

# **THE PORT AUTHORITY OF NY & NJ**

**PROCUREMENT DEPARTMENT  
4 WORLD TRADE CENTER  
150 GREENWICH STREET, 21<sup>ST</sup> FL.  
New York, NY 10001**

04/20/2016

## **ADDENDUM #1**

To prospective Bidder(s) on Bid # 45653 for Retrofit/overhaul of Control Apparatus of Atlas Wheel Truing Lathe for Port Authority Trans-Hudson (PATH) at Harrison Car Maintenance Facility, Harrison, New Jersey

Now Due back on 05/04/2016, no later than 11:00 AM

Original due on 04/27/2016, no later than 11:00 AM

**The following changes/modifications are hereby made to the solicitation documents:**

### **I. PART V – SPECIFICATIONS**

**Revisions as follows:**

- 1. Insert Attachment #1 dated 04/19/2016 entitled “Extra Work” into PART III. Paragraph 8, pages 14 and 15.**
- 2. Insert into Part V-5 Paragraph 2. Work Required by the Specifications, B. Description of Work Required , Section 1.as the first item the following requirement: Replace the entire 4 door panel including all internal components with new compatible unit.**
- 3. Insert into Part V-5 Paragraph 2. Work Required by the Specifications, B. Description of Work Required, Section 3.f. after the words: Existing probe hardware include: removing existing probe system and replace with new probing system.**

### **II. BIDDER'S QUESTIONS AND ANSWERS**

The following information is available in response to questions submitted by prospective Bidders. The responses should not be deemed to answer all questions, which have been submitted by Bidders to the Port Authority. It addresses only those questions, which the Port Authority has deemed to require additional information and/or clarification. The

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fact that information has not been supplied with respect to any questions asked by a Bidders does not mean or imply, nor should it be deemed to mean or imply, any meaning, construction, or implication with respect to the terms.

The Port Authority makes no representations, warranties or guarantees that the information contained herein is accurate, complete or timely or that such information accurately represents the conditions that would be encountered during the performance of the Contract. The furnishing of such information by the Port Authority shall not create or be deemed to create any obligation or liability upon it for any reason whatsoever and each Bidder, by submitting its Bid, expressly agrees that it has not relied upon the foregoing information, and that it shall not hold the Port Authority liable or responsible therefore in any manner whatsoever. Accordingly, nothing contained herein and no representation, statement or promise, of the Port Authority, its Commissioners, officers, agents, representatives, or employees, oral or in writing, shall impair or limit the effect of the warranties of the Bidder required by this Bid or Contract and the Bidder agrees that it shall not hold the Port Authority liable or responsible therefore in any manner whatsoever.

The Questions and Answers numbering sequence will be continued sequentially in any forthcoming Addenda that may be issued.

<b><i>Question #1</i></b>	Are elementary schematic diagrams were available for reference. These drawings show the machine wiring between all devices and their connection points. This presents a problem quoting system replacement. If drawings are not available for the retrofit, the system must be reverse engineered, requiring considerable engineering time.
<b><i>Answer # 1</i></b>	No.
<b><i>Question #2</i></b>	If you have located the drawings can we get a copy
<b><i>Answer #2</i></b>	They are not available.
<b><i>Question #3</i></b>	Please confirm incoming power is 480/3/60 and wye connected for balanced phases, or detail what it actually is.
<b><i>Answer #3</i></b>	Incoming power is: Yes 480/3/60
<b><i>Question #4</i></b>	Are there any transformers in line between the building power source for machine and the connection point at main panel / Observed the main power coming up from under the floor via a large sized conduit.
<b><i>Answer #4</i></b>	No
<b><i>Question #5</i></b>	Can we get the name plate data off that transformer?

<b>Answer #5</b>	No transformers from junction box on the building wall to wheel machine input cables
<b>Question #6</b>	If changes are required for the building power to the machine based on the upgrades being done who is responsible for this change in wiring between the building power source and the main disconnect located at machine panel?
<b>Answer #6</b>	We do not foresee any changes to the power source, all input stays the same.
<b>Question #7</b>	We need the part number and name plate details of the <del>four</del> servo motors including speed and torque characteristics.
<b>Answer #7</b>	Servo motor data: Two servo motors with built on shaft encoders 6FC9320 for “X” and “Z” axis.....SIEMENS Incremental Encoders, 6FX2001-2CC50, ID-521 285-38, Serial # 38 695 787 A, PPR...2500, Volts...5V+ -10%, Signals ...TTL
<b>Question #8</b>	Please verify the total number of servo motors on this machine for driving the machine axes?
<b>Answer #8</b>	See Answer # 7.
<b>Question #9</b>	Describe: Vertical Mounted Motors... Two Probing motors
<b>Answer # 9</b>	Boston Motor, CAT# PM 925AT-3, Spec# 33-20 13Z113, HP .25, 0.18KW, RPM 1750, Volts 90, Amps 2.5, Frame 56C, Type 3320P, ENCL. TENV, DC Permanent Magnet motor, Reversing. Dynamic braking.
<b>Question #10</b>	Please verify the functionality of the external vertically mounted motors that are located on the right and left tool post blocks.
<b>Answer #10</b>	These two motors function as the “Q”axis. Moves tool post simultaneously and individually.
<b>Question #11</b>	Need name plate data off these motors also?
<b>Answer #11</b>	See Answer #9.
<b>Question #12</b>	The specification calls for a Fanuc digital spindle system. The machine currently has two large DC motors, one on each headstock. We require the existing motor details including HP, base speed, top speed, and other pertinent nameplate data.
<b>Answer #12</b>	Headstock Drive DC motor details Main spindle drive comprises of two 50 HP AC motors, Hawker Siddeley Electric, 37.5KW, Variable speed, RPM 1185, Volts 480, Phase 3, Type TEFC, Amps 62, HZ 60, Frame 7P-L444T, Model# T771B-2. Cutting speed 1000/2000 rpm, Probing speed 400 rpm
<b>Question #13</b>	The specification calls for replacing all old wires, cabling, and

