## राष्ट्रीय प्रौद्योगिकी संस्थान, मिजोरम NATIONAL INSTITUTE OF TECHNOLOGY, MIZORAM

(An Institute of National Importance under Ministry of HRD, Govt. of India) CHALTLANG, AIZAWL: MIZORAM - 796012,

Phone No. 0389-2341236/2341699

Fax: 0389-2341774 Web: www.nitmz.ac.in

Email: nit mizoram@nitmz.ac.in

Ref. No.: NIT-MZ/TENDER/01-A/2014

Date: 29th January 2014

## NOTICE INVITING TENDER FOR SUPPLY & INSTALATION OF LABORATORY EQUIPMENTS FOR MECHANICAL ENGINEERING **DEPARTMENT**

CNC & Engineering Models

Last date for receiving Tender documents: 25th February 2014 before 3:00 PM

Date/Time for Opening of Tech. Bids: 25th February 2014 at 3.30 PM

# राष्ट्रीय प्रौद्योगिकी संस्थान, मिजोरम

## NATIONAL INSTITUTE OF TECHNOLOGY, MIZORAM

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Ref. No.: NIT-MZ/TENDER/02-A/2013

Date: 20th May 2013

### **NOTICE INVITING TENDER (NIT)**

National Institute of Technology-Mizoram is one of the ten new NITs established by Ministry of Human Recourse Development, Government of India, New Delhi in the year 2010 at Aizawl, Mizoram to impart education, training and research in Science, Technology and Management leading to award of B. Tech., M. Tech., MBA and Ph.D degrees. This institute if fully financed and governed by Ministry of Human Recourse Development, Government of India.

Sealed Tenders are invited from eligible Manufacturers/Developers or their Authorized Dealers for supply & Installation of Machines as per details at **ANNEXURE-IV**, in **Two Bids** to reach the undersigned on or before <u>25<sup>th</sup> February</u> <u>2014 before 3:00 PM</u>. Date/Time for Opening of Tech. Bids: <u>25<sup>th</sup> February 2014 at 3.30 PM</u>. After evaluation of Technical Bids, Financial Bids of the successful bidders will be opened on later date which will be notified in the Institute website. Venue of bid opening: **NIT Mizoram**, **Aizawl**.

S1. No.	Ref ere nce No.	Items	Qty	EMD (Rs.)in the form of DD only. (Refundable)	Tender Document Fee (Rs.) in the form of DD only. (Non- Refundable)
01.		Supply & Installation of Equipments for CNC & Engineering Models on turnkey basis to be installed at NIT, Mizoram, Aizawl	One Package	<b>@2</b> %	1,000.00

**Note:** Demand Draft must be in favor of "**Director, NIT Mizoram**" Payable at **Aizawl**.

### General Instructions for the Bidders:

01. Quotations will have to be submitted in TWO Bids i.e. Technical Bid and Financial Bid, in hard copy as well as in soft copy (soft copy must be in MS word 2007 provided in separate CDs for Technical Bid and Financial Bid). Both hard copy and soft copy of Technical Bid should be in one sealed envelope specifically mentioning "Technical Bid" on the cover of the envelope similarly for Financial Bid also, both hard copy and soft copy of must be in one sealed envelope specifically mentioning "Financial Bid" on the cover of the envelope. Further these two sealed Bids must be kept inside one big sealed envelope before submitting it.

The address of the firm submitting the quotation and the Officer to whom the quotation is addressed must appear distinctly on sealed covers. Further, on sealed cover, the following are to be written:

QUOTATION FOR SUPPLY & INSTALLATION OF "EQUIPMENT FOR CNC & ENGINEERING MODELS LABORATORY OF MECHANICAL ENGINEERING DEPARTMENT AT NIT MIZORAM".

- 02. **Submission of Compliance Certificate:** Duly filled and signed Compliance Certificates (as per formats at **Annexure I (A & B)** are must with the Technical bid.
- 03. **Bid not transferable:** The bid documents are not transferable and the seal and signature of the authorized official of the firm must appear on all the papers and envelopes submitted.

