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Ref No.: SY-15-13-VDP-1/2024 **Date: 05.03.2025**

CORRIGENDUM-4

Reference: ISP GeM Bid No.GEM/2024/B/5739448 dated 13.01.2025 floated by ISP-Nasik for 'Procurement of UV Variable Printing & Slitting Machine' (Qty.: One No.).

In context with the above referred ISP GeM Bid, the following amendments are hereby authorized to be read as:

A] Amendment w.r.t.: (i) Bid End date & time and (ii) Bid Opening date & time:

Sr. No.	Particulars	For	Read as
1)	Bid End Date/Time	**11-03-2025** 16:00:00	**25-03-2025** 16:00:00
2)	Bid Opening Date/Time	**11-03-2025** 16:30:00	**25-03-2025** 16:30:00

B] Amendment w.r.t.: Technical Specifications:

Sl. No.	Clause no.	ISP Clause Description	Read as
	A) General features of substrates to be used		
1)	A.3	Core ID of reel (in mm) - 76±2	Core ID of reel (in mm) = 76 MM
2)	A.6	Substrate grammage (in GSM) – 50 to 250	Substrate grammage (in GSM) = 50 to 180
3)	A.7	Substrate thickness (in microns) – 50 to 300	Substrate thickness (in microns) = 50 to 200
4)	A.8	Nature of substrate – uncoated paper/paper board/composite, clay coated paper/paperboard/composite, glassine paper, silicon coated paper, PET, polyester, ,OPP, BOPP, LDPE, HDPE, Polyolefin etc.	Nature of substrate – uncoated paper/composite, clay coated paper/composite, glassine paper, PET, polyester.
	B) Unwinding, Web handling, Web transport, Slitting unit and Turret rewinding unit		
	I. Unwinding Unit		
5)	B.I.2.	The unit shall be accompanied with "Automatic assistive Hydraulic reel loading mechanism (Capacity= 500 Kgs or more supported from both ends". Reels must be lifted to the machine operating position from ground position with hydraulic lifter arms operated within machine. Refer fig 1, 2 and 3 for working mechanism.	The unit shall be accompanied with "Automatic assistive Hydraulic reel loading mechanism (Capacity= 350 Kgs or more supported from both ends". Reels must be lifted to the machine operating position from ground position with hydraulic lifter arms operated within machine. Refer fig 1, 2 and 3 for working mechanism.
6)	B.I.5.	The unit shall have arrangement for 'Wrinkle removal by means of bowed roll' before feeding to the processing Station.	The unit shall have arrangement for 'Wrinkle removal by means of bowed roll or similar suitable mechanism' before feeding to the processing Station.
	III. Slitting unit		
7)	B.III.3	Minimum slitting width to be supported= 35 mm or less.	Minimum slitting width to be supported= 35 mm or lesser will be preferable.
	IV. Turret Rewinder unit with Automatic splicing:		
8)	B.IV.2	No. of spindles= 4 nos quickly interchangeable, compatible with core having Inner Diameter (ID) 76±2 mm	No. of spindles= 4 nos quickly interchangeable, compatible with core having Inner Diameter (ID) 76 mm
9)	B.IV.4	Shall be programmed for registered splicing actuated through some pre-printed command on spool such as "cancelled" or any other customized pre-printed command that is duly read by the inspection system.	Shall be programmed for registered splicing actuated through some pre-printed command on spool such as "cancelled" or any other customized pre-printed command duly read by the inspection system and label count.
10)	B.IV.6	The change over from running web to standby web to be executed at machine speed from 180 meters/min or higher.	The change over from running web to standby web to be executed at machine speed from 150 meters/min or higher.
11)	B.IV.9	Double sided adhesive tape applicator for core end of 'empty spools'.	Double sided adhesive tape applicator or glue with proper dispenser for core end of 'empty spools'.
12)	B.IV.11	It shall be equipped with label applicator to close the finished roll. The labels may or may not be printed.	It shall be equipped with label applicator / glue to close the finished roll.

