

**DEPARTMENT OF PRODUCTION ENGINEERING
NATIONAL INSTITUTE OF TECHNOLOGY: TIRUCHIRAPPALLI - 620 015**

08.02.2017

Minutes of the pre-bid conference

Tender Notification No.: NITT/F.No: 020/PLAN/2016-17/PRO

dt: 13-01-2017

With reference to the above tender notification and the pre-bid conference held on 08.02.2017 at 3.00 PM in the committee room of Production department, the following amendments are made.

Specification for Co-axial laser cladding head with necessary accessories

Original tender specification	Corrections/additions/amendments after the Pre-bid meeting
A. Cladding Head	.
Laser power capability : 3 kW (minimum)	No Correction
Nozzle types required: 2 Nos. a) Co-axial 4 way (for 3D processing): Powder focus diameter: 2.0 mm max) b) Co-axial annular: Powder focus diameter: 0.7 mm (max)	Nozzle types required: 1 2 Nos. a) Co-axial 4 way (for 3D processing): Powder focus diameter: 2.0 mm max) b) Co-axial annular: Powder focus diameter: 0.7 mm (max)
Typical grain size of powder usable with the provided nozzle: 20 – 200 µm	No Correction
Allowable beam defocus: 5 mm (minimum)	No Correction
Stand-off distance: 20 – 25 mm	No Correction
Focal position adjustment: Motorized	No Correction
Other mandatory accessories: Camera module, beam splitter module, water cooled focusing lens and protective glass cartridge with a possibility of monitoring the protective window. The supply should also include necessary adaptors and accessories to integrate with the existing laser system. Optional Accessories: Any accessories other than the mentioned above should be quoted separately	No Correction
B. Powder feeding Unit	
Number of feed hoppers : 2 (Minimum)	No Correction
Number of outlets/ hopper : 2 (Minimum)	No Correction
Variable feed rate: 1-50 g/min (Minimum acceptable range)	Variable feed rate: 1-50 g/min 1-15 g/min (Minimum acceptable range)
Hopper size : 0.5 Liter (each) (Minimum)	No Correction
Feed control unit : Separate digital mass flow controller for each feeder (PLC based with monitor/touch screen for user interface)	No Correction
Usable powder grain size : 20 – 200 µm	No Correction
Operational mode : Remote (Ethernet based data exchange between the controller and the feeder)	No Correction