### **QUALIFICATION REQUIREMENTS**

- 01. The Bidder should be a Original Equipment Manufacturer (OEM) Or a firm of reputation having sufficient expertise and experience in the subject tender with sound warranty / service support capability and authorization from Manufacturer/Distributor.
- 02. The Bidder has to Quote for all the items in the CNC & Engineering Models, Bidders who do not Quote for all the items are subject to be disqualified.

### **TERMS & CONDITIONS:**

01. Rates: Rates quoted in the Price Bid should be on DOOR DELIVERY NIT Mizoram basis, as per details below:

Sl. No.	Particulars	Rate
I	Basic Price (per unit) including Packing, Forwarding, Freight, Insurance, Installation & demonstration charges inclusive	
II	Taxes(pl. give break up)	
III	Grand Total for the item on door delivery at NIT Mizoram	

Bidders shall indicate their rates in clear/visible figures as well as in words and shall not alter/overwrite/make cutting in the quotation. In case of a mismatch, the rates written in words will prevail.

- 02. **Validity of Quotation:** Quoted rates must be valid for **90 days** from the date of quotation.
- 03. **Warranty:** The quoted equipment and components must be warranted for a minimum of one Year or period specified against the item from date of Installation.
- 04. **Literature a must**: All the quotations must be supported by the printed technical leaflet/literature and the specifications mentioned in the quotation must be reflected/ supported by such printed technical leaflet/literature. The model and specifications quoted should **invariably be highlighted** in the leaflet/literature for easy reference.
- 05. **After Sales Service:** Vendors should clearly state the available nearest after sales service facilities in the region, without which their offers will be rejected.
- 06. **Dealership Certificate:** Dealers or Agents quoting on behalf of Manufacturer must enclose valid dealership certificate.

### 07. Earnest Money Deposit:

Refundable earnest money deposit (EMD) of @2% of the Quoted Value through demand draft drawn in favor of "The Director, National Institute of Technology Mizoram", payable at Aizawl, will have to accompany the technical Bid. The EMD of unsuccessful bidders shall be returned after award of contract. EMD of the successful bidder will be released on submission of the Performance Guarantee. Offers received without Earnest Money or valid Certificate shall be summarily rejected.

08. **Performance Bank Guarantee (PBG):** In case of items with order value of Rupees five lakhs (INR 5,00,000/-) and above, the successful bidder shall furnish an unconditional PBG (as per format at **Annexure II**) for 5% of the Purchase Order value from a scheduled Bank of India, after receiving the purchase order. Where the PBG is obtained by a foreign bank, it shall be got confirmed by a Schedule Indian bank and shall be governed by Indian Laws and be subject to the jurisdiction of courts at Aizawl. The PBG shall guarantee that,

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- (a) The Vendor guarantees satisfactory operation of the Equipment & components against poor workmanship, bad quality of materials used, faulty designs and poor performance.
- (b) The Vendor shall, at his own cost, rectify the defects/replace the items supplied, for defects identified during the period of guarantee.
- (c) This guarantee shall be operative from the date of installation till 60 days after the warranty period.

### 09. **Delivery:**

- **a) Time Limit:** Maximum within 12 Weeks from the date of issue of this purchase order.
- **b) Safe Delivery:** All aspects of safe delivery shall be the exclusive responsibility of the vendor. At the destination site, the package will be opened only in the presence of NIT user/representative and vendor's representative. The intact condition of the package and the seal/indicators for not being tempered with shall form the basis for certifying the receipt in good condition.
- **c) Insurance:** The supplier is to establish 'All Risk Transit Insurance' coverage till door delivery at NIT Mizoram.
- **d) Part Delivery:** Acceptance of part delivery shall be a prerogative of the institute.
- e) Penalty for delay in delivery: The date of delivery should be strictly adhered to otherwise the Director, NIT Mizoram reserves the right not to accept delivery in part or full.
- 10. **Genuine Pricing**: Vendor is to ensure that quoted price for the particular item is not more than the price quoted to any other customer in India, particularly to IITs/NITs and other Government Organization. Copy of the latest price list for the quoted item, applicable in India, must be enclosed with the offer.
- 11. **Conditional tenders not acceptable:** All the terms and conditions mentioned herein must be strictly adhered to by all the vendors. Conditional tenders shall not be accepted on any ground and shall be rejected straightway. Conditions mentioned in the tender bids submitted by vendors will not be binding on NIT Mizoram.
- 12. **Road Permit:** NIT, Mizoram will provide Road Permit to the Vendors of outside Mizoram.
- 13. **VAT deduction at source:** In case of supply within Mizoram, VAT deduction at source, as per Order/ notification of the Govt. of Mizoram will be applicable.
- 14. **Late and delayed tender**: Late and delayed tender will not be considered. In case any unscheduled holiday occurs on the prescribed closing/opening date the next working day shall be the prescribed date of closing/opening.

