



भारत सरकार टकसाल
INDIA GOVERNMENT MINT

भारत प्रतिभूति मुद्रण तथा मुद्रा निर्माण निगम लिमिटेड की एक इकाई
A Unit of Security Printing & Minting Corporation of India Limited
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A Miniratna Category-I, CPSE **CIN U22213DL2006G0I144763**



डी-2, सैक्टर-1, नोएडा

D-2, Sector-1, NOIDA

☎: 0120-4783116

ज़िला - गौतमबुद्ध नगर, उ. प्र.

Distt. Gautam Buddha Nagar (UP)

Fax: 0120-2537609

पिन 201301

PIN 201 301

email: igm.noida@spmcil.com

SPMCIL/India Government Mint Noida/Purchase/1/22-23/ET/13

DATED 23.05.2022

CORRIGENDUM - I

SUBJECT : SUPPLY, INSTALLATION & COMMISSIONING OF SIX COLOUR WEB (REEL) FEED WET & DRY OFFSET PRINTING MACHINE TO INDIA GOVT. MINT, NOIDA ON TURNKEY BASIS

**REFERENCE : NCB TENDER NO. SPMCIL/INDIA GOVERNMENT MINT NOIDA/PURCHASE/1/22-23/ET/13
DT. 28.04.2022**

The following amendments and addendum in NCB Tender No. SPMCIL/INDIA GOVERNMENT MINT NOIDA/PURCHASE/1/22-23/ET/13 DT. 28.04.2022 has been made :

Point	FOR	READ AS
TIME & DATE OF OPENING OF TENDERS	31.05.2022 (31st May 2022)	14.06.2022 (14th June 2022)
SECTION VI: LIST OF REQUIREMENTS	Required Completion Schedule: Delivery period & all work on turnkey basis within 7 (seven) months including Supply Installation, Commissioning	Required Completion Schedule: Delivery period & all work on turnkey basis within 12 (twelve) months including Supply Installation, Commissioning
SECTION VII TECHNICAL SPECIFICATION	Clause No. 14.14 Kiss-cut/Die-cut with matrix removal unit- Machine must be suitable to run for paper of 50 micron to 500 micron thickness with supported release paper.	Clause No. 14.14 Machine must be suitable to run the paper of 50-220 GSM.

ADDENDUM:

- Technical Specification Clause No. 13**
In case of Hologram Patch (HP), the minimum speed of the machine in this phase should be 60 strokes per minute.
- Technical Specification Clause No. 18.2**
 - Minimum 8 spools capacity should be provided in one rewinding shaft.
 - Further two rewinding shaft to be provided in slitter and rewinding unit.
- Technical Specification Clause No. 18.4**
Needs minimum 9 slitters (7 slitters for spool and two for side trimming)
- Technical Specification Clause No. 20**
Automatic paper cutting machine should be provided for trimming and cutting of sheets with maximum +/-0.50mm tolerance.
- Technical Specification Main functions of machine & page 19,20 & pt 5**
One auto splicer in input of phase-1 for reel loading
For more clarity the flow chart of the proposed machine is enclosed along with.

पंजीकृत कार्यालय: भारत प्रतिभूति मुद्रण तथा मुद्रा निर्माण निगम लिमिटेड

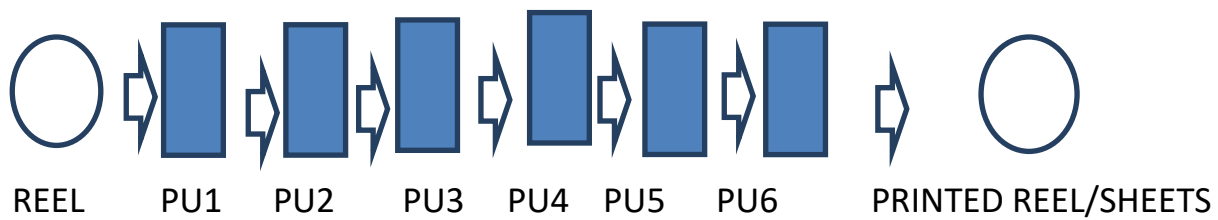
16वीं मंजिल, जवाहर व्यापार भवन, जनपथ, नई दिल्ली-110001

