NAL/PUR/APMF/398/21-Z April 5, 2022

PROCEEDINGS OF THE PRE-BID CONFERENCE HELD 5th April 2022 THROUGH WEBEX, TOWARDS PROCUREMENT OF CNC WIRE EDM MACHINE.

The Pre-bid Conference was held and the following T&PC members attended the meeting: -

Sl. No.	Name & Designation		Role
1	Dr. Ramesh Kumar. M	Chief Scientist, ACD	Chairman
2	Dr. Soumendu Jana	Chief Scientist/PR	Member
3	Dr. J. N. Balaraju	Sr. Principal Scientist / SED	Member
4	Mr. Sunil Prasad	Sr. Scientist/~~ACD~~ ALD	Member
5	Mr. R. Suresh	Principal Scientist	Member - Convener (TSC)

The list of Prospective bidders who attended the Pre-bid Conference is as per **Annexure-I.**

At the outset, the Chairman welcomed all the Members and the representatives of the Bidders and briefed in general the scope of the Project. The Indenting Officer to read out the clarification sought by the bidders and the replied there to as detailed in **Annexure-II (Part A: Technical Clarification and Part B: Commercial Clarification, if any).**

The representatives present were satisfied with the replies given and it was informed that the corrections / additions / clarifications given, as discussed during the Pre-Bid Conference would be hosted on the website of CSIR-NAL and all prospective bidders are required to take cognizance of the proceedings of the Pre-Bid Conference before formulating and submitting their bids as stipulated in bidding Documents.

The meeting ended with a vote of thanks to the Chair.

Dr. J. N. Bala Raju 05/04/2022
Member

Dr. Soumendu Jana 08/04/22
Member

Sunil Prasad 08/04/2022
Member

R. Suresh
Member – Convener (TSC)

Dr. M. Ramesh Kumar 12/04/22
Chairman-T&PC

NATIONAL AEROSPACE LABORATORIES
BENGALURU - 560 017

TENDER NO.: NAL/PUR/APMF/398/21-Z

ANNEXURE - I

DATE & TIME : 05-Apr-2022 @ 11.00 AM

VENUE: THROUGH WEBEX, CSIR-NAL, HALAirport Road, Kodihalli, Bengaluru-560017

Pre-Bid Conference for Procurement of CNC Wire EDM Machine.

Sr. No.	Name of the Firm	Name & Designation of Representative	E-tender Registration (Yes/No)	Email ID	Signature
1	Electronica India Limited	Soundhar Raj A Sr. Branch Manager		sales.bangalore@electronicagroup.com	

CSIR-NATIONAL AEROSPACE LABORATORIES
BENGALURU

TECHNICAL QUERIES & CLARIFICATION

Tender No. : NAL/PUR/APMF/398/21-Z
Item Description : Procurement of CNC Wire EDM Machine.

Sr. No.	Query / Clarification Sought	Clarification/Amendment
①	Sl. No. 8.1 in 4.2 Chapter regarding Built-in AC	Explained to the vendor. no Amendment required.
②	Sl. No. 21 in Chapter 4.2. 21.1 to 21.27 to be included in the quote?	Yes to be included in the quote no amendment required.

I/O Ms R. (Suresh R)
Signature of IO & PL

PL
(MOHAN NAIK. C)

ANNEXURE -1

DRAWING FOR PROVE OUT OF COMPONENTS AT VENDOR'S SITE AND AT CSIR-NAL

Test Specimen

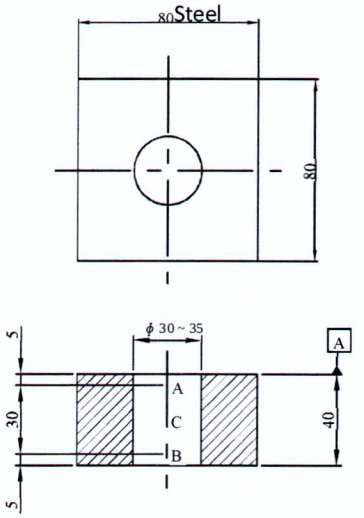
Checking of roundness and axial perpendicularity of machined hole under finishing conditions: a) roundness;

b) perpendicularity between hole axis and reference surface of workpiece; c) consistency of diameters.