Sl. No.	Clause no.	ISP Clause Description	Read as
	V. General conditions		
13)	B.V.1	All the unwinding & rewinding shafts/mandrels shall be air expandable with multi tubes inside it. There shall be provision for inflating/deflating the air expandable shafts through option available on HMI.	There shall be suitable arrangement for inflating or deflating the unwind shaft using air pressure gun or other better arrangement.
14)	B.V.3	The maximum speed of the web handling and transport system as described in Para-B-I,II,III,IV,V shall be 180 m/min or higher. [This speed to be achieved for all other operation except UV inkjet printing at resolution 600x600 DPI]	The maximum speed of the web handling and transport system as described in Para-B-I,II,III,IV,V shall be 150 m/min or higher. [This speed to be achieved for all other operation except UV inkjet printing].
15)	B.V.5	High resolution touch screen HMI of display size 15" or more consisting features for speed control, tension control, programmable spool formation, programmable rotary knives positioning, core positioning, pressured air status within air expandible shafts and other features to be provided. Minimal use of physical buttons will be preferable.	High resolution touch screen HMI of display size 10" or more consisting features for speed control, tension control, programmable spool formation, programmable rotary knives positioning, core positioning, pressured air status within air expandible shafts and other features to be provided. Minimal use of physical buttons will be preferable. There should be separate touch screen for unwinder and turret rewinder.
16)	Note:	All the hardware supplied along with the machine shall be compatible to function at the speed of 180 m/min or higher so that future upgradation in terms of printing speed can be achieved.	All the hardware supplied along with the machine shall be compatible to function at the speed of 150 m/min or higher so that future upgradation in terms of printing speed can be achieved.
	D) Drop on Demand Inkjet printing system		
	I. Printing Hardware		
17)	D.I.4	Ink supply type- Bulk inking system with electronic ink control with ink holding capacity 10 L or higher.	Ink supply type- Bulk inking system with electronic ink control with ink holding capacity 2.5 L or higher.
18)	D.I.5	Print speed (in meters/min)- 50 or higher @ resolution of 600 x 600 DPI or higher and output print density of 1.7 or higher on any substrate mentioned in Para A. However, printing speed of 120 m/min or higher to be achieved at all lower resolutions (other than 600x600). (Note: The machine may support other resolution and ink density, however defined speed must be achievable at specified resolution and output print density, on any substrate mentioned in Para A)	Print speed (in meters/min)- 50 or higher @ resolution of 600 x 600 DPI or higher and output print density of 1.2 or higher on any substrate mentioned in Para A. However, printing speed of 120 m/min or higher to be achieved at all lower resolutions (other than 600x600). (Note: The machine may support other resolution and ink density, however defined speed must be achievable at specified resolution and output print density, on any substrate mentioned in Para A).
19)	D.I.9	Text matters including alphabets, numbers and special character with font size of '3 pts or more' printed on any substrates mentioned in Para-A shall be easily legible and machine readable.	Text matters including alphabets, numbers and special character with font size of '6 pts or more' printed on any substrates mentioned in Para-A shall be easily legible and machine readable.
20)	D.I.11	There should be provision for stitching the print heads within the print module so as to produce 'No Gap' printing across the defined print width of 510 mm or higher. The alignment and movement of print heads within the print module as well as the print module shall be automatically controlled by means of motors actuated through commands from operator HMI/controller	The print heads within the print module shall be stitched so as to produce 'No Gap' printing across the defined print width of 510 mm or higher.
21)	D.I.12	There should be arrangement for automatic print head cleaning and capping.	There should be arrangement for print head cleaning and capping.
	IV. RIP/Workflow Software/Printing Software		
22)	D.IV.6	It shall be capable of generating encrypted 2D codes,	It shall be capable of generating 2D codes.
23)	D.IV.7	Shall be compatible with all standard file formats like (.pdf),(.csv),(.xls), (.txt), Unicode etc	Shall be compatible with all standard file formats like (.pdf),(.csv),(.txt), Unicode etc
24)	D.IV.8	It shall have features like exploding/telescopic font style for text and number	It shall have features like exploding/telescopic for text and number.
25)	D.IV.9	There shall be no limitation on the number of fields that can be linked to any object/message from database. It should also be able to link fields from multiple external databases in a single message for printing text/2D code/Quadra code.	There shall be no limitation on the number of fields that can be linked to any object/message from database. The system shall have the ability to link multiple field from multiple databases in layout or it shall have the ability to link multiple field from a consolidated single database that has been formed by merging multiple database through the in built software.
	E) Label		
	II. Inspection System		
26)	E.II.1	It should be able to perform line scan inspection of each labels using suitable camera hardware (12K resolution or higher) and illumination for capturing 'printed text' 'printed number', data embedded in '2D barcode' etc.	It should be able to perform line/area scan inspection of each labels using suitable no. of camera, hardware and illumination for capturing 'printed text' 'printed number', data embedded in '2D barcode' etc..

