ORIGINAL

State of Nebraska

State Purchasing Bureau

RFP 6152 Z1 – License Plate Blanking Line

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3M Transportation Safety Division

3M Center, 225-4N-14
St. Paul, MN 55144
www.3M.com

November 13, 2019

Ms. Annette Walton / Ms. Nancy Storant
Nebraska State Purchasing Bureau
1526 K Street
Suite 130
Lincoln, NE 68508

Regarding: Solicitation Number RFP 6152 Z1, License Plate Blanking Line

Dear Ms. Walton / Ms. Storant,
3M Company is pleased to submit its proposal in response to the State of Nebraska (RFP) for License Plate Blanking Line. We welcome the opportunity to assist the State of Nebraska in achieving its license plate manufacturing goals and to further our commitment to the State in offering 3M's Blanking Line equipment.

3M is confident that its Blanking Line equipment meets the requirements as set forth in the State's RFP. 3M is proud to have continuously served the State of Nebraska for over 30 years with products and services for license plates. For over half a century, 3M Transportaion Safety Divion has been an industry leader in license plate consumables, production, and equipment. 3M has developed business relationships with many U.S. state Departments of Transportation, with Departments of Corrections, and with Road and Transportation Authorities and have built a reputation for quality products, outstanding service, and technical innovation.

We look forward to the next steps in the State's procurement process.

Regards,

Craig Lorence
Proposal Manager
3M Transportation Safety Division
3M Center, Building 225-4N-14
St. Paul, MN 55144-1000
651-737-9011
cslorence@mmm.com

ADDENDUM THREE QUESTIONS and ANSWERS

Date: October 31, 2019

To: All Bidders

From: Annette Walton/Nancy Storant, Buyers
AS Materiel State Purchasing Bureau

RE: Addendum for Request for Proposal Number RFP Number 6152 Z1 to be opened November 18, 2019, at 2:00 P.M. Central Time.

Questions and Answers

Following are the questions submitted and answers provided for the above mentioned Request for Proposal. The questions and answers are to be considered as part of the Request for Proposal. It is the Bidder's responsibility to check the State Purchasing Bureau website for all addenda or amendments.

Question Number	RFP Section Reference	RFP Page Number	Question	State Response
1.	Scope of Service	1	Page 1 of this section references the Pre-Proposal Conference Date of October 3, 2019. Is this accurate?	Please see the document "Request for Proposal Revised" posted on our website. http://das.nebraska.gov/materiel/purchasing/6152/6152.html
2.	Procurement Procedure	2, C, Activity 3	This section references the Pre-Proposal Conference Date of October 18, 2019. Is this accurate?	See Question 1.
3.	Questions 10/16/2019 Procurement Procedure c. Schedule of Events	2	Because the Optional Pre-Proposal Conference is on Friday, 10/18/2019 and the last day to submit written questions after Pre-Proposal Conference is Monday	Please see Addendum One for the Revised Schedule of Events posted on the website. http://das.nebraska.gov/materiel/purchasing/6152/6152.html

			sharpened) meet the requirement of 2 passenger dies in this referenced section of the RFP?	
38.	Attachment #2, VI. Item #6 Three (3) Two Stage Compound Blanking Rimming die	Page 4of 6	Is Nebraska's motorcycle license Plate Flat?	Yes Nebraska's motorcycle plate is flat.
39.	RFP 6152 Z1 Final Revision One, V. Project Description and Scope Of Work, b.	Page 28	"b .Electrical Power is available in single phase 120V, 3 phase 240, 3 phase 480 volts. The main connection panel is located approximately 160 feet from the proposed line location." Please confirm all 3 forms of electrical power are available: single phase 120V, 3 phase 240, 3 phase 480 volts.	Please see Question 31.

This addendum will become part of the proposal and should be acknowledged with the Request for Proposal response.

3M's Response: 3M acknowledges Addendum Three (pg. 1 - 11) in its entirety.

ADDENDUM TWO, REVISED SCHEDULE OF EVENTS

Date: October 18, 2019

To: All Bidders

From: Annette Walton / Nancy Storant, Buyer
AS Materiel Purchasing

RE: Addendum for RFP Number 6152 Z1 to be opened November 7, 2019 at 2:00 p.m. Central

Schedule of Events

The State expects to adhere to the tentative procurement schedule shown below. It should be noted, however, that some dates are approximate and subject to change. It is the Bidder's responsibility to check the State Purchasing Bureau website for all addenda or amendments.

	ACTIVITY	DATE/TIME
1.	State responds to written questions through Solicitation "Addendum" and/or "Amendment" to be posted to the Internet at: http://das.nebraska.gov/materiel/purchasing.html	October 31, 2019 ~~October 28, 2019~~ ~~October 25,2019~~
2.	Proposal Opening Location: State Purchasing Bureau 1526 K Street, Suite 130 Lincoln, NE 68508	November 18,2019 ~~November 12, 2019~~ ~~November 7, 2019~~ 2:00 PM Central Time
3.	Review for conformance to solicitation requirements	November 22, 2019 ~~November 13, 2019~~ ~~November 7, 2019~~
4.	Evaluation period	November 22, 2019 Through Dec 6, 2019 ~~November 14, 2019~~ ~~through~~ ~~November 20, 2019~~ ~~November 8, 2019~~ ~~through~~ ~~November 15, 2019~~
5.	"Oral Interviews/Presentations and/or Demonstrations" (if required)	TBD
6.	Post "Notification of Intent to Award" to Internet at: http://das.nebraska.gov/materiel/purchasing.html	December 20, 2019 ~~December 6, 2019~~ ~~November 30,2019~~
7.	Contract finalization period	December 20, 2019 ~~December 6, 2019~~ ~~November 30, 2019~~ Through December 30, 2019
8.	Contract award	January 11 ,2020 ~~January 2, 2020~~

	ACTIVITY	DATE/TIME
9.	Contractor start date	January 11 ,2020 ~~January 2, 2020~~

This addendum will become part of the proposal and should be acknowledged with the RFP.

3M's Response: 3M acknowledges Addendum Two.