Other form of machining is also possible when agreed between the user and manufacturer/supplier.

This machining test and circular test (C1) may be alternative.

Diagram Dimensions are in millimetres



Workpiece

Material: Stainless Steel (17-4ph)
Size: 80 × 80
Thickness: 40 Wire electrode
Brass
Diameter of wire: Φ 0,2 ~ Φ 0,3

Finished surface condition
Finishing condition such that the roughness of finished surface is *Ra* 2 µm or less.

Machining condition
Feed speed shall be determined by the manufacturer/supplier considering the finished surface condition.

Tolerance Measured Deviations	
a) 0,02	a)
b) 0,01	b)
c) 0,03	c)

Measuring instruments

Coordinate measuring machine or roundness measuring machine

Observations and references to ISO 230-1:2012

Set the reference surface of the workpiece parallel to the XY plane.

a) Measure the roundness at respective points A, B and C. Take the maximum value as the measured value.

b) Measure the centre of the least-squares circle at respective points A and B.

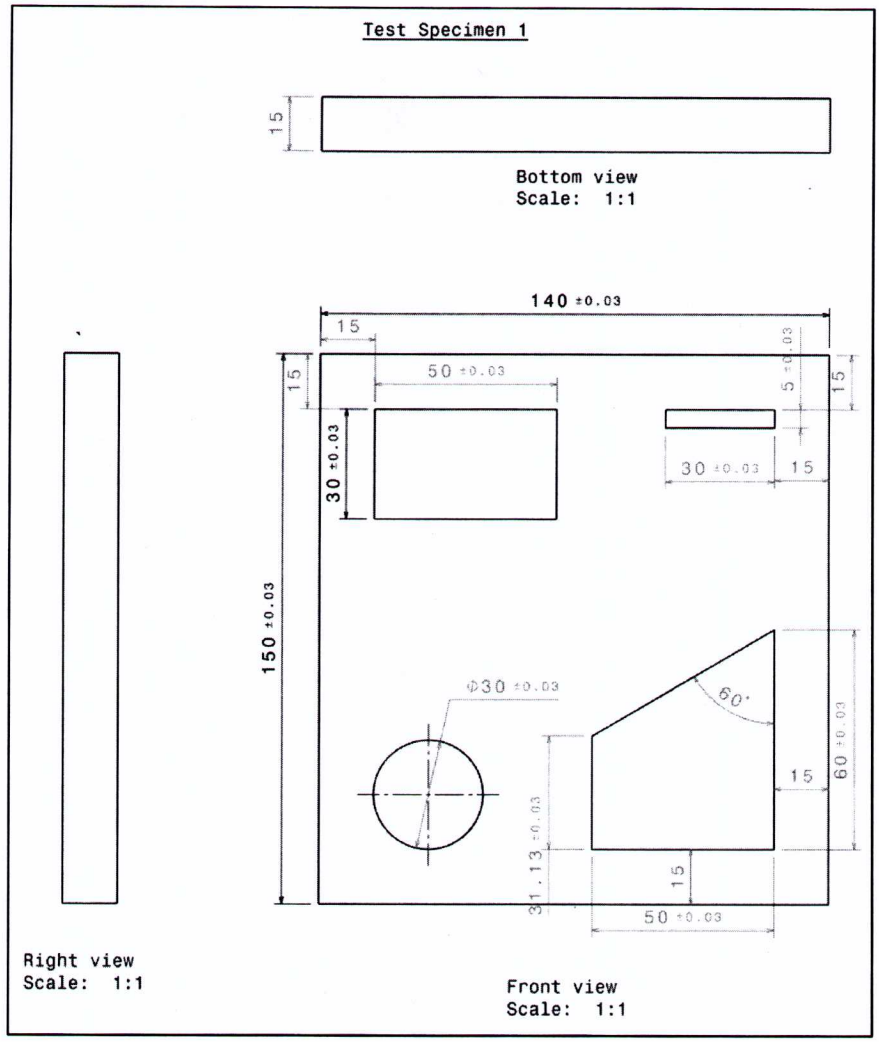
Take the distance between the two centres (A, B) in the horizontal XY plane as the measured value.

c) Measure the diameter at the respective points A, B and C. Take the maximum difference of the 3 results as the measured value (see ISO 230-1:2012, B.2.3).