दूरभाष: 011-23701225-26, 43582200 फ़ैक्स: 011-23701223 ई-मेल: info@spmcil.com

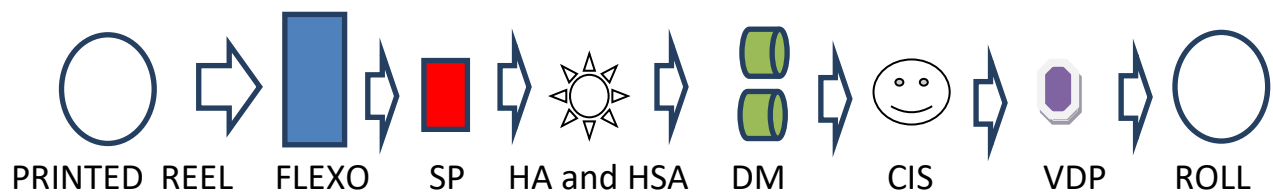
Flow-chart of EAL

PU-Printing Unit, SP- Screen Printing, DM-Die-cut & matrix Removal, HA-Hologram Applicator, HSA- Hologram strip applicator, VDP-Variable data Printing, CIS-Camera inspection system, MIS-Main inspection system

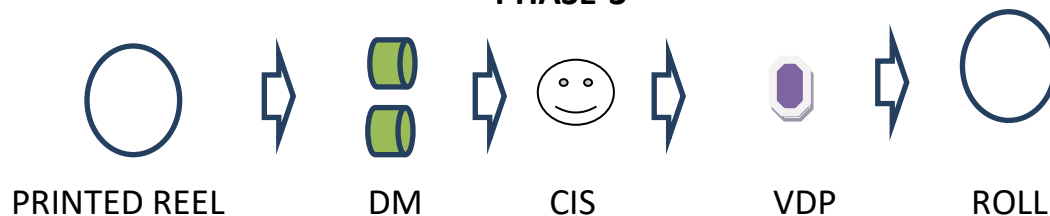
PHASE-1



PHASE-2



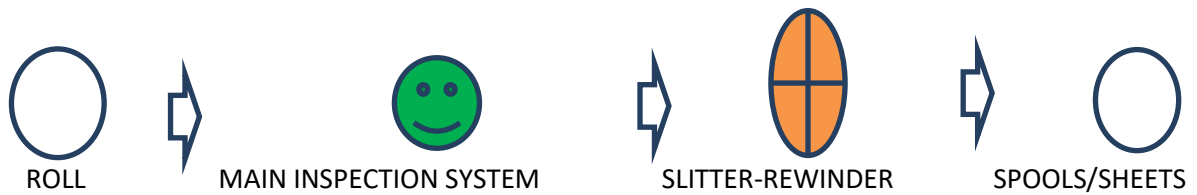
PHASE-3



PHASE-4 (Main Inspection System with checko App)



PHASE-5 (Main inspection system without checko App)



PHASE-6



INDIA GOVERNMENT MINT, NOIDA

PRE-BID QUERIES

NATIONAL COMPETITIVE BID (NCB) NO. SPMCIL/INDIA GOVERNMENT MINT NOIDA/PURCHASE/1/22-23/ ET/ 13 DT. 28.04.2022 FOR SUPPLY, INSTALLATION & COMMISSIONING OF SIX COLOUR WEB (REEL) FEED WET & DRY OFFSET PRINTING MACHINE TO INDIA GOVERNMENT MINT, NOIDA ON TURNKEY BASIS

