TECHNICAL SPECIFICATION

Automatic seaming machine for non-round aluminium cans

Purchaser: SIA "UNDA"

Registration No.: LV59203002531

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LAD project: "Modernisation and Automation of Fish Canning Production Processes"

Subject of procurement: 1 (one) complete new automatic seaming machine.

1. Procurement objective

To ensure automatic, hermetic seaming of non-round aluminium fish cans in the two can formats used by the purchaser.

2. Minimum technical requirements

Parameter	Minimum requirement
Machine type	Automatic seaming machine for non-round aluminium cans.
Can formats	105 × 76 × 21.25 mm and 105 × 76 × 25.1 mm.
Ends	105 × 76 mm Easy Open aluminium ends, in accordance with the attached drawings.
Production capacity	At least 90 cans per minute for each of the two formats.
Seaming method	Hermetic double seaming in accordance with the can and end manufacturer's requirements.
End feeding	Automatic and synchronised; feeding system included.
End detection	System preventing seaming without a correctly positioned end.
Can infeed	Can infeed and positioning mechanism necessary for machine operation; a separate external infeed conveyor is not required.
Speed adjustment	Adjustable operating speed.
Format changeover	Tooling and adjustment components for both formats included; no additional equipment purchase required. Tenderer shall specify changeover time and operations.
Safety	Compliance with applicable EU machinery safety requirements; necessary guards and emergency stop.
Control and monitoring	Operator control panel displaying the number of cans produced and reasons for machine stoppage.

Can and end safety control	Automatic “no can – no end feed” control; machine stops if ends are unavailable.
Construction and hygiene	Parts in contact with food production shall be made of food-suitable, corrosion-resistant materials; cleanable construction.
Completeness of supply	Price includes all tooling, heads, adjustment and conversion components for both specified can heights and ends; no additional tooling purchase required.
Utilities	Tenderer shall specify power supply, compressed air pressure/consumption, machine dimensions, weight and connection requirements.

3. Seaming quality and testing

The machine shall ensure double seam quality in accordance with the attached technical documentation for the non-round aluminium can and end. The end drawing specifies the following inspection reference values: ideal seam height 2.80 mm (specified upper tolerance +0.30 mm), body hook 1.90 ± 0.30 mm, overlap at least 1.0 mm and wrinkling no more than 30%. Final acceptance criteria shall be applied together with the manufacturer's complete seam inspection methodology.

The supplier shall conduct a trial with both purchaser formats, demonstrating a capacity of at least 90 cans/min and compliant seam quality. Test duration, sample quantity and measurement protocol shall be agreed in the procurement contract before signing.

4. Installation, training and handover

• The supplier shall install, adjust and start up the machine at the purchaser's production facility.

• The supplier shall test operation with both non-round aluminium can formats.

• The supplier shall train operators and technical personnel in operation, format changeover, adjustment and routine maintenance.

• The supplier shall provide operating and maintenance documentation.

• Commissioning shall be confirmed by an acceptance and handover certificate signed by both parties.

5. Deadline and warranty

Installation, adjustment, start-up, testing of both formats, training and commissioning shall be completed no later than 5 months after conclusion of the contract, provided the purchaser supplies the samples and technical information specified in the contract in good time.

Warranty: at least 12 months from signing the acceptance and handover certificate. Manufacturing and assembly defects shall be rectified without additional charge during the warranty period, with technical support provided.

6. Information to be included in the tender

• Equipment manufacturer, model and technical description.

• Guaranteed production capacity for each of the two formats, specifying test conditions; a general machine capacity range is insufficient.

• List of tooling included for both formats, changeover procedure and estimated duration.

• Description of automatic end feeding, can positioning and safety control systems.

• Warranty and technical service terms, including remote support and technician arrival times; specify whether travel and accommodation expenses are included.

• Implementation schedule and total comparable price in EUR excluding VAT, separately identifying equipment, tooling for both formats, packaging, transport, insurance, installation, start-up, training and supplier personnel travel/accommodation costs.

7. Tender evaluation principles

Criterion	Maximum points
Tender price excluding VAT	50
Guaranteed production capacity	30
Technical service	20
TOTAL	100

Price: the lowest compliant price receives 50 points; other tenders receive 50 × (lowest compliant price / price being evaluated).

Capacity (max. 30 points): the lower guaranteed capacity of the two non-round aluminium can formats is evaluated. Capacity of 90–99 cans/min receives 15 points; capacity of 100 cans/min or more receives 30 points. A tender with capacity below 90 cans/min fails the minimum requirements.

Service (max. 20 points): if the supplier provides remote technical support within 24 hours of receiving a fault report, 10 points are awarded. If a service technician additionally arrives at the production facility within 72 hours of receiving the fault report, a further 10 points are awarded. Deadlines are measured in calendar hours; the tenderer shall confirm them in writing. Points are awarded for each condition met.

The tenderer shall specify manufacturing and delivery prerequisites, including the required quantities of can and end samples and technical drawings. These prerequisites shall be agreed in the contract, avoiding unforeseen additional costs for processing both formats.

8. Technical annexes

• Non-round aluminium can drawing (drawing No. 17-80002).

• Non-round aluminium can (21.25 mm) product specification.

• Non-round aluminium can (25.1 mm) product specification.

• Non-round aluminium can end drawing (drawing No. 15-80015).

• Non-round aluminium can end product specification.

Note: the can and end drawings supplied by the purchaser serve as a technical compatibility reference. The tenderer may offer equipment from any manufacturer that meets the specified requirements.