

Kęty 21.09.2009

Re: Inquiry for run out table with automatic stacking of profiles in the baskets and with PINZE system, 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 **run out table with automatic stacking of profiles in the baskets and with PINZE system 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): **run out table with automatic stacking of profiles in the baskets and with PINZE system 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, system of conveyors and automatic cranes for transport of the baskets

2. Run out type: double length system 2 x 52 m + approx. 7 m – see attached lay out
Run out configuration: “U type” – with finishing saw closer to the press – see attached lay out

3. Main data of extruded profiles:

Max. profile weight: 15 kg/m – total from all cavities

Belts must be equipped with appropriate traction system preventing slipping under such load

Average. profile weight: 2,2 kg/m – total from all cavities

Min profile height: 5 mm

Max profile height: 270 mm

Max circumscribing circle of the profile: 270 mm

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

4. General dimensional data

Working width of the roller conveyor on the puller track: 550 mm

Width of roller conveyor to finishing saw: approx 1200 mm – as per your recommendation for 1000 mm working batch width

Max extrusion length (length of the cooling table): approx. **52 m**

Rollers pitch on roller conveyor on the puller track: approx. **300 mm**

Rollers pitch on roller conveyor feeding finishing saw: approx. **300 mm**

Belts pitch on the whole run out system (axis to axis): 900 mm

5. Initial adjustable table

Level of the run out (belts) approx 75 mm below press axis.

Level of the run out system 850 mm above the floor level

Length of vertically adjustable initial table: approx. 8 m

Height adjustment possibility approx. 150 mm (+75 mm / - 75 mm)

6. Lead out table

Length of lead out table (between vertically adjustable initial table and cooling table with belt system): approx 52 m – as per your recommendation – see the lay out

7. Puller

Double puller type. Dead cycle time of the puller approx. 12 s

Pulling force: adjustable:

min puller force: 300 N

max puller force: 3000 N or as per your recommendation

Lamella fingers of approx: 10 - 15 mm wide

Puller lowest distance from press mouth for first extrusion: approx 1 m

Safety system to make sure puller will not come back to the press unless extrusions are successfully unclamped

8. Hot saw:

Positionable (not flying cut)

Operating range 7 - 59 m from press exit

Possibility of cutting samples 300 – 800 mm long

Additional stationary cut off saw for hot extrusion within 1 m from press exit. Rigid construction of the saw.

Efficient chip exhausting system for both saws. Collection of chips in a container, easily replacable, preferably situated in the auxiliary room along the main building – see lay out

9. Rollers in the roller conveyors in the press axis

Rollers in the initial adjustable table (up to approx. 8 m from press exit)– all of them driven synchronically with the puller drive

Rollers in the leadout table (approx. 7 – 59 m from the press exit) – all of them driven synchronically with the puller drive

Rollers in the run out table in cooling belts area (approx. 59 – 111 m from the press exit) – all of them driven synchronically with the puller drive

Diameter of the roller: with high temp. resistant sleeve outside: min 110 mm

In the puller track – first part from press exit till beginning of cooling area (first 59 m), - PBO high temp. resistant sleeve (brown layer) material with temp. resistance 600 C – material by company Comexale – 2 symetric parts of the roller / total length divided in half.

In puller track in the cooling area (52 m) kevlar high temp. resistant sleeve material (yellow) with temp. resistance 550 C – material by company Comexale 2 symetric parts of the roller / total length divided in half.

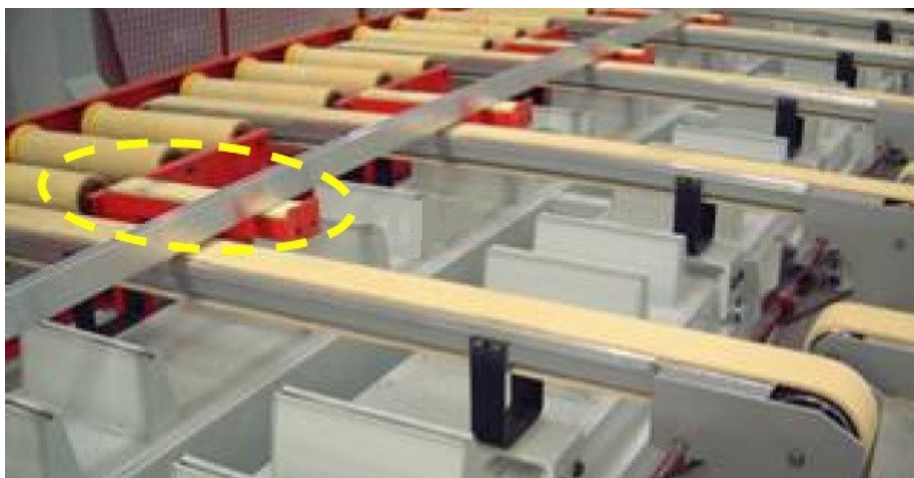
10. Cooling belts

Configuration according to the attached lay out.

