

Scope of Work

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. This scope of work is to cover equipment needed in the Metal Fabrication area of the Plant that will be utilized for the fabrication of replacement parts for snowplows.

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 Pennsylvania Plant site located at 286 Woodland Drive, Marienville, PA, 16239. The awarded vendor/s are responsible for and shall provide all necessary equipment, rigging or other services as required to off load and spot the equipment per the Architectural Drawings. Final hook up of equipment to utilities and equipment anchoring to be handled by others. Awarded vendor is responsible for machine startup, testing and demonstration. Customer will be responsible to provide the hydraulic fluid for the equipment per the manufacturers specifications.

Bidders must return with their bid a detailed equipment layout sketch and the data for utility connections (water, compressed air, exhaust air, make-up air, electric, gas etc.). Bidders must include with their bid the lead time upon receipt of a Purchase Order and cost for weekly and monthly storage of the equipment in case of construction delays. The deadline for delivery of the equipment to the Marienville location is 1/15/2020.

The plant has two loading docks, one with a ramp and the garage doors are 12'W x 14'H. Also available are two additional garage doors at ground level which are 16'Wx 14'H. The overhead doors being 14' are the lowest obstruction in getting equipment to its destination. Bidders must include pre-installation information, foundation plans for all equipment to include specifications for the anchoring hardware. The Iron Worker, Shear and Plate Roller must be flush mount on the floor.

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.

This bid shall be awarded by Lots (4 Lots total):

- Lot 1 Ironworker
- Lot 2 Shear
- Lot 3 Pressbreak
- Lot 4 Plate Roller

Pricing should be bid as FOB destination to include rigging and spotting the equipment per the Architectural drawings. Award will be made to the supplier offering the lowest price per lot.

Lot 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
- Worktable to accommodate and support handling of large sheets of 7GA steel
- 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.

Proposal shall include the manufacturers standard warranty periods and costs for extended warranties. Proposal shall include costs for on-site training at our Marienville location and any available off-site training.

Vendors shall include their standard die package.

Motor shall not exceed 15HP, 220V 3phase.

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

Lot 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 OSHA 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- 1/2"
- 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):

Vendors shall include their standard die package.

Please provide pricing on cost submittal sheet for Squaring Arm and Frontgages Options

- 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 (*each*)
- Solid stops (*each*)
- Disappearing stops for use in dovetail slots in table and frontgauge support arms (*each*)
- Additional pair of knives: Type D
- Additional 3-position footswitch
- Light beam shearing gauge 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')

Proposal shall include the manufacturers standard warranty periods and costs for extended warranties. Proposal shall include costs for on-site training at our Marienville location and any available off-site training.

Motor shall not exceed 40 HP, 460V/3/60Hz.

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

Lot 3- One (1) New 350 Ton x 12' Hydraulic Pressbrake

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 3/4" Plate x 8'6"
- Pit Required..... Yes
- Motor Horsepower 15HP, 460/3/60
- Net Weight..... 44,000 lbs.
- Length 180"
- Width 87"
- Height..... 130"

Standard Equipment-

- 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

Include (3)- three additional 36" arms and (6)- six moveable stops for these arms.

Vendors should include their standard die package.

Please provide pricing on cost submittal sheet 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*)

Operator Control Options

- One Palmbutton Operator Station (mounted on HMI Control) and one Footswitch
- are standard.
- Additional Pedestal mounted operator station
- Additional footswitch

Proposal shall include the manufacturers standard warranty periods and costs for extended warranties. Proposal shall include costs for on-site training at our Marienville location and any available off-site training.

Motor shall not exceed 30HP, 460V/3/60Hz.

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

Lot 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 for available optional features:

Proposal shall include the manufacturers standard warranty periods and costs for extended warranties. Proposal shall include costs for on-site training at our Marienville location and any available off-site training.

Motor shall not exceed 15HP, 460V/3/60Hz.

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