

SPECIFICATIONS FOR STANDARDIZATION OF 2 AXIS CNC TURNING CENTER (SMALL TYPE)

(Small Arms Factory)

Ser	Parameters	BOF Requirement
	Name of Machine:	To be mentioned
1.	Model No:	To be mentioned
2.	Purposes/uses of Machine:	To be described (video will be provided if available)
3.	Country of Origin:	To be mentioned
4.	Country of Manufacturer:	To be mentioned
5.	Country of Assembling:	To be mentioned
6.	Port of Shipment:	To be mentioned
7.	Country of Major Component: (All Servo motors, Spindle Motor, Control system including servo drives, Hydraulic Pump, Lead Screw, Main body, Tool Turret, Pneumatic actuators, Vector drive if available and electronics PCB cards)	To be mentioned
8.	Specification:	
	a. Minimum Swing Over Bed \varnothing 230 mm	To be mentioned
	b. Minimum Swing Over Cross Slide \varnothing 80 mm	To be mentioned
	c. Minimum Turning length 230 mm	To be mentioned
	d. Turning Diameter \varnothing 1~ 80 mm	To be mentioned
	e. Minimum Distance between Center 380 mm	To be mentioned
	f. Minimum Stroke in X Axis 100 mm	To be mentioned
	g. Minimum Stroke in Z Axis 280 mm	To be mentioned
	h. Rapid Speed X & Z	To be mentioned
	j. Cutting Speed	To be mentioned
	k. Spindle:	
	1) Max Rotation Speed	To be mentioned
	2) Chuck Size	To be mentioned
	l. Tail Stock with live Center:	
	1) Quill Taper	To be mentioned
	2) Quill Diameter	To be mentioned
	3) Stroke of tailstock	To be mentioned
	m. Turret:	
	1) Minimum Number of Tools Position 12 Nos.	To be mentioned
	2) VDI Tools Holder:	To be mentioned
	3) Minimum Number of Live Tools 06 Nos.	To be mentioned
	4) Max. Rotation Speed	To be mentioned
	n. Bar Feeder Up to 25 mm	To be mentioned
	p. Type of control system	To be mentioned
	q. Size of Display monitor	To be mentioned
	r. Chips conveyer with each machine	To be confirmed
	s. Spares for each Machine (as per machine standard) and price to be quoted separately:	
	(1) Radial Live tool Holder for Drilling: 02 Nos.	To be confirmed
	(2) Axial Live tool Holder for Drilling: 02 Nos.	To be confirmed
	(3) VDI tool Holder for Drilling: 02 Nos.	To be confirmed
	(4) VDI tool Holder for Turning Left: 02 Nos.	To be confirmed
	(5) VDI tool Holder for Turning Right: 02 Nos.	To be confirmed
	(6) Spring Collet (\varnothing 1 ~ \varnothing 20) mm: 02 Set	To be confirmed
	(7) Air Gun: 01 Nos.	To be confirmed

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	(8) Water Gun: 01 Nos.	To be confirmed
	t. Electrical Safety System	To be mentioned
	u. Mechanical Safety System	To be mentioned
	v. Air Dryer with Filter and Automatic Voltage Regulator must be supplied with each machine which is suitable for the machine	To be confirmed
	w. Power supply (380~400V, 3 ph, 50 Hz)	To be mentioned
9.	Conditions:	
	a. All axes must be integral to the machine, no attachment to be used as any axis.	To be confirmed
	b. CNC Turning Center must be able to perform flowing operations: (1) Turning, (2) Drilling, (3) Reaming etc.	To be confirmed
	c. All accessories, attachments, tools, cutter, fixture etc required to perform the above mentioned job to be supplied and mentioned with price in offer.	To be mentioned
	d. 1 x User/ programming manual in English (Hard & Soft copy) must be supplied with the machine.	To be confirmed
	e. 1 x Operation, 1 x Maintenance and Repair manual (Hard & Soft copy) with parts catalogue and circuit diagram of electrical devices in English to be supplied with the machine. These books must contain the following topics/items:	To be confirmed
	(1) Operation manual: Hydraulic, Pneumatic, Electrical, Electronic and Mechanical operational circuit and component diagrams with their detail working principles & description. Simulation/Animation of major items working/operation to be included in the soft copy.	To be confirmed
	(2) Maintenance and Repair Manual: Detail troubleshooting & repair procedure as well as maintenance and safety system.	To be confirmed
	f. Standard cooling, lighting, lubricating & control system (Software & Hardware) should be provided with machine.	To be confirmed
	g. <u>Local Training</u> : Duration of training should be at least 10 working days (Available or not). Following information must be given as under	To be mentioned
	<u>(1) Details (Local Training after installation of Machine)</u>	
	(a) Trainer Type (Local/Foreign)	To be mentioned
	(b) Number of Trainer: At least 02. One must be expert on operation/application and one must be expert on repair & maintenance on Electrical, Mechanical & Hydraulic system	To be mentioned
	<u>(2) Training:</u>	
	(a). Machine operation training: 05 working days.	To be confirmed
	(b) Machine Maintenance, trouble shooting and repair training: 05 working days.	To be confirmed
	<u>(3) Topic:</u>	
	(a) Details operation of electrical, electronics, pneumatic system, hydraulic system and mechanical system with diagrams in details.	To be confirmed
	(b) Control system: program loading and unloading, debugging, editing and servo drive and servo motors interconnecting and parameter setting in details.	To be confirmed
	(c) Troubleshooting: Artificial problems to be created by removing sensors and changing the parameters of servo drive and servo motors then faults diagnosis and repair procedures.	To be confirmed
	(d) Local training plan along (Available or not)	To be confirmed

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	h. Foreign training proposal: A 03 (three) Members BOF Team would go for operation and maintenance training to the supplier's factory for a duration of 10 (ten) working days and cost will be borne by supplier. Cost of food, accommodation, all internal travel cost, pocket money and air ticket etc. will be borne by BOF.	To be confirmed (Available or not)
	j. Pre-shipment Inspection: Pre-shipment Inspection (PSI) will be carried out by BOF at the discretion of BOF authority and all cost will be borne by BOF. The team may be comprised of 03 (Three) BOF personnel for a period of 05 (Five) working days excluding journey period.	To be confirmed (Available or not)
	k. Machine installation, commissioning & trial run must be completed by the supplier within one month (30 days) from the date of arrival of the machines at BOF.	To be confirmed
	l. The supplier should give service support for ten years after installation of machine.	To be confirmed
	m. Warranty for one year after acceptance.	To be confirmed
	n. List of fast and slow moving spares with quoted price are to be given with the tender including yearly escalation minimum for 10 (ten) years (only for reference purpose).	To be confirmed
	p. All drives and Motors should be of same Control System.	To be confirmed
	q. Tool Box and Chip Conveyor Trolley must be supplied with each machine and price to be quoted with the Machine.	To be confirmed
	r. Original brochure and catalogue must be supplied with the offer.	To be submitted
	y. Price of the Machine with all standard accessories.	To be mentioned
10.	Any other information deemed necessary for your machine	To be mentioned