

Ford C346 Rear Bumper

Date: 03.11.2009
RFQ Nr:104
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Project – name Ford C 346 Rear Bumper (linia spawalniczo-zgrzewalnicza zderzaka tylnego)

KA number 9558

Type of machine Standard cell for arc welding

Production plant KPA II - PL Gliwice

Contact purchasing dept. Marcin Rams , +48 32 3381 630 , +48 663 744 831 ,
m.rams@kirchhoff.pl

Last date for offer	2009-11-17
Expiry date of offer	2009-12-31
Planned date for placing order	t.b.d.
First parts of fixtures (manual produced)	2010-01-13
First parts of fixtures (autom. produced)	2010-01-27
Function check	2010-02-05
Delivery	2010-02-12
End of assembly	2010-02-20
Start trial run	2010-02-23
Delivery instructions data	Version 2009 CAD

FDX_KA9558_90_001_02_3D_DS_C346_011902_0000001_REV19_AIICAT

Part.CATPart

Drawing t.b.d.

Bank account:

PKO BP SA O/Tarnobrzeg
89 1020 4913 0000 9702 0055 1994

Share capital: 25.000.000 PLN
KRS: 0000192802
REGON Plant 1: 831367272-00021
REGON Plant 2: 831367272-00039
EU VAT ID: PL8171949962

Registered in District Court
in Rzeszów
12th Commercial Department

Management Board:

Ryszard Muzyczka
Janusz Soboń



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Page 2 from 3**Process (1) OP 10 : Spot welding of 2 crash boxes, each 6 spots**

- Process flow chart :Manual inserting of 4 halfshelves , Manual start of cycle , Automated welding cycle , Automated ejecting of ready parts
- Technical demands Welding controller Harms + Wende
- Remarks Detailed definition of equipment in the offer
- Appendixes 000.6 KA9558-90-001-02 Weldings BM51 A403C94 AA 16.04.09.pdf

Process (2) OP 20 : Spot welding of beam and closing plate, 44 points

- Process flow chart : Manual inserting of beam and closing plate , Manual start of cycle ,Automated welding cycle ,Automated ejecting of ready parts
- Technical demands: Welding controller Harms + Wende , Middle frequency welding equipment , Servo gun (NIMAK / ARO) as 7th axis, as an option pneumatical gun , Robots FANUC
- Remarks : Detailed definition of equipment in the offer
- Materials :Beam MSW 1200 (1,8 mm), Closing plate (1,2 mm), Crash boxes (1,5 mm) and Base plates (3,0 mm) HC420LA
- Appendixes: 000.6 KA9558-90-001-02 Weldings BM51 A403C94 AA 16.04.09.pdf

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Page 3 from 3**Process (3) OP 30 : ARC welding of assembly**

- Process flow chart: Manual inserting of beam and closing plate, base plates, crash boxes and towing tube , Manual start of cycle ,Automated welding cycle , Manual extracting of ready parts"
- Technical demands "Welding equipment Fronius Robots Fanuc"
- Remarks "Detailed definition of equipment in the offer"
- Materials : Beam MSW 1200 (1,8 mm) , Closing plate (1,2 mm), Crash boxes (1,5 mm) and Base plates (3,0 mm) HC420LA "
- Appendixes 000.6 KA9558-90-001-02 Weldings BM51 A403C94 AA
16.04.09.pdf

Annual quantity of parts	296 000
Working days / year	235
Working hours / day	7,5
Min. technical availability (machine)	98%
Min. system availability (machine + operator + ...)	85%

RFQ is placed on web side Kirchhoff Polska Assembly : <http://www.kirchhoff.pl/pobierz.html>

Marcin Rams

Kierownik Zakupów
KIRCHHOFF POLSKA ASSEMBLY Sp z o.o

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