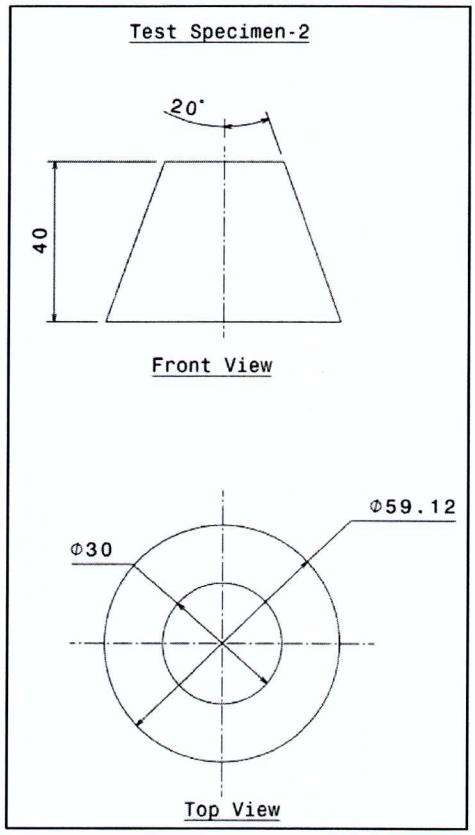
The distance of the upper wire guide to the top surface of workpiece shall be reported.

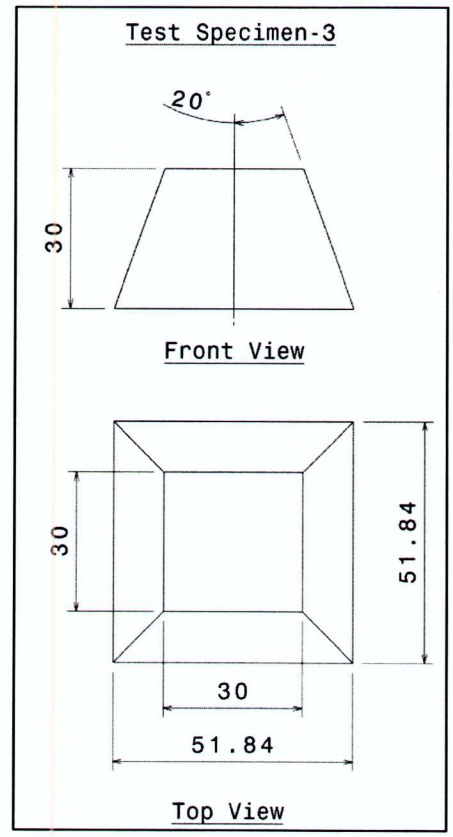
NOTE When the wire orientation is adjusted in reference to the table surface, the parallelism of the top surface to the bottom surface of workpiece may influence the perpendicularity of the machined hole.

ANNEXURE -1


Test Specimen 1
15
Bottom view
Scale: 1:1
140 ±0.03
15
50 ±0.03
5 ±0.03
15
15
30 ±0.03
30 ±0.03
15
150 ±0.03
Φ30 ±0.03
60°
60 ±0.03
15
31.13 ±0.03
15
50 ±0.03
Right view
Scale: 1:1
Front view
Scale: 1:1

ANNEXURE -1





Note:

1. Test Specimens 1, 2 and 3 will cover the linear, positional and angular capabilities.
2. Test Specimen 1 – Material – MDN250 Stainless Steel
3. Test Specimens 2 ,3 – Material Al Alloy (2124 T351)
4. All Dimensions are in mm (millimeter).

CSIR-NATIONAL AEROSPACE LABORATORIES
BENGALURU

COMMERCIAL QUERIES & CLARIFICATION

Tender No. : NAL/PUR/APMF/398/21-Z
Item Description : Procurement of CNC Wire EDM Machine.

Sr. No.	Query / Clarification Sought	Clarification/Amendment
	— NIL —	

12/04/2022
Stores & Purchase Officer
For and on behalf of CSIR