1. M/s. Rotoffset Corporation

Section	Firm's Queries	Mint Reply
Section VI : Earnest Money, page no. 3 & at serial 11, EMD-amount Rs.15,16,000/- (Rupees Fifteen lakh sixteen thousand only)	Is the EMD amount requirements waived for MSME. Do we need to submit our udyog aadhar certificate in lieu of EMD ??	Yes
GCC clause No 6.1, 6.3 on page 14 PBG Demand Draft , from any scheduled..... 3% value of the purchase order	Are there any relaxations for tender requirements for MSME??	No
SCC 5: - Terms and Mode of payments & on page 15 90% release of payment after supply of goods	This being customized, turnkey project & due to Covid pandemic, slowdown, liquidity crunch, vendors are asking for 75-80% down payments. For our company to participate in the tender bid, we request for relaxation in payment terms.	The payment terms is as per our procurement manual hence cannot be relaxed.
SECTION VI: LIST OF REQUIREMENTS Required Completion Schedule: Delivery period & all work on turnkey basis within 7 (seven) months including Supply Installation, Commissioning	World over chip shortage , required for this turnkey & customized machine servos, PLC,HMI and other camera inspection equipment is forcing us to request relaxation for delivery time as per tender.	The proposal for extending delivery period to the tune of 12 months will be sent to the competent authority for approval.
SECTION VII: TECHNICAL SPECIFICATIONS & page 18, pt 11 Coated, Non-coated paper and self-adhesive paper	Please specify types of coating? Our machine cannot be used with thermal paper which is also a type of coated paper.	Coated paper means like silicon or PVA coated paper.

<p>3.Main functions of machine & page 19,page 18 SECTION VII: TECHNICAL SPECIFICATIONS page 23,26,31 hologram strip applicator</p>	<p>cannot offer this function, hologram applicator only in roll form</p>	<p>Must require.</p>
<p>3. Main functions of machine & page 19,20 & pt 5. Unwinder auto reel loader , 4. antilevered unwinder featuring lift- and-load system,4.5.Cantilevered unwinder featuring lift- and-load system. Two cantilevered, pneumatic spindles for use with three inch (76mm) internal diameter of cores.</p>	<p>provision for splicer in phase 1, for reel loading hydraulic trolleys are provisioned. the point 4,5 of the unwinder section is unclear as in phase 1 we are only offering splicer (unwinder) & cantilevered rewinder.</p>	<p>One auto splicer in input of phase-1 for reel loading For more clarity the flow chart of the proposed machine is enclosed along with.</p>
<p>b.Inking Systems pt 11 & page 21 Automatic washing system of blanket cylinder shall be provided.</p>	<p>Our machine has an attachment for roller wash device which can clean rollers while running machine but for blanket there is no such automatic devices. Some foreign machines offer this but it is ver,very expensive & not uneffective.</p>	<ol style="list-style-type: none"> 1. Automatic inking system should be provided. 2. Roller washing system should be provided. 3. Auto blanket washing system should be provided
<p>7.Specifications for wet and dry offset cassettes & page 21 automatic provision to control cut-off length of the printed sheet ,pt 5</p>	<p>this is unclear,please clarify</p>	<ol style="list-style-type: none"> 1. Six Dry offset cassettes, and six wet offset cassettes. Both should be provided in size 25 inches. 2. Automatic provision to control cut-off length of the printed sheet, pt 5. pt c, intake vacuum to hold/ control the final sheet is the part of sheeter. <p>By sheeter unit there should not be cutting variation</p>
<p>a. Automatic Sheeter unit page 22 c, intake vacuum to hold/ control the final sheet. pt d, Trimming exhauster should be capable to work on trim size 2mm to 20 mm.</p>	<p>this is unclear,please clarify</p>	<ol style="list-style-type: none"> 1. Point c. By sheeter after cutting movement of sheets must be controlled upto pile-board. 2. Point d. Trimming exhauster should work with trim size of 2mm to 20mm during roll to roll in phase-1 . 3. Trimming exhauster should also work during roll to spooling in phase-4 and phase-5 with trim size 2mm to 20mm. 4. There must be provision to replace roll to roll in phase-1 5. There must be provision to replace slitter and rewinder units in phase -4 and phase-5.
<p>Kiss-cut/Die-cut with matrix removal unit and page 24</p>	<p>Inbuilt heating chamber should be provided for easy removal of matrix which must be on/off with the machine and its temperature should be synchronizing with machine speed. Printed web should pass through this heating chamber. So that in case of any sudden stoppage, fire and smoke should not be occur.</p>	<p>For easy removal of matrix Inbuilt heating chamber should be provided which must be on/off with the machine and its temperature should be synchronizing with machine speed. Printed web should pass through this heating chamber in case of any sudden stoppage, fire and smoke should not be occurred.</p>