Catwalk for operator's service access in cooling belt # 2

Belts width: approx. 100 mm - as per your recommendation

Cooling belts area should be equipped with liftable resting beams covered with high temp. resistant material (high temp. resistant pads) in order the extrusions can be deposited there during cooling and rest there in order to reduce wearing out of the cooling belts – see the attached picture



Material of the belts by company Comexale

11. System to hold the extrusions from press exit till stretcher jaws under adjustable tension – so called Pinze system

Complete system to hold the extrusions from press exit till stretcher jaws under adjustable tension, with minipuller and 3 pairs of heads, equipped with working jaws – so called Pinze system

Service range for profiles with length of: 15 – 52 m

Max. handling weight of extrusion: 15 kg/m

Please specify in the offer the range of adjustment of the tension and how the regulation is made (stepless or step regulation)

This system is obligatory to be offered.

12. Stretcher

Force: 90 t without detwisting device

Upper jaw: lamella type with fingers approx 10-15 mm wide

Service range for profiles with length of: 15 – 52 m

13. Finishing saw:

Min. height of cut profile 5 mm.

Diameter of the rollers to the finishing saw – approx 100 mm outside diameter

Min cutting length: 2 m

Max. cutting length: 15 m

Cutting tolerance:

For profiles within

- length range: 2 – 3,5 m: +/- 0,5 mm

- length range: 3,6 – 7,5 m: +/- 1 mm

- length range: 7,6 – 15 m: +/- 1,5 mm

All the rollers on roller conveyor feeding the finishing saw: driven

No rollers on the finishing saw table – flat table of the saw

Efficient chip exhausting system. Collection of chips in a container, easily replacable, situated in the auxiliary room along the main building – see lay out

14. Stacker

Type of the stacker: LIFO (LAST IN FIRST OUT)

Possibility to prepare the batch of profiles on the transporter before the stacker, composed of

- 2 length of profiles within the range of 2 – 3,5 m
- 1 length of profiles within the range 3,6 – 15 m

Type of stacker – conventional handling batches of profiles situated on steel spacers in form of rectangular tube with dimensions of 40 x 10 x 1190 mm x 2 mm wall thickness with textile covering

Profiles with length within 7,5 m will be placed in standard basket – see attached drawing of the standard basket

Profiles with length within 7,6 m – 15 m will be placed in long basket – see attached drawing of the long basket

Pitch of the grippers – 900 mm

Function of compacting the batch of profiles in order to avoid the gaps between profiles - included

Function of placing the layers of profiles one on top of another or depending of the choice of the operator placing the layers of profiles on the combs of the baskets (in such case layers of profiles do not touch each other)

Max weight of single batch:

- approx. 300 kg for profiles up to 7,5 m
- approx. 600 kg for profiles within 7,6 m – 15 m

15. Cooling system

Below lead out table in puller track - centralized air cooling system to blow the air from the bottom. Frequency controlled fans, in order to obtain regulation of the air flow. Fans are to be placed in auxiliary rooms along the main building – see the lay out. Suction of the air from outside of the building. Cooling capacity approx. 2 x 25 000 m³/h with air knives and air blowing speed at the nozzle min 15 m/s.

Below run out table (in the cooling belts area) in puller track - centralized air cooling system to blow the air from the bottom. Frequency controlled fans, in order to obtain regulation of the air flow. Fans are to be placed in auxiliary rooms along the main building – see the lay out. Suction of the air from outside of the building. Cooling capacity approx. 2 x 25 000 m³/h with air knives and air blowing speed at the nozzle min 15 m/s.

Below the cooling belt # 1 - centralized air cooling system with dispersed air stream to blow the air from the bottom. Frequency controlled fans, in order to obtain regulation of the air flow. Fans are to be placed in auxiliary rooms along the main building – see the lay out. Suction of the air from outside of the building. Cooling capacity approx. 2 x 25 000 m³/h with air blowing speed at the exit: min 15 m/s.

Below the cooling belt # 2 - centralized air cooling system with dispersed air stream to blow the air from the bottom. Frequency controlled fans, in order to obtain regulation of the air flow. Fans are to be placed in auxiliary rooms along the main building – see the lay out. Suction of the air from outside of the building. Cooling capacity approx. 2 x 25 000 m³/h with air blowing speed at the exit: min 15 m/s.

In the initial table, up to approx 12 m from press exit - air quench unit divided in 2 units 6 + 6 m - cooling system from all sides around the profile with cooling intensity adjusted from each side of the profile – with possibility of memorizing the data in the control system. Frequency controlled fans, in order to obtain regulation of the air flow. Fans are to be placed in auxiliary rooms along the main building – see the lay out. Suction of the air from outside of the building.

Cooling capacity approx. 2 x 60 000 m³/h (60 000 m³/h for each 6 m part) for upper part and both sides + approx. 2 x 30 000 m³/h (30 000 m³/h for each 6 m part) for bottom part with air knives and air blowing speed at the nozzle min 15 m/s

In the lead out table, from approx 12 m from press exit (after above mentioned air quench unit) up to approx. 42 m from press exit - additional cooling system from the top – 5 units of 6 m. Cooling capacity approx. 5 x 12 000 m³/h with air knives and air blowing speed at the nozzle min 15 m/s.

