Technical Specifications (In-Cash Procurement)

New Up Ending Tool anchor plate Type A - Technical summary

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1 Purpose

This document is prepared to provide technical summary for the manufacturing of 4 sets of base plates type A.

2 Scope of Work

Scope of works for the Contractor and IO can be summarized as below table.

[Work Scope of the Contractor]

No	Description	Remark
1	Design –2D GA drawing	
2	Design –2D Manufacturing drawing	
3	Purchase of raw materials	
4	Manufacturing of four (4) sets of Base Plates	
5	NDE	
6	Painting	
7	Cleaning and packing	
8	Delivery to IO site	
9	Declaration of CE mark as manufacturer	
10	Documentation	

[Work Scope of IO]

No	Description	Remark
1	Design – Concept drawing only	

Under this scope of work, IO has no free issue items for the Contractor.

2.1 Scope of Supply

2.1.1 General Description

1) Name: Base plate type A for new upending tool
2) Quantity: 4 sets
3) Materials: Structure - S355JR / Pin - 42CrMo4
4) Overall dimension: 1,300mm(w) x 1,300mm(D) x 950mm (h) / set
5) Mass: net approx.1,900 kg per set

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2.1.2   Technical Requirements

1) Quality Class: 1 (100% VT, UT, MT for full penetration welding / 100% VT, MT for fillet welding)
2) Paint specifications

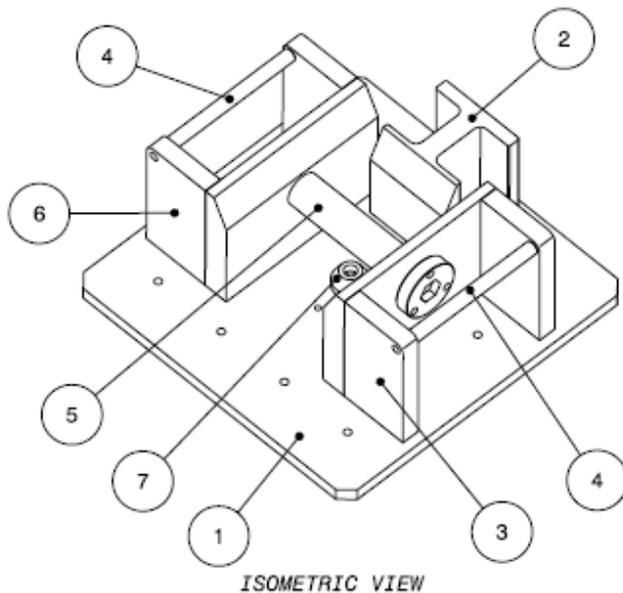| Application	Surface preparation	Painting system	NDFT (μm)
Carbon steel - Steel structure - Interior and exterior of the structural steels - All surfaces of noncorrosive carbon steel	Cleanliness: Sa 2 ½ Roughness: Grade Medium G (50-85 μm Ry5)	Epoxy Shop Primer I.Z.P or E.Z.P Epoxy Intermediate Acrylic Urethane Total MDFT(μm)	>40 >100 >60 >200