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- 15. **Payment**: 100% payment within 30(Thirty) days after receipt of the material in full, satisfactory installation, training and acceptance.
- 16. **Payment for Imported Goods:** By an irrevocable letter of Credit at CIF/CIP Kolkata value negotiable through any overseas branch of State Bank of India/any Schedule Bank of India.

**Note**: Please note LoC will not be opened unless and until Letter of Acknowledgement in original is received at NIT, Aizawl, Mizoram, directly from the principal (Even in case of firms having subsidiary office in India).

### 17. ADDITIONAL TERM FOR IMPORTED GOODS

Following term besides the fore mentioned terms will be applicable in case of foreign purchases:

**Rates:** Prices quoted must be for destination including freight and insurance charges inclusive of free delivery up to the door of department/centre NIT, Mizoram premises, as per details below:

S1. No.	Particulars	Rate
Ι	Basic Price (per unit) including Packing, Forwarding, Freight, Insurance, Installation & demonstration charges inclusive	
II	Custom Duty (Approximate)	
III	Grand Total for the item on door delivery at NIT Mizoram	

- 18. Free Maintenance & Service for 20 Years: An agreement is to be executed between the Institute & the Manufacturer/Distributor/Dealer for providing Free Maintenance & Service for 20 Years after expiry of the Warranty Period of the equipment by the Manufacturer/Distributor/Dealer (Preferably from the Manufacturer) within 30 Days from the day of Complain. The cost of the Spare parts required for the service and maintenance will be paid by the Institute along with the To & Fro charges (The cheapest mode of Travel).
- 18. **Enquiry during the course of evaluation not allowed**: No enquiry from the bidder(s) shall be entertained during the course of evaluation of the tender till final

decision is conveyed to the successful bidder(s). However, the Purchase Committee or its authorized representative may make enquiries/seek clarification from the bidders. In such a case, the bidder must extend full co-operation. The bidders may also be asked to arrange demonstration of the offered items, in a short period of notice.

19. The acceptance of the quotation will rest solely with the Director, NIT Mizoram, who in the interest of the Institute is not bound to accept the lowest quotation and reserves the right to himself to reject or partially accept any or all the quotations received without assigning any reasons.

### 20. Force Majeure:

If the performance of the obligation of either party is rendered commercially impossible by any of the events hereafter mentioned that party shall be under no obligation to perform the agreement under order after giving notice of 15 days from the date of such an event in writing to the other party, and the events referred to are as follows:

- i. Any law, statute or ordinance, order action or regulations of the Government of India,
- ii. Any kind of natural disaster, and
- iii. Strikes, acts of the Public enemy, war, insurrections, riots, lockouts, sabotage.

### 21. Applicable Law:

- (a) The contract shall be governed by the laws and procedures established by Govt. of India and subject to exclusive jurisdiction of Competent Court and Forum in Aizawl only.
- (b) Any dispute arising out of this purchase shall be referred to the Director NIT Mizoram, and if either of the parties hereto is dissatisfied with the decision, the dispute shall be referred to the decision of an Arbitrator to be appointed by the Director of the Institute. The decision of such Arbitrator shall be final and binding on both the parties.
- 22. **Training:** The vendor will provide free training at NIT Mizoram after Successful installation of the Machines/equipments.