16. Overall dimensions in the cross section

Distance between the axis of the puller track and axis of the stretcher – approx. 6 000 mm

Distance between the axis of the puller track and axis of the finishing saw – approx. 9 950 mm

17. Data of the baskets

Average weight of the material in the basket for the ageing oven

- standard basket: 800 kg
- long basket: 1200 kg

Maximum weight of the material in the basket for the ageing oven

- standard basket: 1200 kg
- long basket: 2000 kg

Note: For calculation of the conveyors and automatic cranes you should assume 50 % of max. load and 50 % of the average load, i.e. 1000 kg of aluminium in the standard basket and 1600 kg aluminium in long basket.

Max. weight of the basket itself (steel basket + steel spacers with textile covering)

- standard basket: 700 kg
- long basket: 1100 kg

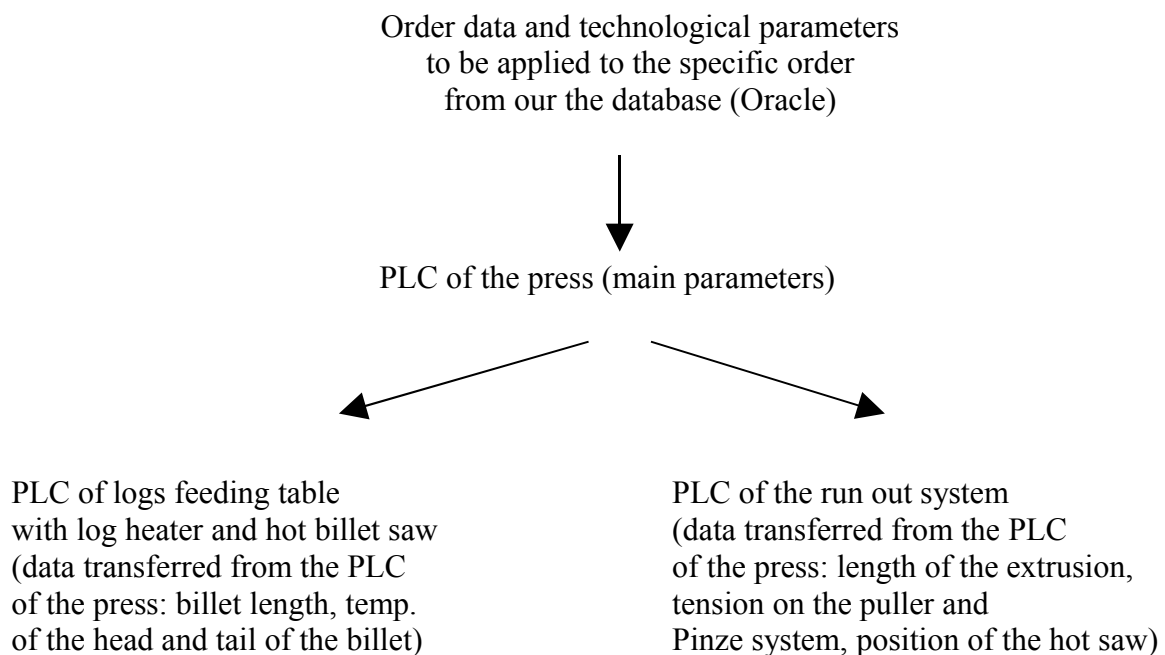
18. Supervision to assembling, start up and final acceptance procedure by specialised, English speaking personnel. We will provide the manpower to work under such supervision and will ensure translation. The costs of board and lodging as well as local transport (airport – hotel – plant) should not be included in the offer. We will cover these costs locally.

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

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

21. Noise level of the equipment at places of operators - below 85 dB
22. HMI system for the operator. HMI system of the equipment should be prepared for acquiring certain production parameters from the PLC of the press.
23. 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
24. 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.
25. 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:



26. Interconnection of signals with other directly co-operating equipments PLC's wherever necessary - like: extrusion press, system of conveyors and automatic cranes for transport of the baskets.
27. 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.

28. 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.

29. 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.

IMPORTANT REMARK ABOUT OPTION !:

Please prepare and present also option of the offer for run out system with flying cut, instead of double length 52 + 52.

The option with flying cut should have length of the cooling belts 61 m + length of the roller table between the press exit and the cooling belts necessary for flying cut of the extrusion.

Please prepare and present in the offer alternative lay out for version with flying cut.

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: gas, compressed air) 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. 7 – 29 and 31, 34, 35 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 run out table with automatic stacking of profiles in the baskets and with PINZE system 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: run out table with automatic stacking of profiles in the baskets and with PINZE system for 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 (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 extruded: 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
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 run out systems (including complete systems and partial systems) for last 20 years (but with clear distinctive marking, which systems were delivered as complete systems and which systems as partial ones and which were fitted with so called Pinze system).
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