Kęty 21.09.2009

Re: Inquiry for 35 MN front loading press with billet loader and thermal control of the container 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 35 MN front loading press with billet loader and thermal control of the container, according to below mentioned conditions:

I. Main technical characteristics of the equipment:

1. Subject of the offer (exact same wording necessary): **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: logs feeding table with log heater and hot billet saw and run out table with automatic stacking of profiles in the baskets and with PINZE system

2. Nominal press force: 35 MN

3. Container size: suitable for billets 9 inch (228 mm 0 / -2 mm) as main container size with possibility to install in the future also container for billets 10 inch (254 mm)

The press must be equipped with all parts necessary to change billet diameter 228 mm / 254 mm (for instance parts on the billet loader, and billet handling system), without spare container or spare liner for 10 inch (254 mm) billets

Complete container with container heating system: Container must be equipped with patented solution for thermal control of the container (so called "QR container"), by company CASTOOL, 2 Parrat Road, Uxbridge, Ontario, Canada L9P 1R1 (www.castool.com). Patent number US 7272967 dated on 25/09/2007 – International classification B21C 27/00 – "Thermal control extrusion press container". The obligatory is to enclose the declaration of CASTOOL Company confirming the possession of all rights to the patented solution referring to the patent number US 7272967 that will be used on the QR container and your separate declaration about application of this patented solution (all declarations must be addressed on the final user – Grupa Kęty SA).

Using of this container is obligatory.

4. Billet length range: approx. 350 to 1300 mm.

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

6. Prestressed tie rods design of the press .

7. Max extrusion speed: 22 mm/s

8. Dead cycle time including burp cycle (with pressure built up to 100 bar) and without boron nitride spray on the dummy block or face of the container: approx. 14 seconds for billets diameter 228 mm and 1300 mm long.

9. Dead cycle time including burp cycle (with pressure built up to 100 bar) and with boron nitride spray on the dummy block or face of the container: approx. 18 seconds for billets diameter 228 mm and 1300 mm long. The smaller the value, the more appreciated.

10. Max circumscribing circle of the profile – approx. 270 mm.

11. Max height of the profile - approx. 270 mm.

12. Max size of panel type profiles approx. 350 mm x 60 mm.

13. Cassette type system for die exchange.

14. Die set dimensions – to be finally agreed at later stage

– please quote for approximately ∅ 520 mm x 520 mm
- please quote as an option at extra price ∅ 520 mm x 520 mm+ 150 mm of additional bolster, constantly remaining in the die set

15. Heavy duty hydraulic clamping of die set during butt end shearing to avoid vibration of the die and marks on extrusions due to butt shearing.

16. Computer system, enabling isothermal extrusion.

17. Cooling system for the butt end shear blade.

18. Butt end knocker to make sure butt end will be removed in case it is sticked to the die.

19. Monitoring system if butt end does not remain sticked to the shearing blade.

20. Monitoring system for butt end after shearing, to make sure it is removed from the die and passed down through the discard chute (second safety system apart form monitoring system mentioned under item 18).

21. System of lubrication of the back side of the billet (contact side with the stem) by boron nitride, installed in the area of billet transfer to the press.

22. System of lubrication of fixed dummy block by boron nitride working in automatic. Boron nitride gun with nozzle to be installed on some linear guiding system, introducing the gun in the right time of press cycle to the press axis and performing the spray of boron nitride on the dummy block. This system should be controlled such a way, that it should be possible for the operator to choose the interval between the press cycles, when the spary shoud be applied.

23. System of lubrication of the face of the container by boron nitride in motorised version. Boron nitride gun with nozzle to be installed on some linear guiding system, introducing the gun in the right time of press cycle to the press axis and performing the spray of boron nitride on the face of the container. This system should be controlled such a way,

that operator would switch it on whenever necessary – not working in automatic in a sense that it activates after preset number of cycles.

24. Oil heating and filtration system suitable for cold ambient conditions.
    Electrostatic oil cleaning system to be applied (for instance Kleentek) in order to reduce the frequency of exchange of the oil.

25. Rexroth hydraulics.

26. Butt shear self adjusting to the face of the die (so called zero gap system).

27. Castool dummy block

28. Cartridge type lubrication system for main moving parts.

29. 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 we 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.

30. All cables and electrical installation material (such as for instance cable trenches with hangers) from electrical cabinets to the equipment are to be quoted.

31. Cleaning system of the container.

32. 1 set of complete tooling for the press, including container with liner suitable for billets 9 inch (228 mm), stem, dummy block, cleaning disc for cleaning system of the container, device for removal of non extrudable billets (stickers).

33. Preparation of the press to connect nitrogen cooling to the die set through a hole in the counterplaten.

34. Safety systems and safety devices including for instance, safety shields for moving parts, safety fences, safety access doors, electrical locks for safety doors.

