

Kęty 21.09.2009

Re: Inquiry for logs loading table with log heater and hot billet saw, as part of 35 MN press project, co-financed with European Union with funds of The Regional Development Fund within The Operational Programme “Innovative Economy” (IE OP 2007-2013).

We kindly ask to send us your detailed offer for **logs feeding table with log heater and hot billet saw for 35 MN front loading press with billet loader and thermal control of the container**, according to below mentioned main technical characteristics:

I. Technical characteristics of the equipment:

1. Subject of the offer (exact same wording necessary): **logs loading table with log heater and hot billet saw for 35 MN front loading press with billet loader and thermal control of the container**

Information about directly co-operating equipment:

It will co-operate with: extrusion press

2. Fuel: natural gas

Calorific data of fuel - approx 38 MJ/Nm³ (normal m³ at 1035 kPa and 0C), Kęty is situated on elevation 280 meter above the sea level

3. Alloys to work with – 6xxx and 1xxx series

4. Logs heating temperature range - approx 320 - 530 C

5. Working billet diameter range and length range:

Billet diameter range:

- 9 inch (228 mm) + 0 / - 2 mm

With possibility to use in the future also billets 10 inch (254 mm)

The machine must be delivered as equipped with all parts necessary to change billet diameter 228 mm / 254 mm (for instance parts on the logs and billets transport, clamping devices, etc)

Length range:

- long logs to be cut: 2500 – 7 000 mm

6. Bow of logs - approx 3 mm / 1 m and not more than 12 mm / 6 m

7. Max. output per hour depending on billet lengths, billet temperature

and cuts per hour with heating up to 480 C, without taper heating with constant calling of the billets

- approx 5 500 kg/h for ϕ 228 mm x 1300 mm billets, number of cuts – 50 cuts per hour

8. Min. and max. billet length:

- ϕ 228 mm: 350 - 1300 mm,

9. Shortest part of 2 parts billet is approx. 250 mm. Such billet can be transported by the billet handling system to the press loader.

10. Temperature tolerance - approx +/- 4 C – defined as measured value (from approx. 50 measurements) and compared to set value - for production capacity less than 80 % of max. capacity for respective billet diameter.

Temperature tolerance- approx +/- 5 C – defined as measured value (from approx. 50 measurements) and compared to set value - for production capacity 100 % of max. capacity for respective billet diameter.

Temperature will be measured after cutting process by touch thermocouple in the same point of temperature measuring thermocouple for taper heating unit.

11. Surfaces of cut logs should be perpendicular to the axis of the billet, and deviation from right angle should not be more than 0,5 mm over the diameter. Measurement taken according to EN 486: 1997 standard: Aluminium and aluminium alloys – billets for extrusion – technical specification)

12. Tolerance of cut billet length - +/- 1mm.

13. Log storage:

Please offer 2 options:

13.1 one level log storage for horizontal storage of the billets (storage can be loaded by side fork lift truck) - approx 2,5 m wide.

13.2 three level log storage for horizontal storage of the billets (storage can be loaded by side fork lift truck) - each level approx 2,5 m wide.

14. Transport system for logs / billets should not cause damages on the surface (scratches), having negative effect on the quality of extruded products. It is appreciated that transport system has possibility to move back the logs from the inside of the heater to the log storage (function of discharge of the heater – for change of the alloy for instance).

15. Billet heater should be equipped with hot saw, enabling using (depending of the decision of the operator) various modes of operation, regarding rest piece control, including:

- function with compensation cut for combining the preset billet length in automatic from 2 parts, in case rest piece of the log is too short to form complete preset billet length in 1 piece.
- using only one part billet and scraping of rest piece

