

REQUEST FOR PROPOSALS #2024-054
Pultrusion Equipment Purchase
RESPONSE ADDENDUM #2
February 9, 2024

QUESTIONS

Q1: The RFQ mentions integration with an existing control system (1.1.3).

- What function of the new puller and saw units are to be integrated with the existing controls?

A1: The puller and saw will have to integrate the following functions with the base machine:

Line speed and process start / stop coordination.

Max pull force and required double grip pulls.

Cut-off section length.

Other operational parameters (grip force, travel limits if required, cutting parameters, heartbeat for both puller and cut-off).

Safety functionality, bi-directional (puller and saw can stop the base machine, base machine can stop the puller and saw).

- What control platform is being used and what is the preferred communication method? (i.e. Modbus, OPC UA, Ethernet TCP, etc.)

A1: The base machine is communicating using EtherCAT, which is the preferred communication method.

The handoff between the machines can be over a different communication protocol if needed, Beckhoff provides interfacing for various fieldbuses.

Q2: The RFQ calls for a saw as a separate module.

Can the saw use the puller section controls for operational processing, or does the saw need to be completely independent of the pullers?

- A “stand-alone” saw would have its own on board logic processor and could function independent of any other equipment. This option increases costs due to the size and complexity of the on-board controls.
- A “tethered” saw would rely on the puller controls for logic processing via a simple ethernet connection, and is therefore a less expensive option.
- Both options include the saw as a separate module from the pullers in terms of an independent frame with its own leveling which can be disconnected from the puller section.

A2: The saw may use the puller controls for operational processing; however the puller must be operational without the saw. In other words, the saw would only be in use with the



[puller, but the puller may be in use without the saw. Based on the provided descriptions it seems as though both stand alone or tethered would fit our needs.](#)

Q3: I interpret the request for a puller section, without mention of a die stand or any provisions for heaters or heater controls, to mean that these features are not in the scope of the request. Is this correct?

A3: [The Interpretation is Correct. Die stands nor heaters/heater controls are not in the scope of the request.](#)