Sd/

Encl.: ANNEXURE-I, ANNEXURE-II, ANNEXURE-III & ANNEXURE-IV

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# A. <u>COMPLIANCE CERTIFICATE FOR NIT TERMS</u> (To be enclosed in the Technical bid)

S1. No.	NIT Terms and Conditions	Yes/No
01	Rate quoted as per instruction	
02	AMC rate after warranty provided	
03	Validity of quoted rate for 90 days agreed	
04	EMD submitted (appropriate certificate enclosed)	
05	PBG term agreed	
06	Payment term agreed	
07	Delivery terms agreed	
08	Warranty period agreed	
09	Literature: Printed Literature provided	
10	<b>Dealership</b> / distributorship certificate (in case of dealers/agents) provided	
11	<b>Sales Service</b> : address of after Sales Service centre in India (for imported goods)/ in the region provided	
12	Manufacturer certificate provided	
14	Applicable law terms agreed	

Signature with Seai:
Vendor: M/s

### **B. COMPLIANCE CERTIFICATE FOR SPECIFICATIONS** (One for each item must to be enclosed in the Technical bid)

Item Sl. No.			
Specification	ons as per Annexure-IV	Quoted Item Specs.*	Complied (Yes/No)
Parameter	Specification		

,	Signature with Seal:
7	Jendor: M/s

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<sup>\*</sup> Vendor must quote the parameter specification of the quoted product in this column and not just copy the specification from the tender call document. Failure to do so will lead to rejection of the tender.

## PERFORMANCE BANK GUARANTEE

To:	
The Director National Institute of Technology Mizoram	
WHEREAS	(Name of Supplier)
No dated	undertaken, in pursuance of Contract 20 to supplyon of Goods and Services) hereinafter called
"the order".	
furnish you with a Bank Guarantee by a re	you in the said order that the Supplier shall ecognized bank for the sum specified therein ier's performance obligations in accordance
<b>AND WHEREAS</b> we have agreed to give the	e Supplier a Guarantee:
behalf of the Supplier, up	are Guarantors and responsible to you, on to a total of
This guarantee is valid until theday of	of20
Się	gnature and Seal of Guarantors
Da	te20
Ad	dress:

All correspondence with reference to this guarantee shall be made at the following address: National Institute of Technology Mizoram, Chaltlang, Aizawl, Mizoram, India: 796012

Ref. No.: NIT-MZ/TENDER/01-B/2014 Dated 29th January 2014

## MANUFACTURERS' AUTHORIZATION FORM

No.	Dated
The Director National Institute of Technology Aizawl-796012, Mizoram	
Dear Sir:	
We	who are established and
reputable manufacturers of	having
factories at	
(address of factory) do hereby certify that	(Name of
the Authorized Dealer)is our authorized dealer to	quote against your tender enquiry no
,L	ast Date of Submission is:
No other Company other than	
(Name of the Authorized Dealer) is authorized to	o quote of our products against this
Tender Enquiry No	
Yours faithfully,	
	(Name)
(	Name of manufacturers)

## TECHNICAL SPECIFICATION FOR CNC & ENGINEERING MODELS LABORATORY

SL NO	TEC	CHNICAL SPECIFICATION	QTY
01.		ation Indexing Tool Post and FANUC & SIEMENS emulated strial Fanuc &SIEMENS (DUAL) Control with TUTOR KEY	01 No.
	Direct Numerical Control from an with facility for proving program incorporates all major functions	Simulation With Virtual onscreen of Fanuc series, driven by an external Micro Computer, programmed using ISO format, is using Tool path graphics and the software which and facilities used on Industrial controller with further and FMS (Flexible Manufacturing System) and CIM system	
	CAPACITY		
	Chuck Size:	100 mm	
	Maximum turning Diameter:	32 mm	
	Maximum turning Length:	120 mm	
	Bed: 45 deg Slant bed type:		
	No. of axes:	2 mm	
	Swing over way covers:	150 mm	
	Swing over cross slide:	50 mm	
	ACCURACY		
	Positioning Accuracy:	0.015 mm	
	Repeatability:	± 0.008mm	
	SPINDLE		
	Spindle nose taper:	MT3	
	Bore through spindle:	20 mm	
	Programmable spindle speed:	150-3000 rpm	