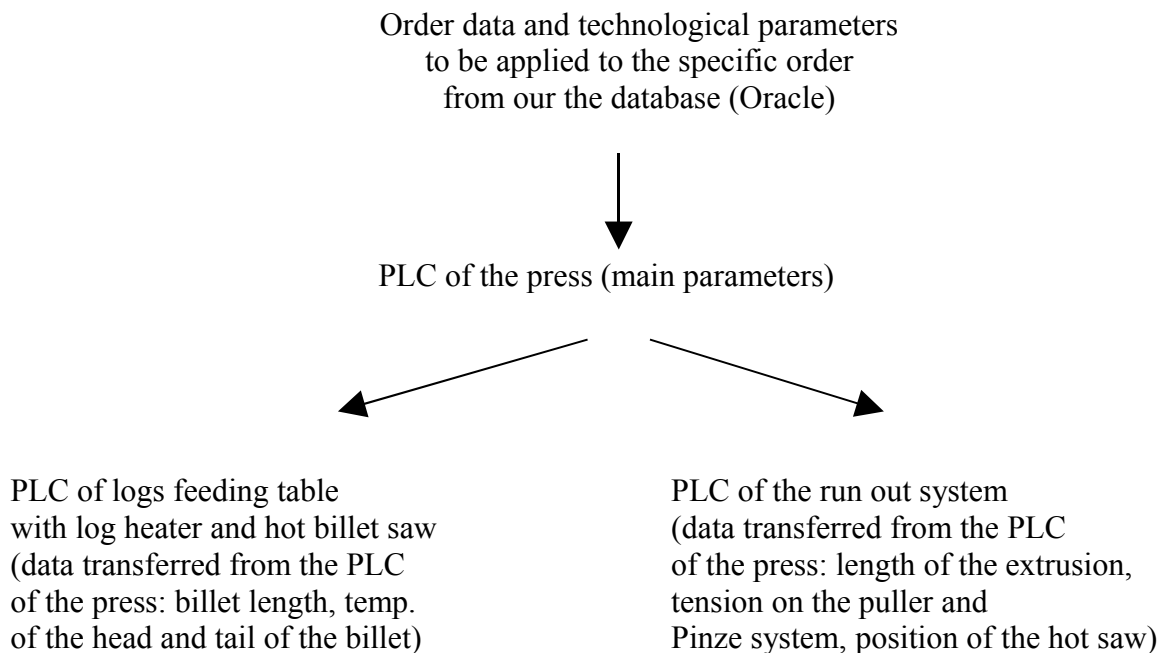
16. Heater should be equipped with taper heating zone (approx 350 mm) by gas with temp difference up to approx 100 C/m from face to end part of the billet
17. Billet heater should be equipped with the system for constant monitoring of the current length of the logs / billets being inside the heater as well as monitoring of quantity of heated material (number of logs and number of current meters of heated logs)
18. The heater should assure no sticking of cut billet face to the face of next log, during and after cutting process and correct gap detection between the logs or between the cut billet and the next log.
19. Hot billet saw should assure smooth face surface of the billet after cutting. Roughness approx 60 microns Rz parameter .
Not permissible on the cut billet are: burr, sticked chips, surfaces covered with oil.
20. The hot billet saw must be equipped with efficient chip extraction system. Chips after extraction should be collected in some container, easily replaceable.
21. Automatic lubrication system for moving parts.
22. Noise level of the equipment (including hot billet saw during cutting cycle) at places of operators - below 85 dB
23. Transfer system to the press billet loader included
24. Rexroth hydraulics, if hydraulics used
25. Supervision to assembling, start up and final acceptance procedure by specialised, English speaking personnel. We will provide the manpower to work under such supervision and will ensure translation. The costs of board and lodging as well as local transport (airport – hotel – plant) should not be included in the offer. We will cover these costs locally.
26. All cables and electrical installation material (such as for instance cable trenches with hangers) from electrical cabinets to the equipment are to be quoted
27. 2 pieces of saw blade for each series of alloys.
In case different saw blades are used for alloys of 1XXX series and 6XXX series, than 2 pieces of saw blades for each alloy group – i.e. 4 pieces altogether
28. Safety systems and safety devices including for instance, safety shields for moving parts, safety fences, safety access doors, electrical locks for safety doors.
29. Billet brushing system for billet cleaning at the entrance to the preheating zone – CE and ATEX compliant – with appropriate dust suction system.
30. HMI system for the operator. HMI system of the equipment should work for control of the equipment independently and also should be prepared for acquiring certain production parameters from the PLC of the press.
31. From the supplier of the extrusion press it will be required, that HMI system of the extrusion press should be prepared for acquiring the data from external database, for instance Oracle (data regarding production order and basic technological parameters to be applied to this production order) and than send those data for execution to the PLC of the extrusion press