ADDENDUM ONE, REVISED SCHEDULE OF EVENTS

Date: October 18, 2019

To: All Bidders

From: Annette Walton / Nancy Storant, Buyer
AS Materiel Purchasing

RE: Addendum for RFP Number 6152 Z1 to be opened November 7, 2019 at 2:00 p.m. Central

Schedule of Events

The State expects to adhere to the tentative procurement schedule shown below. It should be noted, however, that some dates are approximate and subject to change. It is the Bidder's responsibility to check the State Purchasing Bureau website for all addenda or amendments.

	ACTIVITY	DATE/TIME
1.	Last day to submit written questions after Pre-Proposal Conference	October 23, 2019 ~~October 21, 2019~~
2.	State responds to written questions through Solicitation "Addendum" and/or "Amendment" to be posted to the Internet at: http://das.nebraska.gov/materiel/purchasing.html	October 28, 2019 ~~October 25,2019~~
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5.	Evaluation period	November 14, 2019 through November 20, 2019 ~~November 8, 2019~~ ~~through~~ ~~November 15, 2019~~
6.	"Oral Interviews/Presentations and/or Demonstrations" (if required)	TBD
7.	Post "Notification of Intent to Award" to Internet at: http://das.nebraska.gov/materiel/purchasing.html	December 6, 2019 ~~November 30,2019~~
8.	Contract finalization period	December 6, 2019 ~~November 30, 2019~~ Through December 30, 2019
9.	Contract award	January 2, 2020
10.	Contractor start date	January 2, 2020

This addendum will become part of the proposal and should be acknowledged with the RFP.

3M's Response: 3M acknowledges Addendum One.

3M Response

II. TERMS AND CONDITIONS

Bidders should complete Sections II through VI as part of their proposal. Bidder should read the Terms and Conditions and should initial either accept, reject, or reject and provide alternative language for each clause. The bidder should also provide an explanation of why the bidder rejected the clause or rejected the clause and provided alternate language. By signing the solicitation, bidder is agreeing to be legally bound by all the accepted terms and conditions, and any proposed alternative terms and conditions submitted with the proposal. The State reserves the right to negotiate rejected or proposed alternative language. If the State and bidder fail to agree on the final Terms and Conditions, the State reserves the right to reject the proposal. The State of Nebraska is soliciting proposals in response to this solicitation. The State of Nebraska reserves the right to reject proposals that attempt to substitute the bidder's commercial contracts and/or documents for this solicitation.

The bidder should submit with their proposal any license, user agreement, service level agreement, or similar documents that the bidder wants incorporated in the Contract. The State will not consider incorporation of any document not submitted with the bidder's proposal as the document will not have been included in the evaluation process. These documents shall be subject to negotiation and will be incorporated as addendums if agreed to by the Parties.

If a conflict or ambiguity arises after the Addendum to Contract Award have been negotiated and agreed to, the Addendum to Contract Award shall be interpreted as follows:

1. If only one Party has a particular clause then that clause shall control;
2. If both Parties have a similar clause, but the clauses do not conflict, the clauses shall be read together;
3. If both Parties have a similar clause, but the clauses conflict, the State's clause shall control.

A. GENERAL

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The contract resulting from this solicitation shall incorporate the following documents:

1. Request for Proposal and Addenda;
2. Amendments to the solicitation;
3. Questions and Answers;
4. Bidder's proposal (Solicitation and properly submitted documents);
5. The executed Contract and Addendum One to Contract, if applicable; and,
6. Amendments/Addendums to the Contract.

These documents constitute the entirety of the contract.

Unless otherwise specifically stated in a future contract amendment, in case of any conflict between the incorporated documents, the documents shall govern in the following order of preference with number one (1) receiving preference over all other documents and with each lower numbered document having preference over any higher numbered document: 1) Amendment to the executed Contract with the most recent dated amendment having the highest priority, 2) executed Contract and any attached Addenda, 3) Amendments to solicitation and any Questions and Answers, 4) the original solicitation document and any Addenda, and 5) the bidder's submitted Proposal.

Any ambiguity or conflict in the contract discovered after its execution, not otherwise addressed herein, shall be resolved in accordance with the rules of contract interpretation as established in the State of Nebraska.

B. NOTIFICATION

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Contractor and State shall identify the contract manager who shall serve as the point of contact for the executed contract.

Communications regarding the executed contract shall be in writing and shall be deemed to have been given if delivered personally or mailed, by U.S. Mail, postage prepaid, return receipt requested, to the parties at their respective addresses set forth below, or at such other addresses as may be specified in writing by either of the parties. All notices, requests, or communications shall be deemed effective upon personal delivery or five (5) calendar days following deposit in the mail.

Either party may change its address for notification purposes by giving notice of the change, and setting forth the new address and an effective date.

C. NOTICE BUYER'S REPRESENTATIVE

The State reserves the right to appoint a Buyer's Representative to manage [or assist the Buyer in managing] the contract on behalf of the State. The Buyer's Representative will be appointed in writing, and the appointment document will specify the extent of the Buyer's Representative authority and responsibilities. If a Buyer's Representative is appointed, the Contractor will be provided a copy of the appointment document, and is required to cooperate accordingly with the Buyer's Representative. The Buyer's Representative has no authority to bind the State to a contract, amendment, addendum, or other change or addition to the contract.

D. GOVERNING LAW (Statutory)

Notwithstanding any other provision of this contract, or any amendment or addendum(s) entered into contemporaneously or at a later time, the parties understand and agree that, (1) the State of Nebraska is a sovereign state and its authority to contract is therefore subject to limitation by the State's Constitution, statutes, common law, and regulation; (2) this contract will be interpreted and enforced under the laws of the State of Nebraska; (3) any action to enforce the provisions of this agreement must be brought in the State of Nebraska per state law; (4) the person signing this contract on behalf of the State of Nebraska does not have the authority to waive the State's sovereign immunity, statutes, common law, or regulations; (5) the indemnity, limitation of liability, remedy, and other similar provisions of the final contract, if any, are entered into subject to the State's Constitution, statutes, common law, regulations, and sovereign immunity; and, (6) all terms and conditions of the final contract, including but not limited to the clauses concerning third party use, licenses, warranties, limitations of liability, governing law and venue, usage verification, indemnity, liability, remedy or other similar provisions of the final contract are entered into specifically subject to the State's Constitution, statutes, common law, regulations, and sovereign immunity.

The Parties must comply with all applicable local, state and federal laws, ordinances, rules, orders, and regulations.

