

ANNEXURE

Electro Magnetic Table for CNC Machine.

1	Table Size (Qty-1 No.)	800L x 600 W x (max90) H. Machined out of single block and water proof. Magnetic pole Size 75x75mm
2	Table Size (Qty-5 No.)	400 L x 400 W (max90) H. Machined out of single block and water proof.
3	Table Size (Qty-2 No.)	600 L x 300 W x (max90) H. Machined out of single block and water proof.
4	Electro permanent Magnet Fixed Magnetic Transfer Blocks Qty-100 nos.	Size 75 x75 mm.
5	Power Supply unit with Magnetising/De-magnetising Switch suitable for above all Chucks.	Qty. 3 nos.
6	Essential features	Work holding device for conventional and CNC Milling Machine.
		No continuous power requirement except for activation & de-activation.
		Chuck should be tested for slipping force, water proof for wet machining and dust proof for dry machining.
		Any other accessory for special holding of the job like Cylinders, thin components etc . may be quoted separately. (Not to be calculated for assessing the L-1.)
		Suitable facility should be available for de-magnetisers to overcome residual magnetism.
		Chucks should be supplied with 4 meter long cable (Sheathed).
		It should be easily integrated with pallet clamping.
		General requirements: All tests and confirmation to clamping force, slipping force of vertical lifting force should comply with IS8710-1978.
		There should be no de-clamping of the component due to power failure
7	Suitable for light machining.	3-6 mm depth of cut.
8	Slipping force	2.5 to 3.5 kg / sq. cm. or better
9	Vertical lifting force.	40 to 45 kg / sq. mc or better

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10	Variable supply unit to vary the power.	220 V
11	Accessories	Standard accessories (Mechanical & Electrical) Should be quoted Separate to mount on the Machine/to operate the electromagnetic chuck.
12	Installation and commissioning	Installation, commissioning & proving of the unit to its desired capacity and complete at CSIR-CMERI CoEFM, Ludhiana 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.
13	Training	The OEM shall have to provide training exclusively for min one working day in the field of operation and maintenance.
14	Warranty & Service backup	The complete unit must have comprehensive onsite warranty for the date of successful commissioning for 12 months .
15	Documentation	2 hard copies of Operation & maintenance manual.
16	Important notes.	<p>Vendors should provide NUMERICAL VALUES in the technical document compliance sheet against the specification of CSIR-CMERI.</p> <p>Comments like YES, AGREED, CONFIRMED and WILL BE COMPLETED are not acceptable where numerical values are required to be quoted.</p>

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