Spindle motor: 1 HP AC Induction

Programmable feed rate: 0 - 1000 mm/min

Control: FANUC & SIEMNS EMULATED CONTROL WITH INDUSTRIAL TUTOR KEY BOARD

FOR PROGRAMMING

Control system : PC based 2 axis continues path

Turret

Tool cross section: 12 x 12

No. of Station: 8 no

Boring bar size(capacity): 16 mm

Axes

X- axis travel: (160 in dia)mm

Z - axis Travel: 180 mm

Rapid feed rate: 1200 mm/min

Distance between centers: 210 mm

Axis motor: Stepper

Slides: Hardened ground guide ways

**Tailstock** 

Tailstroke base travel: 150 mm

Tailstroke Quill Stroke: 40 mm

Quill Diameter: 26 mm

Tailstroke Taper: MT2

**Coolant / Lubrication** 

Lubrication: Centralized system **Power source** Main supply: 230V, Single Ph, 50 Hz Stabilizer: 1 phase servo type **Features** Compatibility / Upgradable: FMS / CIM system **TOOLING PACKAGE** a)Set of 5 external turning carbide tool holders with inserts as described below Turning & Facing Tool holder: 2 no Copy Turning Tool Holder (LH, RH, N): 6 (each 2no.)nos Threading Tool Holder: 1 no b)Set of 3 Internal boring carbide tool holders with inserts as described below Boring bars: 4 nos Internal threading: 2 no c) Centre drill dia shank dia 8mm: 2 no d) Twist Drill dia 6,8,16 & 12mm: 8 (each 2 no.)nos **Optional Accessories** Lamp bulb PL3 – 9W: 1no REQUIRED EQUIPMENT AT SITE DURING COMMISSIONING, DEMONSTRATION & **TRAINING** a) 3 KVA SERVO STABILISER, Single Phase Output Voltage 230V AC - 1 No. b) Desktop Computer: Intel Corei3 Processor, 2 GB RAM with Windows WP Operating system, 17" LCD Monitor – 1 No. **BECHTOP CNC MILLING MACHINE (Trainer Type)** 01 No.

02.

CNC Milling Machine with 6 Station Automatic Tool Changer (ATC), FANUC & SIEMENS (DUAL) Control with TUTOR KEY BOARD

Axes CNC Bench Milling Machine with Fanuc & SIEMENS DUAL Control

Programming Software and Industrial Fanuc & SIEMENS Emulated Control Panel

With advanced Digital graphics Simulation With Virtual onscreen of Fanuc series, driven by Direct Numerical Control from an external Micro Computer, programmed using ISO format, with facility for proving programs using Tool path graphics and the software which incorporates all major functions and facilities used on Industrial controller with further option of linking to CAD/CAM and FMS (Flexible Manufacturing System).and CIM system