E. BEGINNING OF WORK

The Contractor shall not commence any billable work until a valid contract has been fully executed by the State and the successful Contractor. The Contractor will be notified in writing when work may begin.

F. AMENDMENT

This Contract may be amended in writing, within scope, upon the agreement of both parties.

G. CHANGE ORDERS OR SUBSTITUTIONS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The State and the Contractor, upon the written agreement, may make changes to the contract within the general scope of the solicitation. Changes may involve specifications, the quantity of work, or such other items as the State may find necessary or desirable. Corrections of any deliverable, service, or work required pursuant to the contract shall not be deemed a change. The Contractor may not claim forfeiture of the contract by reasons of such changes.

The Contractor shall prepare a written description of the work required due to the change and an itemized cost sheet for the change. Changes in work and the amount of compensation to be paid to the Contractor shall be determined in accordance with applicable unit prices if any, a pro-rated value, or through negotiations. The State shall not incur a price increase for changes that should have been included in the Contractor's proposal, were foreseeable, or result from difficulties with or failure of the Contractor's proposal or performance.

No change shall be implemented by the Contractor until approved by the State, and the Contract is amended to reflect the change and associated costs, if any. If there is a dispute regarding the cost, but both parties agree that immediate implementation is necessary, the change may be implemented, and cost negotiations may continue with both Parties retaining all remedies under the contract and law.
In the event any product is discontinued or replaced upon mutual consent during the contract period or prior to delivery, the State reserves the right to amend the contract or purchase order to include the alternate product at the same price.

*****Contractor will not substitute any item that has been awarded without prior written approval of SPB*****

H. VENDOR PERFORMANCE REPORT(S)

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The State may document any instance(s) of products or services delivered or performed which exceed or fail to meet the terms of the purchase order, contract, and/or solicitation specifications. The State Purchasing Bureau may contact the Vendor regarding any such report. Vendor performance report(s) will become a part of the permanent record of the Vendor.

I. NOTICE OF POTENTIAL CONTRACTOR BREACH

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

If Contractor breaches the contract or anticipates breaching the centract, the Contractor shall immediately give written notice to the State. The notice shall explain the breach or potential breach, a proposed cure, and may include a request for a waiver of the breach if so desired. The State may, in its discretion, temporarily or permanently waive the breach. By granting a waiver, the State does not forfeit any rights or remedies to which the State is entitled by law or equity, or pursuant to the provisions of the contract. Failure to give immediate notice, however, may be grounds for denial of any request for a waiver of a breach.

J. BREACH

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Either Party may terminate the contract, in whole or in part, if the other Party breaches its duty to perform its obligations under the contract in a timely and proper manner. Termination requires written notice of default and a thirty (30) calendar day (or longer at the non-breaching Party's discretion considering the gravity and nature of the default) cure period. Said notice shall be delivered by Certified Mail, Return Receipt Requested, or in person with proof of delivery. Allowing time to cure a failure or breach of contract does not waive the right to immediately terminate the contract for the same or different contract breach which may occur at a different time. In case of default of the Contractor, the State may contract the service from other sources and hold the Contractor responsible for any excess cost occasioned thereby. OR In case of breach by the Contractor, the State may, without unreasonable delay, make a good faith effort to make a reasonable purchase or contract to purchased goods in substitution of those due from the Contractor. The State may recover from the Contractor as damages the difference between the costs of covering the breach. Notwithstanding any clause to the contrary, the State may also recover the contract price together with any incidental or consequential damages defined in UCC Section 2-715, but less expenses saved in consequence of Contractor's breach.

The State's failure to make payment shall not be a breach, and the Contractor shall retain all available statutory remedies and protections.

K. NON-WAIVER OF BREACH

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The acceptance of late performance with or without objection or reservation by a Party shall not waive any rights of the Party nor constitute a waiver of the requirement of timely performance of any obligations remaining to be performed.

L. SEVERABILITY

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

If any term or condition of the contract is declared by a court of competent jurisdiction to be illegal or in conflict with any law, the validity of the remaining terms and conditions shall not be affected, and the rights and obligations of the parties shall be construed and enforced as if the contract did not contain the provision held to be invalid or illegal.

M. INDEMNIFICATION

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
	S.B.		Please see the 3M Comments and Qualifications table on Page 62-63 for 1.0 General and 2.0 Intellectual Property.

1. **GENERAL**
The Contractor agrees to defend, indemnify, and hold harmless the State and its employees, volunteers, agents, and its elected and appointed officials ("the indemnified parties") from and against any and all third party claims, liens, demands, damages, liability, actions, causes of action, losses, judgments, costs, and expenses of every nature, including investigation costs and expenses, settlement costs, and attorney fees and expenses ("the claims"), sustained or asserted against the State for personal injury, death, or property loss or damage, arising out of, resulting from, or attributable to the willful misconduct, negligence, error, or omission of the Contractor, its employees, subcontractors, consultants, representatives, and agents, resulting from this contract, except to the extent such Contractor liability is attenuated by any action of the State which directly and proximately contributed to the claims.

2. **INTELLECTUAL PROPERTY (Optional)**
The Contractor agrees it will, at its sole cost and expense, defend, indemnify, and hold harmless the indemnified parties from and against any and all claims, to the extent such claims arise out of, result from, or are attributable to, the actual or alleged infringement or misappropriation of any patent, copyright, trade secret, trademark, or confidential information of any third party by the Contractor or its employees, subcontractors, consultants, representatives, and agents; provided, however, the State gives the Contractor prompt notice in writing of the claim. The Contractor may not settle any infringement claim that will affect the State's use of the Licensed Software without the State's prior written consent, which consent may be withheld for any reason.

If a judgment or settlement is obtained or reasonably anticipated against the State's use of any intellectual property for which the Contractor has indemnified the State, the Contractor shall, at the Contractor's sole cost and expense, promptly modify the item or items which were determined to be infringing, acquire a license or licenses on the State's behalf to provide the necessary rights to the State to eliminate the infringement, or provide the State with a non-infringing substitute that provides the State the same functionality. At the State's election, the actual or anticipated judgment may be treated as a breach of warranty by the Contractor, and the State may receive the remedies provided under this solicitation.