	wiring harnesses. Does this mean rewiring every component on the lathe? Console, CNC, spindle and servo motors wiring will be new, along with all wiring from the new main control cabinet to the first junction box on the lathe. During a normal field retrofit its generally inspect all wiring to each device on the machine and only replace what is required. What will be acceptable.
<b>Answer #13</b>	Console, CNC, spindle, associated limit switches, probing and servo motors wiring will be new, along with all wiring from the new main control cabinet to the first junction box on the lathe. Other wiring will be inspected and replace if necessary.
<b>Question #14</b>	The remote pushbuttons, for example on each headstock, seem to function properly. Are they to be replaced?
<b>Answer #14</b>	No.
<b>Question #15</b>	There was discussion of replacing some of the mechanical limit switches for the axes. There are quite a few other limit switches. - Exactly which switches are to be replaced.
<b>Answer #15</b>	Those relating to the programming and axis. There are 5 limit switches.
<b>Question #16</b>	The probes that determine depth of cut are reported to not have functioned properly for some years. They should be replaced and made functional. This will require some mechanical modifications.
<b>Answer #16</b>	See above Revisions to Specifications

<b>Question #17</b>	We need to understand the function of the two Q axes. Please explain their functionality as related to the wheel machining process
<b>Answer #17</b>	They are used in referencing the machine. When probing the tool slide and either the LH or RH tool slide made the limit switch, the “Z” axis motor stops. The slide which has not reach it’s reference point must be traversed there by means of the “Q” traverse push button.
<b>Question #18</b>	Part programs and subprograms need to be converted to the proper format for the new CNC. Please verify that this will be for the three wheel types currently used
<b>Answer #18</b>	Yes part programs and subprograms. Also we must have the ability to write new programs for different sizes and profiles for wheels, if necessary in the future
<b>Question #19</b>	Reserved
<b>Answer #19</b>	Reserved
<b>Question #20</b>	The current CNC system is a Siemens 840C with Step5 PLC

	programming, and parametric part programs. The specification calls for a Fanuc 0i-TD system with no equals or substitutes. It is possible that new Siemens servo motors may be a direct replacement.
<i>Answer #20</i>	Use Fanuc as specified.
<i>Question #21</i>	If we are required to bid to specification only (Fanuc) are we allowed to submit a secondary offer using other components.
<i>Answer #21</i>	Use Fanuc as specified. <b>No secondary offers.</b>
<i>Question #22</i>	Do you want to include new main panel as described above as part of your work required specification?
<i>Answer #22</i>	See above Revisions to Specifications
<i>Question #23</i>	Custom screens were requested to simplify program selection. Can you confirm what kind of data input is required to select the different programs.
<i>Answer #23</i>	Part programs and subprograms. Ability to convert to inches, mm, wheel tape sizes.
<i>Question #24</i>	Programs will have to be converted to standard Fanuc G code programming. How many programs are there?
<i>Answer # 24</i>	No conversion is necessary since we will have new controls and new Fanuc system. Existing Siemens programming will be replaced with new Fanuc G code program. We need to have the ability to enter the required wheel size after probing and input the amount of passes, depth of cut and the machine should produce the required wheel sizes.
<i>Question #25</i>	the current electrical prints for the machine going to be made available?
<i>Answer #25</i>	Not available
<i>Question #26</i>	A new probing system is needed for identifying the position offsets and wheel flange locations. Please provide a description of what the current system is used for?
<i>Answer #26</i>	The current system picks up where the wheels are in relation to tooling to provide for both wheels being machined simultaneously. It provides a starting point, so the operator can use that measurement as a datum when entering depth of cut and check on amount to be removed.