SECTION IX: QUALIFICATION/ ELIGIBILITY CRITERIA,page 33 (Financial Standing) average annual financial turnover of the bidder firm.....	to participate we need tender requirements of turnover to be relaxed for msme	Turnover is exempted for MSE firms.
17. Inline Variable data printing (VDP) & page 26 3.Resolution of inkjet system or latest system with minimum (600-600 DPI)	VDP with 300-600 dpi resolution can be offered	Resolution of inkjet system or latest system with minimum (600-600 DPI)

2. M/s. Condot System Private Limited

Section	Queries	Mint Reply
Section VI: List of Requirement Clauses no. 1: Delivery Schedule:	Query No.1 With the machine configuration, minimum delivery schedule time required is 16 months including installation, Commissioning and Training. Request for amendment.	The proposal for extending delivery period to the tune of 12 months will be sent to the competent authority for approval
Section-VII: Technical Specification		
Clause No. 2.7: Wet offset plate thickness 0.15 to 0.40 mm	Query No. 1 Our machine is designed for 0.15 mm thickness of Wet offset plates. It is not possible to design the machine with range of Wet offset plates. Please clarify.	Anyone thickness between this range is suitable.
Clause No.2.8: Dry offset plate thickness 0.43 to 0.73 mm	Query No. 1 Our machine is designed for 0.73 mm thickness of Dry offset plates. It is not possible to design the machine with range of Dry offset plates. Please clarify.	Anyone thickness between this range is suitable.
Clause No.3.2.2(b) The second phase shall cover - One unit of flexography printing with one inline rotary screen printing, one inline hologram applicator and hologram strip applicator, one inline kiss-cut/Die-cut with matrix removal, one inline variable data printing (VDP) numbering and Bar-coding/QR Coding and one camera inspection system. The minimum speed of the machines in this phase should be 45 meter/min. & Clause No. 13: Inline Hologram Applicator and Strip Applicator:	Query No. 1 For excise labels, inline Hologram application is not possible. With inline Hologram application the required speed cannot be achieved. Also the small size of hologram patch is not available which can fit and applied on excise labels. Additional details Hologram application provided by the firm vide their email dt. 18.05.2022 is : Hologram Stripe (HS) application and Hologram Patch (HP) application: 1. HS application will be one unit and HP application will be another unit. 2. They are two separate technologies; the HS application is in rotary form, whereas HP application is in flat form.	1. Both hologram applicator and hologram strip applicator is required. 2. Camera inspection system is before VDP system in both phases two and three. (refer flow chart) 3. Bad Labels should not be numbered (as described in point no.3 at page no.19) 4. Bad labels will be removed in fourth and fifth phases during main inspection system. 5. Hologram applicator should be run with minimum 10 x 10 mm size. 6. In case of Hologram Patch (HP), the minimum speed of the machine in this phase should be 60 strokes per minute.