and certain of those data also to the PLC's of directly co-operating equipment, i.e.: logs feeding table with log heater and hot billet saw as well as run out system

32. Our requirement is that, the press would have optimization of the billet length after each billet. This optimization will be based on the feedback with the real length of extrusion taken from the PLC of the run out system. Than after each billet, the press would send optimized billet length required from log heater to the PLC of log heater.

33. Our requirement is that, the press would exchange the data with logs feeding table with log heater and hot billet saw as well as run out system. The press would be leading in this concept of transferring the data, i.e. data to the PLC's of the logs feeding table with log heater and hot billet saw as well as run out system will go through the PLC of the press.

The information flow would be as follows:



34. Interconnection of signals with other directly co-operating equipments PLC's wherever necessary - like: extrusion press.

35. Control system based on Siemens S7 PLC series 300 or 400, with possibility of connection to local Ethernet network and remote service by VPN connection, which we will provide.

36. If communication of PLC with executing devices (like frequency converters, laser length measuring devices, etc) is necessary Profibus DP should be used for it. Exchange of the data between the press PLC and the PLC's of other directly co-operating equipment to be done by Ethernet.

37. All the control signals should be available in the PLC for pick up by Production Management System (production data collection). We do not need Production Management System to be offered, since we already have one. It is only to make sure that signals will be available in the PLC for pick up by our Production Management System by means of before mentioned data exchange table.

II. Exclusions from the scope of supply – for clarity reasons, what items should not be offered

1. Hydraulic oil for first filling of the hydraulic system
2. Any civil works
3. Electrical supply lines for electrical cabinets
4. Supply line for other utilities (for instance: water, compressed air, nitrogen) up to the connection points on the equipment
5. Lifting equipment for assembling of the equipment and for regular operation (like for instance crane for tool handling)
6. Modifications in PLC's of other suppliers (i.e. suppliers of co-operating equipment like: extrusion press, run out system, etc)
7. Scrap bins
8. Manpower for assembling and commissioning
9. The costs of board and lodging as well as local transport (airport – hotel – plant) specialised, supervising personnel.

III Lay out

Attached you can find the indicative lay out drawing of the equipment, with identified 60 items (apart from the extrusion press itself), which form the production line. Excel file is attached, with list of items and short description of each item.

Please note, that main purpose of the attached lay out is to show the idea of material flow, the idea of interrelation between various equipment and relation of the equipment to the building.

Dimensions of the structure of the building are fixed.

The other dimensions should result from the above mentioned specification of the equipment. Please do not scale and take dimensions of the equipment from this lay out drawing.

We ask you to quote item no. 1 - 5 on the lay out.

Other items are shown for your information, in order you can have better idea about the configuration of other directly co-operating equipment as well as configuration of all other equipment.

IV Conditions of the presentation of the offer

We kindly ask to deliver to us the offer only in written form with signature, within 30.10.2009. - 2.00 p.m. in closed, not transparent envelope marked:

“The offer for logs loading table with log heater and hot billet saw for 35 MN front loading press with billet loader and thermal control of the container.”

We kindly ask not to send the offer by e-mail or fax.

We ask to send it enough time in advance (preferably by courier service) to be sure it reaches us before 30.10.2009. - 2.00 p.m

The offer should be addressed to

GRUPA KĘTY S.A.