3. **PERSONNEL**
The Contractor shall, at its expense, indemnify and hold harmless the indemnified parties from and against any claim with respect to withholding taxes, worker's compensation, employee benefits, or any other claim, demand, liability, damage, or loss of any nature relating to any of the personnel, including subcontractor's and their employees, provided by the Contractor

4. **SELF-INSURANCE**
The State of Nebraska is self-insured for any loss and purchases excess insurance coverage pursuant to Neb. Rev. Stat. § 81-8,239.01 (Reissue 2008). If there is a presumed loss under the provisions of this agreement, Contractor may file a claim with the Office of Risk Management pursuant to Neb. Rev. Stat. §§ 81-8,829 – 81-8,306 for review by the State Claims Board. The State retains all rights and immunities under the State Miscellaneous (§ 81-8,294), Tort (§ 81-8,209), and Contract Claim Acts (§ 81-8,302), as outlined in Neb. Rev. Stat. § 81-8,209 et seq. and under any other provisions of law and accepts liability under this agreement to the extent provided by law.

5. The Parties acknowledge that Attorney General for the State of Nebraska is required by statute to represent the legal interests of the State, and that any provision of this indemnity clause is subject to the statutory authority of the Attorney General.

N. ATTORNEY'S FEES

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

In the event of any litigation, appeal, or other legal action to enforce any provision of the contract, the Parties agree to pay all expenses of such action, as permitted by law and if ordered by the court, including attorney's fees and costs, if the other Party prevails.

O. PERFORMANCE BOND

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor will be required to supply a bond executed by a corporation authorized to contract surety in the State of Nebraska, payable to the State of Nebraska, which shall be valid for the life of the contract to include any renewal and/or extension periods. The amount of the bond must be equal to the amount of the bid the bond will guarantee that the Contractor will faithfully perform all requirements, terms and conditions of the contract. Failure to comply shall be grounds for forfeiture of the bond as liquidated damages. Amount of forfeiture will be determined by the agency based on loss to the State. The bond will be returned when the contract has been satisfactorily completed as solely determined by the State, after termination or expiration of the contract.

P. ASSIGNMENT, SALE, OR MERGER

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Either Party may assign the contract upon mutual written agreement of the other Party. Such agreement shall not be unreasonably withheld.

The Contractor retains the right to enter into a sale, merger, acquisition, internal reorganization, or similar transaction involving Contractor's business. Contractor agrees to cooperate with the State in executing amendments to the contract to allow for the transaction. If a third party or entity is involved in the transaction, the Contractor will remain responsible for performance of the contract until such time as the person or entity involved in the transaction agrees in writing to be contractually bound by this contract and perform all obligations of the contract.

Q. CONTRACTING WITH OTHER NEBRASKA POLITICAL SUB-DIVISIONS OF THE STATE OR ANOTHER STATE

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor may, but shall not be required to, allow agencies, as defined in Neb. Rev. Stat. §81-145, to use this contract. The terms and conditions, including price, of the contract may not be amended. The State shall not be contractually obligated or liable for any contract entered into pursuant to this clause. A listing of Nebraska political subdivisions may be found at the website of the Nebraska Auditor of Public Accounts.

The Contractor may, but shall not be required to, allow other states, agencies or divisions of other states, or political subdivisions of other states to use this contract. The terms and conditions, including price, of this contract shall apply to any such contract, but may be amended upon mutual consent of the Parties. The State of Nebraska shall not be contractually or otherwise obligated or liable under any contract entered into pursuant to this clause. The State shall be notified if a contract is executed based upon this contract.

R. FORCE MAJEURE

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Neither Party shall be liable for any costs or damages, or for default resulting from its inability to perform any of its obligations under the contract due to a natural or manmade event outside the control and not the fault of the affected Party ("Force Majeure Event"). The Party so affected shall immediately make a written request for relief to the other Party, and shall have the burden of proof to justify the request. The other Party may grant the relief requested; relief may not be unreasonably withheld. Labor disputes with the impacted Party's own employees will not be considered a Force Majeure Event.

S. CONFIDENTIALITY

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

All materials and information provided by the Parties or acquired by a Party on behalf of the other Party shall be regarded as confidential information. All materials and information provided or acquired shall be handled in accordance with federal and state law, and ethical standards. Should said confidentiality be breached by a Party, the Party shall notify the other Party immediately of said breach and take immediate corrective action.

It is incumbent upon the Parties to inform their officers and employees of the penalties for improper disclosure imposed by the Privacy Act of 1974, 5 U.S.C. 552a. Specifically, 5 U.S.C. 552a (i)(1), which is made applicable by 5 U.S.C. 552a (m)(1), provides that any officer or employee, who by virtue of his/her employment or official position has possession of or access to agency records which contain individually identifiable information, the disclosure of which is prohibited by the Privacy Act or regulations established thereunder, and who knowing that disclosure of the specific material is prohibited, willfully discloses the material in any manner to any person or agency not entitled to receive it, shall be guilty of a misdemeanor and fined not more than $5,000.

T. EARLY TERMINATION

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The contract may be terminated as follows:

1. The State and the Contractor, by mutual written agreement, may terminate the contract at any time.

2. The State, in its sole discretion, may terminate the contract for any reason upon thirty (30) calendar day's written notice to the Contractor. Such termination shall not relieve the Contractor of warranty or other service obligations incurred under the terms of the contract. In the event of termination the Contractor shall be entitled to payment, determined on a pro rata basis, for products or services satisfactorily performed or provided.

3. The State may terminate the contract immediately for the following reasons:

   a. if directed to do so by statute;
   b. Contractor has made an assignment for the benefit of creditors, has admitted in writing its inability to pay debts as they mature, or has ceased operating in the normal course of business;
   c. a trustee or receiver of the Contractor or of any substantial part of the Contractor's assets has been appointed by a court;
   d. fraud, misappropriation, embezzlement, malfeasance, misfeasance, or illegal conduct pertaining to performance under the contract by its Contractor, its employees, officers, directors, or shareholders;
   e. an involuntary proceeding has been commenced by any Party against the Contractor under any one of the chapters of Title 11 of the United States Code and (i) the proceeding has been pending for at least sixty (60) calendar days; or (ii) the Contractor has consented, either expressly or by operation of law, to the entry of an order for relief; or (iii) the Contractor has been decreed or adjudged a debtor;
   f. a voluntary petition has been filed by the Contractor under any of the chapters of Title 11 of the United States Code;
   g. Contractor intentionally discloses confidential information;
   h. Contractor has or announces it will discontinue support of the deliverable; and,
   i. In the event funding is no longer available.