THE PORT AUTHORITY OF NY & NJ

SELENE ORTEGA, MANAGER  
COMMODITIES AND SERVICES DIVISION  
PROCUREMENT DEPARTMENT

BIDDER'S FIRM NAME: \_\_\_\_\_

INITIALED: \_\_\_\_\_

DATE: \_\_\_\_\_

QUESTIONS CONCERNING THIS ADDENDUM MAY BE ADDRESSED TO  
LARRY WAXMAN, WHO CAN BE REACHED AT (212) 435-4639 OR AT  
[LWAXMAN@PANYNJ.GOV](mailto:LWAXMAN@PANYNJ.GOV)

## 8. Extra Work

The Contractor is required to provide separate materials, supplies, equipment and personnel for Extra Work when such is deemed necessary by the Superintendent/Manager. "Extra Work" as used herein shall be defined as work which differs from that expressly or impliedly required by the Specifications in their present form. Total Extra Work performed by the Contractor shall not exceed six percent (6%) of the Total Estimated Contract Price of this Contract for the entire Term of this Contract including extensions thereof, or six percent (6%) of the Total Estimated Contract Price of each Section if this Contract is awarded by separate Sections.

An increase in area or frequency does not constitute Extra Work, but shall be compensable based on the prices in the Pricing Sheet(s) and the paragraph herein titled "Increase or Decrease in Areas or Frequencies".

The Contractor is required to perform Extra Work pursuant to a written order of the Superintendent/Manager expressly recognizing such work as Extra Work. If Lump Sum or Unit Price compensation cannot be agreed upon by the parties in writing prior to the start of Work, the Contractor shall perform such Extra Work and the Contractor's compensation shall be increased by the sum of the following amounts and such amounts only: (1) the actual net cost, in money, of the labor and material, required for such Extra Work; (2) ten percent (10%) of the amount under (1) above; (3) such rental as the Manager deems reasonable for plant and equipment (other than small tools) required for such Extra Work; (4) if the Extra Work is performed by a subcontractor, an additional five percent (5%) of the sum of the amounts under (1) through (3) above.

As used in this numbered clause (and in this clause only):

"Labor" means laborers, mechanics, and other employees below the rank of supervisor, directly employed at the Site of the Work subject to the Superintendent/Manager or their designee's authority to determine what employees of any category are "required for Extra Work" and as to the portion of their time allotted to Extra Work; and "cost of labor" means the wages actually paid to and received by such employees plus a proper proportion of (a) vacation allowances and union dues and assessments which the employer actually pays pursuant to contractual obligation upon the basis of such wages, and (b) taxes actually paid by the employer pursuant to law upon the basis of such wages and workers' compensation premiums paid pursuant to law. "Employees" as used above means only the employees of one employer.

"Net Cost" means the Contractor's actual cost after deducting all permitted cash and trade discounts, rebates, allowances, credits, sales taxes, commissions, and refunds (whether or not any or all of the same shall have been taken by the Contractor) of all parts and materials purchased by the Contractor solely for the use in performing its obligation hereunder provided, where such purchase has received the prior written approval of the Superintendent/Manager as required herein. The Contractor shall promptly furnish to the Superintendent/Manager such bills of sale and other instruments as the Superintendent/Manager may require, executed, acknowledged and delivered, assuring to the Superintendent/Manager title to such materials, supplies, equipment, parts, and tools free of encumbrances.

“Materials” means temporarily-installed and consumable materials as well as permanently-installed materials; and “cost of materials” means the price (including taxes actually paid by the Contractor pursuant to law upon the basis of such materials) for which such materials are sold for cash by the manufacturers or producers thereof, or by regular dealers therein, whether or not such materials are purchased directly from the manufacturer, producer or dealer (or if the Contractor is the manufacturer or producer thereof, the reasonable cost to the Contractor of the manufacture and production), plus the reasonable cost of delivering such materials to the Site of the Work in the event that the price paid to the manufacturer, producer or dealer does not include delivery and in case of temporarily-installed materials, less their salvage value, if any.

The Superintendent/Manager shall have the authority to decide all questions in connection with Extra Work. The exercise by the Superintendent/Manager of the powers and authorities vested in him/her by this section shall be binding and final upon PATH and the Contractor.

The Contractor shall submit all reports, records and receipts as are requested by the Superintendent/Manager so as to enable him/her to ascertain the time expended in the performance of the Extra Work, the quantity of labor and materials used therein and the cost of said labor and materials to the Contractor.

The provisions of this Contract relating generally to Work and its performance shall apply without exception to any Extra Work required and to the performance thereof. Moreover, the provisions of the Specifications relating generally to the Work and its performance shall also apply to any Extra Work required and to the performance thereof, except to the extent that a written order in connection with any particular item of Extra Work may expressly provide otherwise.

If the Contractor deems work to be Extra Work, the Contractor shall give written notice to the Superintendent/Manager within twenty-four (24) hours of performing the work that he so considers as Extra Work, and failure of the Contractor to provide said notice shall constitute a waiver of any claim to an increase in compensation for such work and a conclusive and binding determination that it is not Extra Work.

The Contractor shall supply the amount of materials, supplies, equipment and personnel required by the Superintendent/Manager within three (3) business days following the receipt of written or verbal notice from the Superintendent/Manager, or in the case of an emergency as determined by the Superintendent/Manager, within one (1) business day following the receipt by the Contractor of the Superintendent/Manager’s written or oral notification. Where oral notification is provided hereunder, the Superintendent/Manager will thereafter confirm the same in writing. All Extra Work shall be billed to PATH on a separate invoice on a monthly basis.

PART III-15  