Ul. Kościuszki 111

PL 32-650 Kęty

Poland

To the attention of Mr Adam Miarka

The offer should be presented in English language and be structured according to the below presented pattern:

1. Subject of the offer: logs loading table with log heater and hot billet saw for 35 MN front loading press with billet loader and thermal control of the container

2. Price in EUR, including delivery DDU Kęty and supervision to commissioning

3. Warranty period defined from Final Acceptance Test, completed with positive result: Warranty period (min. 12 months) , covered by the Good Performance Bank Guarantee valid till the end of warranty period and in the amount of the 10% of the Contract Value.

4. Time schedule of delivery and commissioning

Delivery date DDU Kęty: weeks from signing the contract (in anyway not later than May 2011)

First hot billet heated: weeks from signing the contract

Final Acceptance Test, completed with positive result: weeks from signing the contract (in anyway not later than November 2011)

5. Payment conditions

If payment conditions assume the advance payment installments, the payment will be covered by bank or insurance payment guarantee in the amount of each payment and valid till the end of delivery.

6. Validity of the offer (in any case not shorter till 15.01.2010)

7. Appendix no. 1 – Technical specification to the offer presenting technical side of the equipment.

We ask to present in the offer in details the following issues:

7.1. Detailed description of the equipment and its individual items / units / subunits, illustrated with pictures from most similar installation you have done and as much technical data as you can provide Please include as much as possible some drawings, sketches, pictures, for better explanation

7.2. Lay out drawing of the equipment as top view and other views and cross section drawings in most important areas

7.3. Description and presentation by some drawings and pictures of the transfer point in your machine where you deliver the billet to the press. We must be clear to which point of your machine the billet will be delivered, and from which point it is picked up by the extrusion press, which will not be part of your supply.

7.4. Drawing of cross section of the oven, showing positions of the burners and their distance from the log for 9 inch billet and for 10 inch billet (which will be possibly used in the future).

8. Appendix no. 2 – Other conditions of the offer (for instance detailed commercial conditions)
9. Appendix no. 3 - Up to date reference list for all delivered log heating systems for last 20 years (but with clear distinctive marking, which systems were equipped with hot billet saw).
10. Appendix no. 4 - List of patented solutions to be used in the equipment, if any. Please attach copies of respective documents, which would confirm obtaining the patent or declare, that no patented solutions will be used.
11. Appendix no. 5 - List of brands for commercial components for electrical, mechanical, hydraulic, pneumatic systems (identifying which brand of for instance: frequency converters, pneumatic valves, bearings, etc is offered)
12. Appendix no. 6 - Declaration, confirming that you meet formal conditions to present the offer and to be able to be chosen as the supplier, due to procedures related with co-financing by European Union with funds of The Regional Development Fund within The Operational Programme “Innovative Economy” (IE OP 2007-2013). Pattern of the declaration to be filled in is attached to this inquiry.

The evaluation of the complying with the formal conditions will be done accordance with the formula: comply or not comply. If the Bidder does not comply with any of the formal criteria, his offer will be excluded from evaluation and excluded from possibility of attaining the order.

13. Appendix no. 7 – Declaration, confirming that you meet environmental criteria, if any such criteria are applicable. Pattern of the declaration to be filled in is attached to this inquiry. Please attach of copies of respective documents, which would confirm complying the environmental criteria.

The evaluation of the complying with the formal conditions will be done accordance with the formula: comply or not comply. If the Bidder does not comply with any of the formal criteria, his offer will be excluded from evaluation and excluded from possibility of attaining the order.

V. Additional information regarding how the offer will be processed:

Due to the formal reasons, connected with co-financing of this project by European Union with funds of The Regional Development Fund within The Operational Programme "Innovative Economy" (IE OP 2007-2013), we need to follow certain rules in the processing the offers and choosing of the supplier for this project.

We would like to inform you therefore how the offer, presented by, you according to above mentioned conditions, will be evaluated and on what basis the decision regarding the final choice of the supplier will be made.

Each presented offer will be evaluated with the use of assigned points, against below mentioned criteria. Each criterion will be evaluated independently.