3) Code for tolerance control

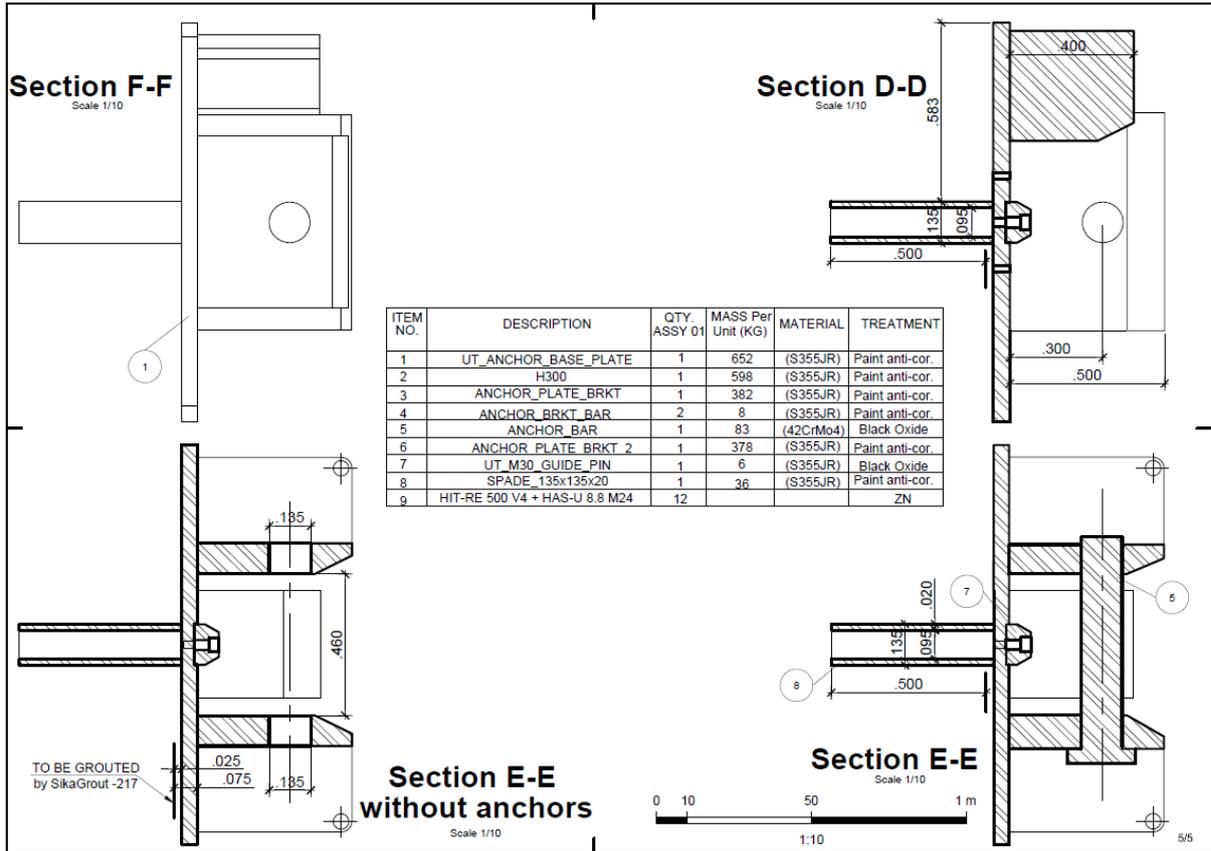| Ref	Title	Doc Ref.	Version
1	General tolerance for machining (Class m)	EN ISO 2768-1	Ed.1989
2	General tolerances for welded constructions (Class B)	EN ISO 13920	Ed.2023

2.1.3   Concept drawing

Below drawing is provided only for Prior Information Notice (PIN), first step of the Open Tender. Detail dimensions may be subject to modification to improve the efficiency of assemble work. Final drawings will be provided in the technical specifications, when launching the tender.


ISOMETRIC VIEW

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Section F-F
Scale 1/10

Section D-D
Scale 1/10

ITEM NO.	DESCRIPTION	QTY. ASSY 01	MASS Per Unit (KG)	MATERIAL	TREATMENT
1	UT_ANCHOR_BASE_PLATE	1	652	(S355JR)	Paint anti-cor.
2	H300	1	598	(S355JR)	Paint anti-cor.
3	ANCHOR_PLATE_BRKT	1	382	(S355JR)	Paint anti-cor.
4	ANCHOR_BRKT_BAR	2	8	(S355JR)	Paint anti-cor.
5	ANCHOR_BAR	1	83	(42CrMo4)	Black Oxide
6	ANCHOR_PLATE_BRKT_2	1	378	(S355JR)	Paint anti-cor.
7	UT_M30_GUIDE_PIN	1	6	(S355JR)	Black Oxide
8	SPADE_135x135x20	1	36	(S355JR)	Paint anti-cor.
9	HIT-RE 500 V4 + HAS-U 8.8 M24	12			ZN