U. CONTRACT CLOSEOUT

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Upon contract closeout for any reason the Contractor shall within 30 days, unless stated otherwise herein:

1. Transfer all completed or partially completed deliverables to the State;
2. Transfer ownership and title to all completed or partially completed deliverables to the State;
3. Return to the State all information and data, unless the Contractor is permitted to keep the information or data by contract or rule of law. Contractor may retain one copy of any information or data as required to comply with applicable work product documentation standards or as are automatically retained in the course of Contractor's routine back up procedures;
4. Cooperate with any successor Contactor, person or entity in the assumption of any or all of the obligations of this contract;
5. Cooperate with any successor Contactor, person or entity with the transfer of information or data related to this contract;
6. Return or vacate any state owned real or personal properly; and,
7. Return all data in a mutually acceptable format and manner.

Nothing in this Section should be construed to require the Contractor to surrender intellectual property, real or personal property, or information or data owned by the Contractor for which the State has no legal claim.

3M Response

III. CONTRACTOR DUTIES

A. INDEPENDENT CONTRACTOR / OBLIGATIONS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

It is agreed that the Contractor is an independent contractor and that nothing contained herein is intended or should be construed as creating or establishing a relationship of employment, agency, or a partnership.

The Contractor is solely responsible for fulfilling the contract. The Contractor or the Contractor's representative shall be the sole point of contact regarding all contractual matters.

The Contractor shall secure, at its own expense, all personnel required to perform the services under the contract. The personnel the Contractor uses to fulfill the contract shall have no contractual or other legal relationship with the State; they shall not be considered employees of the State and shall not be entitled to any compensation, rights or benefits from the State, including but not limited to, tenure rights, medical and hospital care, sick and vacation leave, severance pay, or retirement benefits.

By-name personnel commitments made in the Contractor's proposal shall not be changed without the prior written approval of the State. Replacement of these personnel, if approved by the State, shall be with personnel of equal or greater ability and qualifications.

All personnel assigned by the Contractor to the contract shall be employees of the Contractor or a subcontractor, and shall be fully qualified to perform the work required herein. Personnel employed by the Contractor or a subcontractor to fulfill the terms of the contract shall remain under the sole direction and control of the Contractor or the subcontractor respectively.

With respect to its employees, the Contractor agrees to be solely responsible for the following:

1. Any and all pay, benefits, and employment taxes and/or other payroll withholding;
2. Any and all vehicles used by the Contractor's employees, including all insurance required by state law;
3. Damages incurred by Contractor's employees within the scope of their duties under the contract;
4. Maintaining Workers' Compensation and health insurance that complies with state and federal law and submitting any reports on such insurance to the extent required by governing law;
5. Determining the hours to be worked and the duties to be performed by the Contractor's employees; and,
6. All claims on behalf of any person arising out of employment or alleged employment (including without limit claims of discrimination alleged against the Contractor, its officers, agents, or subcontractors or subcontractor's employees)

If the Contractor intends to utilize any subcontractor, the subcontractor's level of effort, tasks, and time allocation should be clearly defined in the Contractor's proposal. The Contractor shall agree that it will not utilize any subcontractors not specifically included in its proposal in the performance of the contract without the prior written authorization of the State.

The State reserves the right to require the Contractor to reassign or remove from the project any Contractor or subcontractor employee.

Contractor shall insure that the terms and conditions contained in any contract with a subcontractor does not conflict with the terms and conditions of this contract.

The Contractor shall include a similar provision, for the protection of the State, in the contract with any subcontractor engaged to perform work on this contract.

B. EMPLOYEE WORK ELIGIBILITY STATUS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor is required and hereby agrees to use a federal immigration verification system to determine the work eligibility status of employees physically performing services within the State of Nebraska. A federal immigration verification system means the electronic verification of the work authorization program authorized by the Illegal Immigration Reform and Immigrant Responsibility Act of 1996, 8 U.S.C. 1324a, known as the E-Verify Program, or an equivalent federal program designated by the United States Department of Homeland Security or other federal agency authorized to verify the work eligibility status of an employee.

If the Contractor is an individual or sole proprietorship, the following applies:

1. The Contractor must complete the United States Citizenship Attestation Form, available on the Department of Administrative Services website at http://das.nebraska.gov/materiel/purchasing.html

2. The completed United States Attestation Form should be submitted with the solicitation response.

3. If the Contractor indicates on such attestation form that he or she is a qualified alien, the Contractor agrees to provide the US Citizenship and Immigration Services documentation required to verify the Contractor's lawful presence in the United States using the Systematic Alien Verification for Entitlements (SAVE) Program.

4. The Contractor understands and agrees that lawful presence in the United States is required and the Contractor may be disqualified or the contract terminated if such lawful presence cannot be verified as required by Neb. Rev. Stat. §4-108.

C. COMPLIANCE WITH CIVIL RIGHTS LAWS AND EQUAL OPPORTUNITY EMPLOYMENT / NONDISCRIMINATION (Statutory)

The Contractor shall comply with all applicable local, state, and federal statutes and regulations regarding civil rights laws and equal opportunity employment. The Nebraska Fair Employment Practice Act prohibits Contractors of the State of Nebraska, and their subcontractors, from discriminating against any employee or applicant for employment, with respect to hire, tenure, terms, conditions, compensation, or privileges of employment because of race, color, religion, sex, disability, marital status, or national origin (Neb. Rev. Stat. §48-1101 to 48-1125). The Contractor guarantees compliance with the Nebraska Fair Employment Practice Act, and breach of this provision shall be regarded as a material breach of contract. The Contractor shall insert a similar provision in all subcontracts for goods and services to be covered by any contract resulting from this solicitation.

D. COOPERATION WITH OTHER CONTRACTORS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Contractor may be required to work with or in close proximity to other Contractors or individuals that may be working on same or different projects. The Contractor shall agree to cooperate with such other Contractors or individuals, and shall not commit or permit any act which may interfere with the performance of work by any other Contractor or individual. Contractor is not required to compromise Contractor's intellectual property or proprietary information unless expressly required to do so by this contract.

