

**REQUEST FOR PROPOSALS #2020-066  
4 Axis Turning Center  
RESPONSE ADDENDUM #1  
May 1, 2020**

**CLARIFICATION**

**THE FOLLOWING REQUIREMENTS REPLACE THE CORRESPONDING RFP SPECIFICATIONS FOR ACCURACY AND REPEATABILITY:**

**Precision and Guideway Parameters**

- Linear bi-directional positioning error, **parameter A**, for linear axes per **ISO 230-2: .0004” or less.**
- Please include factory calibration procedures and inspection specifications (geometric errors as well as linear) for the proposed machine along with an estimate of the machine’s volumetric accuracy. These reports will be required to be made available to UMaine AMC prior to delivery.

**Part Run-off Requirement**

- Machine one piece **M3\_80** per **ISO 10791-7:2020** from **6061-T6 Aluminum** at factory before shipping and at UMaine AMC upon delivery. Inspection to be performed on a CMM of traceable calibration. This test is primarily to verify the machines milling capabilities and additional axes.
- Include factory’s standard turning run-off part with supporting documents including dimensions and tolerances. If this part meets similar requirements to M3\_80, UMaine AMC may waive the above requirement.

**QUESTIONS**

**Q1: Listed on Page 5 under Machine Delivery and Set-up Instructions, regarding part run-off to ISO 10791-7:20:**

**This is not a test typically done on our lathe products. However, we can use a CDS (Circle, Diamond Square) method prior to shipment and duplicated on your floor. I have attached a PDF doc with description.**

**Please confirm:**

- **Is this acceptable?**
- **How will U Maine check this at your facility? (hand gauges, CMM...etc)**

**A1: The included PDF is acceptable. It will be checked by a CMM. Depending on when machines are delivered it will be either performed on our own CMM or will be inspected at a local shop.**