TO BE GROUTED
by SikaGrout -217

**Section E-E
without anchors**
Scale 1/10

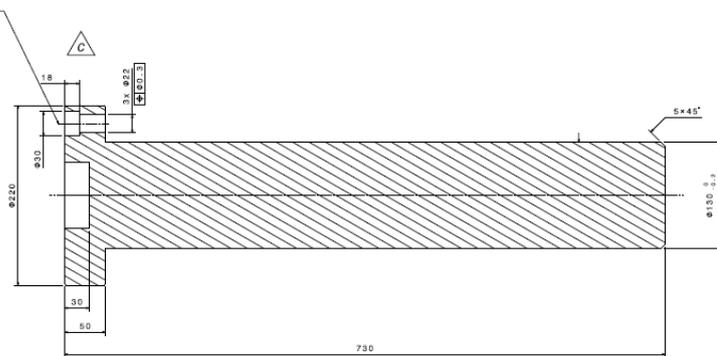**Section E-E**
Scale 1/10

1:10

HEX SOCKET BOLTS (M16 CLASS 8.8) NEED TO BE SUPPLIED BY CONTRACTOR
LENGTH OF M16 BOLTS CAN BE SELECTED BY CONTRACTOR

ISOMETRIC VIEW
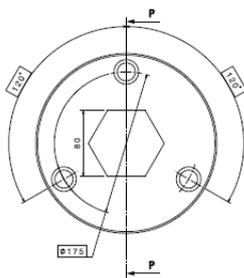
FRONT VIEW

SECTION VIEW P-P

2.1.4   Delivery Time

The maximum expected duration from the contract signature to the supply of the scope of work is [3] months.

3   Location for Scope of Work Execution

The location where the work shall be performed can be defined as follows:
- ✓ Manufacturing design and Manufacturing: Contractor's own location
- ✓ Delivery; to IO site.

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4   List of deliverables

The list of deliverables will be further developed in the technical specifications.

You can find here below a minimum list of documents, but not limited to, that will be required within the expected timing:

Technical Design Family (TDF)	Generic Document Title (GTD)	Further Description	Expected Timing (T0+x) *
Contract Management	Quality Assurance Plan	Kick off meeting	2weeks
Contract Management	Subcontractor Approval Form (SAF) in required	Kick off meeting	2weeks
Contract Management	Contract Schedule	Kick off meeting	2weeks
Assembly or Component Definition Drawing	Manufacturing drawing	Manufacturing Readiness Review	4 weeks
Other Manufacturing Input	Welding Procedure Specification	Manufacturing Readiness Review	4 weeks
Other Manufacturing Input	Welding Procedure Qualification Record	Manufacturing Readiness Review	4 weeks
Other Manufacturing Input	NDE procedure	Manufacturing Readiness Review	4 weeks
Other Manufacturing Input	Welder qualification procedure	Manufacturing Readiness Review	4 weeks
Inspection and Test Record or Report	Paint procedure	Manufacturing Readiness Review	4 weeks
Inspection and Test Record or Report	Surface treatment procedure	Manufacturing Readiness Review	4 weeks
Verification and Validation Plan	Quality Plan	Manufacturing Readiness Review	4 weeks
Other Manufacturing Input	Manufacturing and Inspection Plan	Manufacturing Readiness Review	4 weeks

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Other Manufacturing Input	Welding Map	Manufacturing Readiness Review	4 weeks
Review or Decision or Recommendations Report	Manufacturing Readiness Review Report	After MRR	5 weeks
Other Manufacturing Input	Manufacturing and Inspection Plan (Signed)	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	Certificate for materials	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	Calibration Record	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	Dimension Check Sheet	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	paint inspection report	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	NDE report	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	Qualified welder list	Delivery Readiness Review	12 weeks
Inspection and Test Record or Report	Certificate for welding consumables	Delivery Readiness Review	12 weeks
Bill Of Material-BOM	Bill of Materials	Delivery Readiness Review	12 weeks
Shipping or Logistics Record	Contractor Release Note.	Delivery Readiness Review	12 weeks
Shipping or Logistics Record	Delivery Report	Delivery Readiness Review	12 weeks
Shipping or Logistics Record	Packing List	Delivery Readiness Review	12 weeks
Shipping or Logistics Record	Equipment Storage & Preservation Requirements	Delivery Readiness Review	12 weeks

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Shipping or Logistics Record	Declaration of conformity- CE mark	Delivery Readiness Review	12 weeks
Shipping or Logistics Record	Lifting information for every cargo	Delivery Readiness Review	12 weeks

(*) T0 = Commencement Date of the contract ; X in weeks.