E. PERMITS, REGULATIONS, LAWS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The contract price shall include the cost of all royalties, licenses, permits, and approvals, whether arising from patents, trademarks, copyrights or otherwise, that are in any way involved in the contract. The Contractor shall obtain and pay for all royalties, licenses, and permits, and approvals necessary for the execution of the contract. The Contractor must guarantee that it has the full legal right to the materials, supplies, equipment, software, and other items used to execute this contract.

F. OWNERSHIP OF INFORMATION AND DATA / DELIVERABLES

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The State shall have the unlimited right to publish, duplicate, use, and disclose all information and data developed or obtained by the Contractor on behalf of the State pursuant to this contract.

The State shall own and hold exclusive title to any deliverable developed as a result of this contract. Contractor shall have no ownership interest or title, and shall not patent, license, or copyright, duplicate, transfer, sell, or exchange, the design, specifications, concept, or deliverable.

G. INSURANCE REQUIREMENTS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor shall throughout the term of the contract maintain insurance as specified herein and provide the State a current Certificate of Insurance/Acord Form (COI) verifying the coverage. The Contractor shall not commence work on the contract until the insurance is in place. If Contractor subcontracts any portion of the Contract the Contractor must, throughout the term of the contract, either:

1. Provide equivalent insurance for each subcontractor and provide a COI verifying the coverage for the subcontractor;
2. Require each subcontractor to have equivalent insurance and provide written notice to the State that the Contractor has verified that each subcontractor has the required coverage; or,
3. Provide the State with copies of each subcontractor's Certificate of Insurance evidencing the required coverage.

The Contractor shall not allow any subcontractor to commence work until the subcontractor has equivalent insurance. The failure of the State to require a COI, or the failure of the Contractor to provide a COI or require subcontractor insurance shall not limit, relieve, or decrease the liability of the Contractor hereunder.

In the event that any policy written on a claims-made basis terminates or is canceled during the term of the contract or within one (1) years of termination or expiration of the contract, the Contractor shall obtain an extended discovery

or reporting period, or a new insurance policy, providing coverage required by this contract for the term of the contract and one (1) years following termination or expiration of the contract.

If by the terms of any insurance a mandatory deductible is required, or if the Contractor elects to increase the mandatory deductible amount, the Contractor shall be responsible for payment of the amount of the deductible in the event of a paid claim.

Notwithstanding any other clause in this Contract, the State may recover up to the liability limits of the insurance policies required herein.

1. **WORKERS' COMPENSATION INSURANCE**

The Contractor shall take out and maintain during the life of this contract the statutory Workers' Compensation and Employer's Liability Insurance for all of the contactors' employees to be engaged in work on the project under this contract and, in case any such work is sublet, the Contractor shall require the subcontractor similarly to provide Worker's Compensation and Employer's Liability Insurance for all of the subcontractor's employees to be engaged in such work. This policy shall be written to meet the statutory requirements for the state in which the work is to be performed, including Occupational Disease. **The policy shall include a waiver of subrogation in favor of the State. The COI shall contain the mandatory COI subrogation waiver language found hereinafter**. The amounts of such insurance shall not be less than the limits stated hereinafter. For employees working in the State of Nebraska, the policy must be written by an entity authorized by the State of Nebraska Department of Insurance to write Workers' Compensation and Employer's Liability Insurance for Nebraska employees.

2. **COMMERCIAL GENERAL LIABILITY INSURANCE AND COMMERCIAL AUTOMOBILE LIABILITY INSURANCE**

The Contractor shall take out and maintain during the life of this contract such Commercial General Liability Insurance and Commercial Automobile Liability Insurance as shall protect Contractor and any subcontractor performing work covered by this contract from claims for damages for bodily injury, including death, as well as from claims for property damage, which may arise from operations under this contract, whether such operation be by the Contractor or by any subcontractor or by anyone directly or indirectly employed by either of them, and the amounts of such insurance shall not be less than limits stated hereinafter.

The Commercial General Liability Insurance shall be written on an **occurrence basis**, and provide Premises/Operations, Products/Completed Operations, Independent Contractors, Personal Injury, and Contractual Liability coverage **The policy shall include the State, and others as required by the contract documents, as Additional Insured(s). This policy shall be primary, and any insurance or self-insurance carried by the State shall be considered secondary and non-contributory**. **The COI shall contain the mandatory COI liability waiver language found hereinafter.** The Commercial Automobile Liability Insurance shall be written to cover all Owned, Non-owned, and Hired vehicles.

REQUIRED INSURANCE COVERAGE	
COMMERCIAL GENERAL LIABILITY	
General Aggregate	$2,000,000
Products/Completed Operations Aggregate	$2,000,000
Personal/Advertising Injury	$1,000,000 per occurrence
Bodily Injury/Property Damage	$1,000,000 per occurrence
Medical Payments	$10,000 any one person
Damage to Rented Premises (Fire)	$300,000 each occurrence
Contractual	Included
XCU Liability (Explosion, Collapse, and Underground Damage)	Included
Independent Contractors	Included
Abuse & Molestation	Included
If higher limits are required, the Umbrella/Excess Liability limits are allowed to satisfy the higher limit.	
WORKER'S COMPENSATION	
Employers Liability Limits	$500K/$500K/$500K
Statutory Limits- All States	Statutory - State of Nebraska
Voluntary Compensation	Statutory
COMMERCIAL AUTOMOBILE LIABILITY	
Bodily Injury/Property Damage	$1,000,000 combined single limit
Include All Owned, Hired & Non-Owned Automobile liability	Included
Motor Carrier Act Endorsement	Where Applicable
UMBRELLA/EXCESS LIABILITY	
Over Primary Insurance	$5,000,000 per occurrence
CYBER LIABILITY	
Breach of Privacy, Security Breach, Denial of Service, Remediation, Fines and Penalties	$10,000,000
MANDATORY COI SUBROGATION WAIVER LANGUAGE	
"Workers' Compensation policy shall include a waiver of subrogation in favor of the State of Nebraska."	
MANDATORY COI LIABILITY WAIVER LANGUAGE	
"Commercial General Liability & Commercial Automobile Liability policies shall name the State of Nebraska as an Additional Insured and the policies shall be primary and any insurance or self-insurance carried by the State shall be considered secondary and non-contributory as additionally insured."	

