Manual (Red) (USB flash drive)
- One Operation and Safety Manual (Blue) (hard copy)
- UL 508A Listed Industrial Control Panel

Specifications:

- Full Capacity tonnage ..... 350 Tons
- Overall Length ..... 14’
- Closed Height ..... 8”
- Standard Stroke ..... 8”
- Open Height ..... 18”
- Throat Clearance from Die
  - Centerline ..... 10”
- Overall Height 134
- Ram Speeds
  - Approach 105
  - Forming ..... 1 to 20
  - Return ..... 1 to 95
- Ram Repeat 0.0004
- Distance Between Housings ..... 12’6-1/2”
- Total overall Die Surface ..... 14’
- Thickness and Length ..... ¾” Plate x 8’6”
- Pit Required ..... Yes
- Motor Horsepower 15HP, 460/3/60
- Net Weight ..... 44,000 lbs.
- Length ..... 180”
- Width ..... 87”
- Height ..... 130”

Please provide pricing in the Cost Submittal, not this Technical Response, for each of the following optional features:

- Back Gauge Options
  - 40” X-axis range (in place of standard 24” range)
  - 12” Programmable R-axis (in place of manual)
  - Dies C, D and E with 6-Upper and 3-lower
  - Heavy Gauge Knife Die
- Operator Control Options
  - One Palmbutton Operator Station (mounted on HMI Control) and one Footswitch are standard.
  - Additional Pedestal mounted operator station
  - Additional footswitch
- Extended warranty
- On-site training
- Off-site training

Make/Model Number: Cincinnati/350PF+12 or approved equal.

Item 4: One (1) new Four-Roll Hydraulic Powered Plate Rolling Machine

Standard Features:

- Induction Hardened Rolls
- Electronic Parallelism
- Digital Display
- Cone Bending Device
- Two Speed Control

- All rolls are made of special steel.
- Machine body is steel construction (ST52).
- All rollers mounted in bearing.
- Separate control panel.
- Drop-end controlled from control panel in order to release easily bended metal sheet.
- Movement and parallelism adjustment of the rollers controlled from the control panel.
- Ergonomic designed control panel which allows to control all the functions of the machine is independent from the machine.
- Central rolls are driven with hydraulic motor and reducer.
- Electrical and hydraulic protection against overloads.
- CE approved

Specifications:

- Working Length ..... 16'
- Maximum Thickness Yield Point ..... 36,000 PSI Pre-Bending-5/16", Bending-3/8"
- Number of Rolls 4
- Motor HP 15HP
- Rolling Speed up to ..... 16' per minute
- Top Roll Diameter ..... 14.2"
- Pinch Roll Diameter ..... 13"
- Side Roll Diameter ..... 10"
- Machine Length ..... 22'
- Machine Height ..... 66"
- Machine Width ..... 74"
- Machine Weight ..... 49,600lbs.

Please provide pricing in the Cost Submittal, not this Technical Response, for each of the following optional features:

- Extended warranty
- On-site training
- Off-site training

Make/Model Number: AKYAPAK9-/AHS-5008 or approved equal.

Offeror Response and agreement to provide the items in this Section.

B. The equipment shall conform to the requested specifications and shall be new and of good quality. All equipment shall be provided complete including freight to the Marienville, Pennsylvania Plant site located at 286 Woodland Drive, Marienville, PA 16239. The selected Offeror shall provide all necessary equipment, rigging or other services as required to off load, spot and secure the equipment to the concrete floor per the Architectural Drawings. Final hook up of equipment to utilities to be handled by others.

Offeror Response

C. Offerors must return with their proposal a detailed equipment layout sketch and the data for utility connections (water, compressed air, exhaust air, make-up air, electric, gas etc.). The construction schedule is calling for equipment delivery starting November 1, 2019. Offerors must include in the Cost Submittal, not this Technical Response, the cost for weekly and monthly storage of the equipment in case of construction delays.

Offeror Response

D. The selected Offeror shall provide equipment startup, testing and training for up to 15 PCI staff (40 hours total onsite training). Please describe how you will accomplish this requirement.

Offeror Response

E. General Requirements

a. Cost/Prices. The proposal submitted by the selected Offeror will be incorporated into any resulting Contract and the Offeror will be required to provide the awarded item(s) at the prices quoted in its proposal.

b. Approved Equal. Whenever an item is defined in this RFP by trade name and catalogue number of a manufacturer or vendor, the term "or approved equal," if not inserted therewith shall be implied. Any reference to a particular manufacturer's product either by trade name or by limited description is solely for the purpose of more clearly indicating the minimum standard of quality desired, except where a "no substitute" is requested. When a "no substitute" is requested, the Issuing Office will consider only proposals for the referenced product only. The term "approved equal" is defined as meaning any other make which, in the sole opinion of the Issuing Office, is of such character, quality, and performance equivalence as to meet the standard of quality of products specified for which is to be used equally as well as specified. An Offeror quoting on a product other than the referenced product shall: a) furnish complete identification in its proposal of the product it is offering by trade name, brand and/or model number; b) furnish descriptive literature and data with respect to the substitute product it proposed to furnish; and c) indicate any known specification deviations from the referenced product.

c. New Equipment. Unless specified in this RFP, all products offered by the Offeror must be new or remanufactured. A "new" product is one that will be used first by the Commonwealth after it is manufactured or produced. A "remanufactured" product is one which: 1) has been rebuilt, using new or used parts, to a condition which meets the original manufacturer's most recent specifications for the item; 2) does not, in the opinion of the Issuing Office, differ in appearance from a new item; and 3) has the same warranty as a new item. Unless otherwise specified in this RFP, used or reconditioned products are not acceptable. This clause shall be construed to prohibit Offerors from offering products with recycled content, provided the product is new or remanufactured.

d. Post-Submission Descriptive Literature. The Commonwealth may, during its evaluation of the proposed product(s), require the Offeror to submit cuts, illustrations, drawings, prints, test data sheets, specification sheets and brochures which detail construction features, design components, materials used, applicable dimensions and any other pertinent information which the Issuing Office may require in order to evaluate the product(s) offered. The required information must be submitted within two (2) business days after notification from the Issuing Office. Failure to submit the required information prior to the expiration of the second business day after notification shall result in the rejection of the proposal as non-responsive.

e. The purchaser may reject any equipment that is deemed defective or non-conforming in any material respect. The supplier shall be responsible at its own expense for the removal or replacement of any rejected equipment. It is expected that within the 30-calendar day acceptance testing period, the supplier will make all adjustments necessary. The supplier shall conduct all quality control testing necessary to ensure quality standards and shall further ensure the equipment produced or manufactured by it complies with the requirements of this agreement. Where the purchaser issues a disapproval notice in writing to the supplier, the supplier shall have an additional 15 business days to cure the deficiencies and achieve acceptance. In the event that acceptance is not achieved within the specified period, the purchaser may at its option: request and have replaced by the supplier at no additional cost to the purchaser the equipment or components of the equipment that have been the source of the failure. At which case the supplier shall have a reasonable period of time to replace the equipment or the purchaser can terminate the agreement and request prompt removal of the equipment from the purchasers premises at no cost to the purchaser and the supplier shall provide a full refund of the money paid to date to the purchaser within a reasonable period of time following removal. The supplier agrees that the warranty for equipment shall come in to effect from the date of equipment acceptance or the date of acceptable use if there is no acceptance testing period.

Offeror Agreement to Above Requirements