The points for each individual criterion will be assigned to each bidder, depending on the rank of his offer after comparison with all the other presented offers. Ranking of sum of all individual points will be decisive for the choice of the supplier.

Criteria for evaluation of the offers:

1. **The criterion „the Price of the Offer”** will be calculated according to the following formula:

$$W_{\text{PRICE}} = (\text{PRICE}_{\text{min}} / \text{PRICE}_{\text{bidder}}) * \text{the coefficient of the importance} * 100 \text{ points}$$

where:

W_{PRICE} – means the quantity of points obtained in the category

$\text{PRICE}_{\text{min}}$ – means the minimum-amount offered among estimated offers

$\text{PRICE}_{\text{bidder}}$ – means the amount offered by the bidder

- the coefficient of the importance fixed in the category and expressed in percentage
- For this criterion we can give maximum **51 points**

2. **The Criterion the technical „Value of the offer ”** will be calculated according to the following formula:

$$W_{\text{TECH}} = (W_{\text{tech bidder}} / W_{\text{tech max}}) * \text{the coefficient of the importance} * 100 \text{ points}$$

where:

W_{TECH} – means the quantity of points obtained in the category

$W_{\text{tech max}}$ – means the maximum points gave in the technical estimation in the category

$W_{\text{tech bidder}}$ – means the quantity of points gave to the bidder offer.

- the coefficient of the importance fixed in the category and expressed in percentage
- for this criterion we can give maximum **35 points**

3. **The criterion „Time schedule of the contract ”** - will be calculated according to the following formula:

$$W_{\text{PERIOD}} = (W_{\text{min period}} / W_{\text{bidder period}}) * \text{the coefficient of the importance} * 100 \text{ points}$$

where:

W_{PERIOD} – means the quantity of points obtained in the category

$W_{\text{min period}}$ – means the shorter time of the final acceptance test offered among estimated offers

$W_{\text{bidder period}}$ – means the time of the final acceptance test offered by the bidder

- the coefficient of the importance fixed in the category and expressed in percentage
- the time of final acceptance test will be expressed in whole months starting from the date of order.

- For this criterion we can assigned maximum **4 points**

4. **The Criterion „Warranty period”** ” will be calculated according to the following formula:

$$W_{\text{warranty}} = (W_{\text{warranty bidder}} / W_{\text{warranty max}}) * \text{the coefficient of the importance} * 100$$

points

where:

W_{warranty} – means the quantity of points obtained in the category

$W_{\text{warranty max}}$ – means the maximum period of given warranty offered in the category

$W_{\text{warranty bidder}}$ – means the period of given warranty offered by the bidder

- the coefficient of the importance fixed in the category and expressed in percentage
- the period of the offered warranty will be expressed in whole months starting from the positive final acceptance protocol
- for this criterion we can assigned maximum **4 points**

5. **The Criterion „Payment condition”** ” will be evaluated as following:

- During estimation of this criterion we can assigned from **0 to 6 points**. The better terms of the payment will receive properly biggest quantity of points.
- for this criterion we can assigned maximum **6 points**

6. The maximum quantity of points to the obtainment: **100**.

7. The Offers will be estimated according to the following formula:

$$W = W_{\text{PRICE}} + W_{\text{TECH}} + W_{\text{PERIOD}} + W_{\text{Warranty}}$$

8. The coefficient of the importance:

Serial	Condition	The coefficient of the importance	The condition of given points	Maximum points to be assigned
1	Price of the Offer	51%	According to rules described in point 1	51
2	Value of the offer	35 %	According to rules described in point 2	35
3	Time schedule of the Contract	4%	According to rules described in point 3	4
4	Warranty period	4%	According to rules described in point 4	4
5	Payment conditions	6%	According to rules described in point 5	6

9. The offer which obtained biggest quantity of points will be chosen. Remaining offers will be classified in accordance with a quantity of obtained points.

10. After process of evaluation of the offers is completed, each bidder will be informed about the status of his offer.

GRUPA KĘTY S.A.

Ul. Kościuszki 111, 32-650 Kęty