	<p>3. It is possible to have these two stations in one machine, to give customer opportunity to have multiple jobs application in one machine.</p> <p>4. The speed is strictly tied to the hologram (HS & HP) quality and its reaction to these factors are: glue reaction at temperature, and release according to a specific speed. With a good hologram patch it is possible to achieve maximum 60 strokes per minute for the HP applied in flat.</p> <p>5. For liquor tax labels only HS application is recommended and not hologram patch because of speed and size of the patch. World over on liquor tax labels HS is applied and not HP.</p> <p>Query No. 2 If inline VDP is combined in second phase (before inspection - forth phase), then VDP barcode and numbering will be done also on bad quality labels, missing labels etc. Please advice the work flow</p>	
<p>Clause No. 3.2.2(c): The third phase shall cover - One kiss-cut/Die-cut with matrix removal and one-inline Variable Data Printing (VDP) Numbering & Bar-Coding/QR Coding and one line Camera Inspection System. The minimum speed of the machines in this phase should be 60 meter/min.</p>	<p>Query No. 1 If inline VDP is combined in third phase (before inspection-fifth phase), then VDP barcode and numbering will be done also on bad quality labels, missing labels etc. Please advice the work low</p>	<p>1.Camera inspection system is before VDP system in both phases two and three.</p> <p>2. Bad Labels should not be numbered (as described in point no.3 at page no.19).</p> <p>3. Bad labels will be removed in fourth and fifth phases during main inspection system.</p> <p>4. The minimum speed of the machine in this phase should be 60 meter/min.</p>
<p>Clause No.11.1: Rotary Flexographic Printing /Section VII 12.5 Inline Rotary Screen Printing: Camera inspection system should be control/register to all rotary flexography printing, rotary screen printing, Hologram Applicator and Hologram strip applicator, die-cut and VDP system from one common monitor/place in second phase. & Clause no. 15: Camera Inspection system:</p>	<p>Query No. 1 Camera inspection system cannot do control/registration job.</p> <p>Query No.2 VDP system is controlled by its own control device and not by camera system.</p> <p>Query No. 3 It mentions that the main function of camera inspection is to control quality of the product - Please confirm whether print quality also to be done.</p> <p>Query No. 4 Clause 15.8 mentions the missing label details shall be listed and stored in a separate log file - Please elaborate what details needs to be stored of missing labels.</p>	<p>1. Camera system should control all activities of second phase like Flexo print, screen print, hologram, die-cut and VDP.</p> <p>2. VDP should be done only at good labels as controlled by camera inspection system (as described in point no.3 at page no.19).</p> <p>3. Camera system should control to all activities of second phase for VDP printing. All activities of second phase Flexo print, screen print, hologram, die-cut and VDP should be controlled from one point by separate screens.</p> <p>4. Missing label details shall be listed and stored in a separate log file. Like Number of labels (Page No.25, point no.15.9)</p>
<p>Clause No. 11.5: Rotary Flexographic Printing: Anilox roller should be provided with 600-</p>	<p>Query No. 1 1 Anilox roller has 1 screen size. Please provide the required Anilox screen size.</p>	<p>A minimum 600 anilox screen should be provided for anilox roller in flexo unit.</p>

1200 Anilox screen size. (With one stand by Anilox roller).		
Clause no. 14.14: Kiss-cut/Die-cut with matrix removal unit- Machine must be suitable to run for paper of 50 micron to 500 micron thickness with supported release paper.	Query No. 1 500 micron appears to be typo error and is in contradiction with the printing substrate defined in 2.12. Please amend this clause suitably.	Machine must be suitable to run the paper of 50-220 GSM.
Clause no. 18.2: Slitter and rewinder Unit (Spooling Unit)- The slitter and rewinder Unit must have spooling capacity of 6 to 12 spools at a time in one shaft. Two rewinding shafts should be provided.	Query No. 1 The maximum number of labels across the web is 6 Nos. with 3 spools on each shaft.	1. Minimum 8 spools capacity should be provided in one rewinding shaft. 2. Further two rewinding shaft to be provided in slitter and rewinding unit.
Clause no. 18.4: Slitter and rewinder Unit (Spooling Unit)- Required set of slitters (for 6 to 12 ups) should be provided before rewinder.	Query No. 1 Maximum slitter required is 7 Nos (5 Nos. slitter for spools and 2 Nos for side trimmers).	Needs minimum 9 slitters (7 slitters for spool and two for side trimming)
Clause no. 20: Automatic Paper Cutting Machine	Query No. 1 Please let us know the required cutting accuracy.	Automatic paper cutting machine should be provided for trimming and cutting of sheets with maximum +/-0.50mm tolerance.
Clause no. 21: General technical specifications- If applicable, the firm has to provide CAMC (Comprehensive annual maintenance charge) for three years after warranty periods.	Query No. 1 The CAMC is not acceptable due to lot of wear and tear parts (moving parts), reliability of many parts depend on skill of operators. Regular maintenance of machine also define the life of the mechanical as well as pneumatic parts. Hence we are not able to quote the CAMC as optional.	It is optional and evaluation will be done based on the price quoted for machine on turnkey basis.