### **Travel**

X axis: 225 mm

y axis: 150 mm

Z axis: 115 mm

### **Table**

Table size: 360 x 132 mm

T- Slot: 2 x 10 x 50 mm

Load on table:15Kgs

### Spindle

Spindle nose to table top: 70 to 185mm

Spindle to Column: 110 mm

Spindle nose taper: BT 30 Spindle motor capacity: 0.5 hp

Programmable spindle speed: 150-4000 rpm

### **CNC** detail

Control : FANUC & SIEMNS EMULATED CONTROL WITH INDUSTRIAL TUTOR KEY BOARD FOR PROGRAMMING

**Control system:** PC based 3 axis Continues path

**Feed rate** 

Programmable feed rate: 0-1200 mm/min

Rapid feed: 1200 mm/min

Accuracy

Positioning accuracy: 0.010mm

Repeatability: ±0.005 mm

**Guide ways** 

Slides: Hardened ground guide ways

Ball screws: C3 class type

**Electric motors** 

Axis motor: Stepper

Axis motor capacity: 0.8 Nm

**Power source** 

Main supply: 230V, Single Ph, 50 Hz

Stabilizer: 1 phase servo type

**Coolant / Lubrication** 

Lubrication: Centralized system

**Features** 

Compatibility / Upgradable: FMS / CIM system

**TOOLING PACKAGE** 

Collet Chuck BT30/A45 RD25 with Pull Stud: 2 no

Collet Chuck BT 30/A45 RD16 with Pull Stud: 2 no

RD25 Collets Dia 5,6,8,10,12,16mm (each 1 No.): 2 set

RD16 Collets Dia 3,4,5mm (each 1 No.): 2set

2 lipped carbide slot mill for facing shank dia 16mm: 2 no

Clamping kit set: 2set

Set of HSS End Mills Dia 5, 6, 6,6,8 mm (each 1 No): 2set

Set of HSS End Mills Dia 10, 12, 16 mm (each 1 No.): 2set

HSS Slot Drills Dia 5, 6, 6, 6, 8, mm (each 1 No: 2set

HSS Slot Drills Dia 10,12,16mm (each 1 No.): 2set

# REQUIRED EQUIPMENT AT SITE DURING COMMISSIONING , DEMONSTRATION & TRAINING

- a) 3 KVA SERVO STABILISER, Single Phase Output Voltage 230V AC 1 No.
- b) Desktop Computer: Intel Corei3 Processor, 2 GB RAM with Windows WP Operating system, 17" LCD Monitor 1 No.
- c) Compressor: 100 Liter tank capacity, 6 to 8 Bar (100 psi) ( For ATC operation) 1 No.

### **Optional Accessories:**

- a) Work Bench 1 No
- b) 6 Station Automation Tool Changer 1 No.

• Tool shank: BT 30 type

• No of tool: 6 Nos.

Actuation type: PneumaticMaximum tool dia: 16 dia

Maximum tool length :40

### c) Pneumatic Vice - 1 No.

3	OBJECT DRAWING MODELS	Quantity	
	Rectangular Prism	1	1
	Rectangular Pyramid	1	1
	Triangular Prism	1	
	Triangular Pyramid	1	1
	Square Prism	1	-

	Square Pyramid	1	
	Pentagonal Prism	1	
	Pentagonal Pyramid	1	
	Hexagonal Prism	1	01Set
	Hexagonal Pyramid	1	
	Octegonal Prism	1	
	Octegonal Pyramid	1	
	Decagonal Prism	1	
	Decagonal Pyramid	1	
	Cube 20 x 20cm	1	
	Cone	1	
	Cone cut in four sections	1	
	Cylinder	1	
	Sphere 15cm	1	_
4	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SING		
4			01 Set
4	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SING		01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER	LE QUANTITY IN	01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL	LE QUANTITY IN  Quantity	01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL  Pelton Turbine	Quantity  1	01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGLANDING NUMBER  TURBINE MODEL  Pelton Turbine  Pelton Turbine (Dynamometer)	Quantity  1 1	01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL  Pelton Turbine  Pelton Turbine (Dynamometer)  De-Lavel Turbine	Quantity  1  1  1	01 Set
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL  Pelton Turbine  Pelton Turbine (Dynamometer)  De-Lavel Turbine  De-Lavel Turbine (transparent window)	Quantity  1  1  1	-
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL  Pelton Turbine  Pelton Turbine (Dynamometer)  De-Lavel Turbine  De-Lavel Turbine (transparent window)  Kaplan Turbine (Superior)	Quantity  1  1  1  1  1	-
	WOODEN MODELS ON INTERPENETRATION OF SOLIDS (SET OF 10) SINGINUMBER  TURBINE MODEL  Pelton Turbine  Pelton Turbine (Dynamometer)  De-Lavel Turbine  De-Lavel Turbine (transparent window)  Kaplan Turbine (Superior)  Francis Turbine	Quantity  1  1  1  1  1  1	-

	Tumble Fixture with 1 head bolt pattern plate, ability to accommodate interchangeable bores and with degreed swivel feature. Head Bolt Pattern Plate for swivel Tumble Fixture.	
	Bore Sleeve for swivel tumble Fixture.	
7	MULTITOOL MINI DRIVER MACHINE	01 Set
	1. Motor -175W power	
	2. Speed – 5000 to 35000 RPM	
	Compatible Accessories	
	1. Carver / Engraver/Router	
	2. Grinder	
	3. Cutter	
	4. Collets/ Mandrel	