3. **EVIDENCE OF COVERAGE**

The Contractor shall furnish the Contract Manager, with a certificate of insurance coverage complying with the above requirements prior to beginning work at:

Agency Cornhusker State Industries
Attn: Business Manager
Address 800 Pioneers Blvd
City, State, Zip Lincoln, NE 68502

These certificates or the cover sheet shall reference the RFP number, and the certificates shall include the name of the company, policy numbers, effective dates, dates of expiration, and amounts and types of coverage afforded. If the State is damaged by the failure of the Contractor to maintain such insurance, then the Contractor shall be responsible for all reasonable costs properly attributable thereto.

Reasonable notice of cancellation of any required insurance policy must be submitted to the contract manager as listed above when issued and a new coverage binder shall be submitted immediately to ensure no break in coverage.

4. **DEVIATIONS**

The insurance requirements are subject to limited negotiation. Negotiation typically includes, but is not necessarily limited to, the correct type of coverage, necessity for Workers' Compensation, and the type of automobile coverage carried by the Contractor.

H. NOTICE OF POTENTIAL CONTRACTOR BREACH

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

If Contractor breaches the contract or anticipates breaching the contract the Contractor shall immediately give written notice to the State. The notice shall explain the breach or potential breach, and may include a request for a waiver of the breach if so desired. The State may, at its discretion, temporarily or permanently waive the breach. By granting a temporary waiver, the State does not forfeit any rights or remedies to which the State is entitled by law or equity, or pursuant to the provisions of the contract. Failure to give immediate notice, however, may be grounds for denial of any request for a waiver of a breach.

I. ANTITRUST

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
	S.B.		Please see the 3M Comments and Qualifications table on pages 62-63.

The Contractor hereby assigns to the State any and all claims for overcharges as to goods and/or services provided in connection with this contract resulting from antitrust violations which arise under antitrust laws of the United States and the antitrust laws of the State.

J. CONFLICT OF INTEREST

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
	S.B.		Please see the 3M Comments and Qualifications table on pages 62-63..

By submitting a proposal, bidder certifies that no relationship exists between the bidder and any person or entity which either is, or gives the appearance of, a conflict of interest related to this Request for Proposal or project.

Bidder further certifies that bidder will not employ any individual known by bidder to have a conflict of interest nor shall bidder take any action or acquire any interest, either directly or indirectly, which will conflict in any manner or degree with the performance of its contractual obligations hereunder or which creates an actual or appearance of conflict of interest.

If there is an actual or perceived conflict of interest, bidder shall provide with its proposal a full disclosure of the facts describing such actual or perceived conflict of interest and a proposed mitigation plan for consideration. The State will then consider such disclosure and proposed mitigation plan and either approve or reject as part of the overall bid evaluation.

K. STATE PROPERTY

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor shall be responsible for the proper care and custody of any State-owned property which is furnished for the Contractor's use during the performance of the contract. The Contractor shall reimburse the State for any loss or damage of such property; normal wear and tear is expected.

L. SITE RULES AND REGULATIONS

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor shall use its best efforts to ensure that its employees, agents, and Subcontractors comply with site rules and regulations while on State premises. If the Contractor must perform on-site work outside of the daily operational hours set forth by the State, it must make arrangements with the State to ensure access to the facility and the equipment has been arranged. No additional payment will be made by the State on the basis of lack of access, unless the State fails to provide access as agreed to in writing between the State and the Contractor.

1. NDCS SECURITY

a. CONTRACTOR'S personnel shall be subject to Nebraska Department of Correctional Services' (NDCS) background security checks prior to their arrival on site, and will carry proper identification with them at all times while on facility grounds. Please see Attachment One Personal Information for Security Check NCDS form DCS-A-per-002-pc

b. CONTRACTOR shall provide a list of personnel commitments and their information prior to the start of the contract. The list of personnel shall not be changed without the prior written approval of NDCS. Replacement of key personnel, if approved by NDCS, shall be with personnel of equal or greater ability and qualifications.

c. CONTRACTOR shall make its employees aware of the provisions of Neb. Rev. Stat. § 28-322.01, which state that a person commits the offense of sexual abuse of an inmate or parolee if such person subjects an inmate or parolee to sexual penetration or sexual contact, because an inmate or parolee is not legally capable of giving consent to any such relationship. Neb. Rev. Stat. § 28-322 states that individuals "working under contract with the department" are included in the list of persons prohibited from having sexual relations with one or more of NDCS' inmates. CONTRACTOR will promptly notify NDCS if allegations of sexual abuse or contact become known.

d. CONTRACTOR shall make his/her employees aware of the Nebraska Department of Correctional Services, Policy 112.31 (Code of Ethics and Conduct). Please see Attachment Four – Administrative Regulation 112.31. CONTRACTOR may be required to sign and return documentation showing receipt of NDCS Policy 112.31 (Code of Ethics and Conduct). Please see Attachment Three - Receipt of Rules.

e. CONTRACTOR shall inform his/her personnel of the Nebraska Department of Correctional Services Tobacco Policy, which states that tobacco and tobacco-related products are contraband and must not be carried into any NDCS-owned or controlled property. Such products must remain in CONTRACTOR'S locked vehicle while on NDCS-owned or controlled property.

f. CONTRACTOR'S personnel may be subject to pat searches and tool inventory upon arrival and departure from NDCS facilities.

g. Wireless devices and/or cellular phones are prohibited at NDCS facilities unless prior approval is given. If wireless devices are necessary for use on site at NDCS, CONTRACTOR will seek prior approval to carry such devices by requesting the Cellular Device Institutional Use Report form. All persons are prohibited from providing a cellphone/electronic communication device to an inmate of any facility, per PD 104.06. Please see Attachment Five – Cellular Device Institutional Use Request and Attachment Six – Administrative Regulation 104.06 Computer Equipment Telephone Usage.

M. ADVERTISING

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Contractor agrees not to refer to the contract award in advertising in such a manner as to state or imply that the company or its goods or services are endorsed or preferred by the State. Any publicity releases pertaining to the project shall not be issued without prior written approval from the State.