Sl. No.	Clause no.	ISP Clause Description	Read as
27)	E.II.2	Printed Text' or 'printed objects' matters including alphabets, numbers and special character with font size of '3 pts or more' printed on any pre-printed substrates mentioned in Para-A shall be easily readable by the inspection system at all machine speeds 150 meters/min or higher. (Note- Texts are usually over printed on already pre-printed stock printed using oil based offset inks) '2D barcodes' like QR code, Data matrix etc consisting 40 characters or higher in area 7.5 mm x 7.5 mm or higher and 80 characters or higher in area 10 mm x 10 mm or higher shall be easily scannable by the inspection system at all machine speeds of 150 meters/min or higher.	Printed Text' or 'printed objects' matters including alphabets, numbers and special character with font size of '6 pts or more' printed on any pre-printed substrates mentioned in Para-A shall be easily readable by the inspection system at all machine speeds 120 meters/min or higher. (Note- Texts are usually over printed on already pre-printed stock printed using oil based offset inks) '2D barcodes' like QR code, Data matrix etc consisting 40 characters or higher in area 7.5 mm x 7.5 mm or higher and 80 characters or higher in area 10 mm x 10 mm or higher shall be easily scannable by the inspection system at all machine speeds of 150 meters/min or higher.
	F) Error Marking System:		
28)	F.4	Printer for error making system should be operated through electronic controlled bulk inking system compatible with ink that can print on all substrates mentioned in Para-A. It should have ink holding capacity of 5 lt. ink or higher.	Printer for error making system should be operated through electronic controlled bulk inking system compatible with ink that can print on all substrates mentioned in Para-A. It should have ink holding capacity of 1 lt. ink or higher.
29)	F.5	Error marking system should be able to work at the speed of 150m/min or higher and should have print width coverage of 510 mm or higher.	Error marking system should be able to work at the speed of 120 m/min or higher and should have print width coverage of 510 mm or higher.
	G) Logical Integration of machine		
	II. Interaction between VDP Inspection system and Turret Rewinder		
30)	G.II.2	The splicing shall take place in between the two consecutive rows labels printed with 'cancel'/any other custom message command.	The splicing shall take place in between the consecutive rows not more than 6 rows to be wasted for this implementation) printed with 'cancel'/any other custom message command.
	H) General Technical Specifications		
31)	H.11.C	Program of the PLC/HMI system along with complete access to be provided in the service laptop	Program of the PLC/HMI system along with complete access to be provided in the service laptop wherever applicable.
	I) Essential terms and conditions		
32)	I.1	The firm shall undertake to provide service back up for minimum 10 years from the date of supply of the system.	The firm shall undertake to provide service back up for minimum 10 years from the date of supply of the system wherever applicable or propose upgrade.
33)	I.4	The firm has to provide back up of all PLC program, drive program parameters and source code of all customised software built for INDIA SECURITY PRESS, NASHIK along with a dedicated laptop for servicing.	The firm has to provide back up of all PLC program, drive program parameters and source code of all customised software built for INDIA SECURITY PRESS, NASHIK along with a dedicated laptop for servicing wherever applicable.
	L) Pre-Dispatch Inspection		
34)	L.5	During PDI, Required Trial material like dummy pre-printed sticker paper and pre-printed polymer-based label stock of minimum and maximum specified GSM/thickness as per Para-A, VDP Ink for PDI trial will be arranged by the Supplier & the necessary information for label size will be provided by ISPN to the successful vendor in advance.	During PDI, ISP will provide 4 unprinted stock reels for trial and testing purpose on returnable basis.

Note*: **a.** All other terms and conditions of tender shall remain unchanged.

b. For further details, please visit our website www.spmcil.com or https://ispnasik.spmcil.com regularly.

05.03.2025

Addl. General Manager (Materials)
For Chief General Manager