# TENDER NUMBER: DLS150614

**TECHNICAL AND MANUFACTURING REQUIREMENTS FOR MECHANICAL COMPONENTS AND STRUCTURES**

## 1 PART DESCRIPTION AND PART NUMBERS

- Description: Bin Assy
- Part no : 925234317002 00
- Description: Bracket Radio Assembly
- Part no : 925172715004 09

## 2 INPUTS

- NDA, Drawings, Datasheets, Specifications and dxf laser files on CD
- Surface Treatment Specifications
- Weld Specifications
- QA and Industrialisation Requirements – See CRL
- Data Sheets for Standard Fasteners
- Inspection and Final Acceptance – see para 6.4 for procedure
- Manufacturing Requirements
- Delivery Schedule
- Acceptance Criteria of Tender
- DLS 92 Release Certificate
- Industrial Participation - NIP / DIP Requirements
- See industrialisation requirements for instructions regarding Earth Strap (925/17325/5001/10) and Handle Locking (925/18605/5000/00)

## 3 OUTPUTS

- Quotation, Execution Plan, signed NDA and NIP/DIP declaration
- Bin Assy – delivered to DLS
- Bracket Radio Assy –delivered to DLS
- Built History Records (BHR)
- Presentation of Bin Assy and Bracket Radio Assembly for final inspection and acceptance
- Jigs and Fixtures
- Qualified Manufacturing Process, Measuring Process and Weld Process

## 4 DELIVERY SCHEDULE

**BRACKET RADIO ASSEMBLY**

Phase 1 – 182 off : as per attached schedule.

Phase 2 – 220 off : as per attached schedule.

**BIN ASSY**

Phase 1 – 85 off : as per attached schedule.

Phase 2 – 110 off : as per attached schedule.

# 5 MANUFACTURING REQUIREMENTS

## 5.1 WELDING REQUIREMENTS AND CAPABILITY

- Three years qualified and proven weld capability and experience of materials and structures in material like Armour, Weldox, Armox, Roq-tuff, Mild Steel and Stainless Steel is applicable.

## 5.2 WELDING PROCESS AND PREPARATION

- All weld areas to be sand blasted and cleaned with Duva PPC
- WPS of weld process to be approved prior to welding
- All welds will conform to the weld specifications

## 5.3 WORKMANSHIP

All open areas to be deburred and no sharp edges is allowed.

## 5.4 CRACK DETECTION

Crack detection as per weld and drawing specifications is applicable. Only serialised components can be submitted for dye penetrant or crack testing as per drawing specification.

## 5.5 SURFACE TREATMENT

- DLS can act as a possible supplier for surface treatment of components and assemblies as per drawing specification prior to the assembly phase.
- A Certificate of Conformance (COC) to be issued from the sub-contractor who is responsible for the surface treatment. The COC will form part of the BHR.
- Contact Details at DLS paint shop: Johan van der Merwe @ 012 620 3145 at DLS for an official quotation.

## 5.6 SERIALISATION AND IDENTIFICATION

- Assemblies and components to be serialised where applicable for traceability purposes and to allow a crack testing certificates to be issued.
- The drawing and weld specifications will indicate when serialisation is applicable.
- For identification purposes a company identification number must be added to the main assembly.

## 5.7 JIGS AND FIXTURES

- Jigs and fixtures to be quoted as a separate line.

# 6 QUALITY AND INSPECTION

## 6.1 MEASURING CAPABILITY

- Calibrated Measuring Equipment to be used at all times.

## 6.2 QUALITY REQUIREMENTS

- As per Control Requirements List (CRL)
- All BHR together with the hardware to be presented to the DLS QAR for acceptance

## 6.3 INDUTRIALISATION REQUIREMENTS

- As per Control Requirements List (CRL)
- The industrialisation phase must be completed before production can continue.
- Jigs and fixtures to be developed to ensure repeatability.
- The supplier will have to source for the following components as they are specially made up and has an import element :
  Handle Locking Long – 925/18605/5000/00
  Handle Locking Short – 925/18603/5000/03
  Strap Bonding Radio Rack - 925/17325/5001/10
  Strap Bonding Radio Rack FCM – 925/17324/5000/09

## 6.4 INSPECTION AND FINAL ACCEPTANCE PROCUDURE

- The Supplier will invite the DLS QAR for inspection by submitting a notification via the email system.
- As part of the notification the Supplier will submit the signed DLS92 Release Certificate and BHR to the following email address: dls-release@dlsys.co.za
- The DLS QAR will only act on the notification once received via the email system.

## 6.5 BUILT HISTORY RECORDS (BHR)

A BHR file will include a DLS92 Release Certificates, material certificates, crack detection certificates and measuring reports. All BHR to be clearly marked with the part number, item description and order number. The supplier will certify the certificates in the BHR file.

## 6.6 ASSEMBLY AND INSPECTION

- Assembly to be performed within a controlled assembly workspace with instructions.
- Acceptance and inspection to be performed against qualified jigs and fixtures.

# 7 DELIVERY

- The DLS 92 and delivery note will accompany the hardware to the DLS warehouse.
- All hardware to be delivered to the DLS Warehouse.

# 8 INDUSTRIAL PARTICIPATION

The Supplier will indicate the NIP / DIP obligations by completing the NIP / DIP declaration.

# 9 EVALUATION CRITERIA OF THE TENDER

The Tender will be evaluated according criteria as stated in paragraph 1 under sub paragraph 2.1.1 of the tender application

# 10 ESCALATION

The tables and values of Seisfa is applicable and the supplier is responsible for obtaining the information and the data from the Seifsa organisation.

## 11 ORDER PLACEMENT

An order will be issued only for phase one of the schedule as per paragraph 4 of the Technical and Manufacturing Requirements document SC0NH Rev 00.

## 12 EXECUTION PLAN

The Supplier must submit an Execution Plan for each deliverable which must include all main activities. The execution plan forms part of the tender documents.

## 16 NON DISCLOSURE AGREEMENT (NDA)

The Supplier will return a signed NDA before any drawings, datasheets, specifications or informational CDs can be handed over for quotation purposes.

**APPROVED BY:**

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|---|---|---|
| Technical Expert: | M Mendes | _____ |
| Date: | | _____ |
| QAR : | V Fortune | _____ |
| Date: | | _____ |
| Senior Manager at SC: | W Raven | _____ |
| Date: | | _____ |