35. Calculation and optimization of the billet length after each billet in feedback with the real length of extrusion taken from the run out system – request to the billet heater for next billet with optimized length

36. Noise level of the equipment at places of operators - below 85 dB

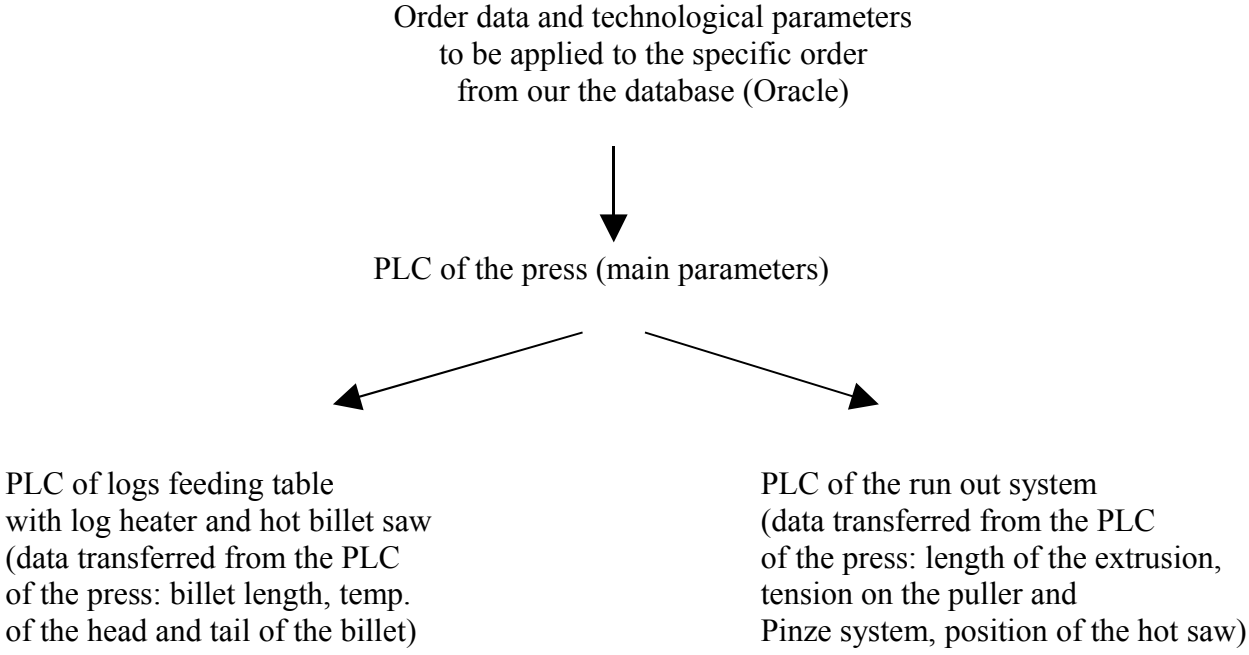
37. HMI system for the operator. HMI system should be prepared for acquiring the data from external database, for instance Oracle (data regarding production order and basic technological parameters to be applied to this production order) and than send those data for execution to the PLC of the press.

The same aquiring of the data from the data base to the PLC for execution on the equipment will be required of directly co-operating equipment, i.e.: logs feeding table with log heater and hot billet saw as well as run out system.

Our requirement is that, since the press will have optimization of the billet length and exchanges the data with logs feeding table with log heater and hot billet saw as well as run

out system, the press will 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:



38. HMI system should record to its local database, for instance Oracle or Sybase, data regarding production order for each billet, including also part of the data from log heater and run out system (details of the table of data for data exchange to be agreed at later stage)

39. Interconnection of signals with other directly co-operating equipments PLC's wherever necessary - like: logs feeding table with log heater and hot billet saw, run out system, butt end conveyor, nitrogen supply system for cooling of the dies, etc.

40. 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.

41. 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..

42. 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. Extrusion tools such as bolsters, subbolsters, die holders, dies
6. Lifting equipment for assembling of the equipment and for regular operation (like for instance crane for tool handling)
7. Modifications in PLC's of other suppliers (i.e. suppliers of co-operating equipment like: logs feeding table with log heater and hot billet saw, run out system, butt end conveyor, nitrogen supply system for cooling, etc)
8. Scrap bins
9. Butt end conveyor
10. Manpower for assembling and commissioning
11. 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.

Other items, apart from the press 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 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 courrier 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: 35 MN frontloading 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 for main press body parts (including: platen, counter platen, tie rods units, press bed, container housing): …… months (min. 36 months)

Warranty period for all other parts of the press: ……. months (min.18 months). Warranty to be covered by the Good Performance Bank Guarantee valid till the end of warranty period for all other parts of the press and in the amount of the 10% of the Contract Value.

4. Time schedule of delivery and commissioning

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

4.2. First hot billet extruded: …… weeks from signing the contract

4.3. 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 from which you pick up the billet from logs feeding table with log heater and hot billet saw to the press. We must be clear to which point of your machine the billet should be

delivered, by logs feeding table with log heater and hot billet saw, which will not be part of your supply.

7.4. Drawing of press opening in the counterplaten, with dimensions included, which will make possible to see what maximum sizes of the profiles can be extruded on the press.

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 extrusion presses for last 20 years (including extrusion presses for all types of metals, but with clear distinctive marking, which of them are frontloading presses).

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:

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

where:

W_{PRICE} – means the quantity of points obtained in the category
$PRICE_{min}$ – means the minimum-amount offered among estimated offers
$PRICE_{bidder}$ – 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:

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

where:

W_{TECH} – means the quantity of points obtained in the category
$W_{tech\ max}$ – means the maximum points gave in the technical estimation in the category
$W_{tech\ bidder}$ – 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:

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

where:

W_{PERIOD} – means the quantity of points obtained in the category
$W_{min\ period}$ – means the shorter time of the final acceptance test offered among estimated offers
$W_{bidder\ period}$ – 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:

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

where:

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

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

$W_{warranty\ bidder}$ – 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 fallowing:

- 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:
   $W = W_{PRICE} + W_{TECH} + W_{PERIOD} + W_{Warranty}$

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