

Revised 14/11/18

Double Column with Linear Motion Guide (LMG) Fully Automatic Horizontal Band saw Machine

1	Cutting capacity :	Round 300 mm dia., Square 300 x 300 mm
2	Cutting speed :	20 To 100 Mtr /Min Infinite variable for cutting all types of metals (Ferrous & Non Ferrous).
3	Supply	415 +/- 6% Ph AC Supply
4	Cutting Tapper Accuracy	+/- 0.15mm in 100mm
5	Cutting Length Accuracy	+/- 0.15mm in 100mm
6	Blade Size	4100X34X1.1mm (Preferable/std. available in market)
7	Motor	<ul style="list-style-type: none"> All Electric motors of reputed makes KIRLOSKAR/SIEMENS/CROMPTON/ABB. Switch gear from L&T/TC/BCH/SIEMENS. <p>The OEM to provide catalogue / drawings of the items offered.</p>
8	Essential Items	<p>-4100X34X1.1mm (BIMETALL BLADE): 5 Nos. -Feeder Roller Table 1000mm Length : 02 Nos -Hydraulic Bundle Cutting attachment -First Time Requirement of all consumables like Blade/Oil/Cutting Fluid etc.</p>
9	Standard Construction	<ul style="list-style-type: none"> Fully heavy duty welded structure torsion free construction. Infinitely variable pressure controlled cutting feed & upward return rapid movement by hydraulic cylinder. Coolant tank with 80 Ltr. Or more capacity and powered with low power motor. Blade Guides. High pressure coolant jets for cleaning. Powered Chip Removal Wire Brush Unit Necessary Safety and Coolant Guards
10	Machine Should Have Functional Features	<ul style="list-style-type: none"> Piece Counter and Length Counter Cutting feed and rapid reverse of cutting arm. Blade Tension when Hydraulic power is on Automatic clamping before cutting arm starts moving down for cutting. Facility for vice release and clamps as the cycle is set & synchronized with length indexing table. With fully automatic cycle, manual mode is required to facilitate initial setting. Facility for Automatic machine stop when blade fails/ breaks. Automatic height adjustment for saw frame. Feed control valve. Hydraulic sensor arrangement. Powered driven rotating cleaning wire brush thru V belt. Tungsten Carbide Face Guide Suitably Machine Mounting required for less

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		<p>vibration in machine</p> <ul style="list-style-type: none"> Hydraulic main vice and shuttle vice. Hand lubrication pump. Cycle sequencing with PLC. Auto indexing shuttle of stroke length of 400 mm or more and synchronized with auto cycle.
11	Optional Item (Quoted Separately & for information only, Not to be considered in evaluation of L1)	Optional items if any for smooth operation of machine OEM has to be mentioned & Quote
12	PRE DESPATCH INSPECTION	Before inspection of the machine at OEM's works, Test pieces will be carried out by the OEM. All the tooling, work holding devices & Standard test piece will be supplied by the OEM at free of cost.
13	INSTALLATION & COMMISSIONING OF THE MACHINE	<p>Installation, commissioning & proving of the machine to its desired capacity and complete at Customer site and will be done by the OEM's engineer. Commissioning work including acceptance test/component trial will be carried out by the OEM's Expert.</p> <p>During commissioning at least 10 nos. Of different materials test pieces will be produced on the machine and test pieces will be inspected for dimensional accuracy.</p> <p>The commissioning will be treated as complete when we issue the certificate of acceptance. Installation, commissioning & proving of the machine to its desired capacity and complete satisfaction</p>
14	TRAINING	The OEM shall have to provide onsite training to 3-5 persons exclusively for minimum seven working days in the field of programming, operation, maintenance (mechanical/hydraulic/electrical) etc.
15	WARRANTY & SERVICE BACK UP	The complete machine must have comprehensive onsite warranty from the date of successful commissioning as per below period: 12 Months
16	DOCUMENTATION	Three sets of hardcopy in English language and one set of soft copy in English language Programming, Operating and Maintenance manual. a) Mechanical b) Electrical
17	IMPORTANT NOTES	<ul style="list-style-type: none"> Vendors should provide in the technical document compliance sheet against the specification of CSIR-CMERI. Comments like yes, agreed, will be given at the time of supply, confirmed and will be completed ARE NOT ACCEPTABLE where numerical values are required to be quoted. THE MACHINE MODEL BEING OFFERED MUST BE A STANDARD LATEST MODEL. THE OEM MUST HAVE AT LEAST 5 INSTALLATIONS OF THE OFFERED SYSTEM IN INDIA (DOCUMENTARY EVIDENCE MUST BE SUBMITTED). GOVT SUPPLY DOCUMENTARY

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EVIDENCE MAY PLEASE BE PROVIDED.

2	Cutting speed	<p style="text-align: center;">1 <i>Plot</i></p> <p>20 To infinity Infinite for cutting all types of metals (Ferrous & Non Ferrous)</p>
3	Supply	415-47-6N PH 40 supply
4	Cutting Taper Accuracy	± 0.15mm in 100mm
5	Cutting Length Accuracy	± 0.15mm in 100mm
6	Blade Size	4100X34X1 3mm (Preferable/and available in market)
7	Motor	<ul style="list-style-type: none"> • All Electric motors of reputed makes KIRLOSKAR/ SIEMENS/ CHAMPION/ABB • Switch gear from L&T/TC/BCI/ SIEMENS <p>The OEM to provide catalogue / drawings of the items offered</p>
8	Essential Items	<p>4100X34X1 3mm (BIMETALL BLADE) 5 Nos. Feeder Roller Table 1000mm Length - 02 Nos. Hydraulic Bundle Cutting attachment First Time Requirement of all consumables like Blade/Oil/Cutting Fluid etc</p>
9	Standard Construction	<ul style="list-style-type: none"> • Fully heavy duty welded structure torsion free construction • Infinitely variable pressure controlled cutting load & upward return rapid movement by hydraulic cylinder • Coolant tank with 80 Ltr. Or more capacity and powered with low power motor • Blade guides • High pressure coolant jets for cleaning • Powered Chip Removal Wire Brush Unit • Necessary Safety and Cooldown Guards
10	Machine Should Have Functional Features	<ul style="list-style-type: none"> • Piece Counter and Length Counter • Cutting feed and rapid reverse of cutting and Blade Tension when hydraulic power is on • Automatic clamping before cutting and marks moving down for cutting • Facility for vice release and clamps as the cycle is set & synchronized with length indexing table • With fully automatic cycle, manual mode is required to facilitate initial setting • Facility for Automatic machine stop when blade fails/breaks • Automatic height adjustment for saw frame • Feed control valve • Hydraulic sensor arrangement • Powered driven rotating cleaning wire brush unit • V-Jack • Tungsten Carbide Face Guide • Suitable Machine Mounting required for use

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