N. DISASTER RECOVERY/BACK UP PLAN

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			Per the Section V. Project Description and Scope of Work, I.1.e requirement, this will be provided 60 days after award of contract within Milestone One deliverable.

The Contractor shall have a disaster recovery and back-up plan, of which a copy should be provided upon request to the State, which includes, but is not limited to equipment, personnel, facilities, and transportation, in order to continue delivery of goods and services as specified under the specifications in the contract in the event of a disaster.

O. DRUG POLICY

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Contractor certifies it maintains a drug free work place environment to ensure worker safety and workplace integrity. Contractor agrees to provide a copy of its drug free workplace policy at any time upon request by the State.

P. WARRANTY

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Despite any clause to the contrary, the Contractor represents and warrants that its services hereunder shall be performed by competent personnel and shall be of professional quality consistent with generally accepted industry standards for the performance of such services and shall comply in all respects with the requirements of this Agreement. For any breach of this warranty, the Contractor shall, for a period of ninety (90) days from performance of the service, perform the services again, at no cost to the State, or if Contractor is unable to perform the services as warranted, Contractor shall reimburse the State all fees paid to Contractor for the unsatisfactory services. The rights and remedies of the parties under this warranty are in addition to any other rights and remedies of the parties provided by law or equity, including, without limitation actual damages, and, as applicable and awarded under the law, to a prevailing party, reasonable attorneys' fees and costs.

IV. PAYMENT

A. PROHIBITION AGAINST ADVANCE PAYMENT (Statutory)

Neb. Rev. Stat. §§81-2403 states, "[n]o goods or services shall be deemed to be received by an agency until all such goods or services are completely delivered and finally accepted by the agency."

B. TAXES (Statutory)

The State is not required to pay taxes and assumes no such liability as a result of this solicitation. The Contractor may request a copy of the Nebraska Department of Revenue, Nebraska Resale or Exempt Sale Certificate for Sales Tax Exemption, Form 13 for their records. Any property tax payable on the Contractor's equipment which may be installed in a state-owned facility is the responsibility of the Contractor

C. INVOICES

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

Invoices for payments must be submitted by the Contractor to the agency requesting the services with sufficient detail to support payment.

Invoices to: NE Department of Correctional Services
Accounts Payable
P.O. Box 94661
Lincoln, NE 68509-4661

Accounts Payable Contact: (402) 479-5715

Invoices may be emailed to: DCSAccountsPayable@nebraska.gov

The terms and conditions included in the Contractor's invoice shall be deemed to be solely for the convenience of the parties. No terms or conditions of any such invoice shall be binding upon the State, and no action by the State, including without limitation the payment of any such invoice in whole or in part, shall be construed as binding or estopping the State with respect to any such term or condition, unless the invoice term or condition has been previously agreed to by the State as an amendment to the contract.

D. INSPECTION AND APPROVAL

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
	S.B.		Please see the 3M Comments and Qualifications table on pages 62-63 for H. Right To Audit.

Final inspection and approval of all work required under the contract shall be performed by the designated State officials.

The State and/or its authorized representatives shall have the right to enter any premises where the Contractor or subcontractor duties under the contract are being performed, and to inspect, monitor or otherwise evaluate the work being performed. All inspections and evaluations shall be at reasonable times and in a manner that will not unreasonably delay work.

E. PAYMENT (Statutory)

Payment will be made by the responsible agency in compliance with the State of Nebraska Prompt Payment Act (See Neb. Rev. Stat. §81-2403). The State may require the Contractor to accept payment by electronic means such as ACH deposit. In no event shall the State be responsible or liable to pay for any goods and services provided by the Contractor prior to the Effective Date of the contract, and the Contractor hereby waives any claim or cause of action for any such services.

F. LATE PAYMENT (Statutory)

The Contractor may charge the responsible agency interest for late payment in compliance with the State of Nebraska Prompt Payment Act (See Neb. Rev. Stat. §81-2401 through 81-2408).

G. SUBJECT TO FUNDING / FUNDING OUT CLAUSE FOR LOSS OF APPROPRIATIONS (Statutory)

The State's obligation to pay amounts due on the Contract for a fiscal years following the current fiscal year is contingent upon legislative appropriation of funds. Should said funds not be appropriated, the State may terminate the contract with respect to those payments for the fiscal year(s) for which such funds are not appropriated. The State will give the Contractor written notice thirty (30) calendar days prior to the effective date of termination. All obligations of the State to make payments after the termination date will cease. The Contractor shall be entitled to receive just and equitable compensation for any authorized work which has been satisfactorily completed as of the termination date. In no event shall the Contractor be paid for a loss of anticipated profit.

H. RIGHT TO AUDIT (First Paragraph is Statutory)

The State shall have the right to audit the Contractor's performance of this contract upon a thirty (30) days' written notice. Contractor shall utilize generally accepted accounting principles, and shall maintain the accounting records, and other records and information relevant to the contract (Information) to enable the State to audit the contract. (Neb. Rev. Stat. §84-304 et seq.) The State may audit and the Contractor shall maintain, the Information during the term of the contract and for a period of five (5) years after the completion of this contract or until all issues or litigation are resolved, whichever is later. The Contractor shall make the Information available to the State at Contractor's place of business or a location acceptable to both Parties during normal business hours. If this is not practical or the Contractor so elects, the Contractor may provide electronic or paper copies of the Information. The State reserves the right to examine, make copies of, and take notes on any Information relevant to this contract, regardless of the form or the Information, how it is stored, or who possesses the Information. Under no circumstance will the Contractor be required to create or maintain documents not kept in the ordinary course of Contractor's business operations, nor will Contractor be required to disclose any information, including but not limited to product cost data, which is confidential or proprietary to Contractor.

Accept (Initial)	Reject (Initial)	Reject & Provide Alternative within Solicitation Response (Initial)	NOTES/COMMENTS:
S.B.			

The Parties shall pay their own costs of the audit unless the audit finds a previously undisclosed overpayment by the State. If a previously undisclosed overpayment exceeds one-half of one percent (.05%) of the total contract billings, or if fraud, material misrepresentations, or non-performance is discovered on the part of the Contractor, the Contractor shall reimburse the State for the total costs of the audit. Overpayments and audit costs owed to the State shall be paid within ninety (90) days of written notice of the claim. The Contractor agrees to correct any material weaknesses or condition found as a result of the audit.

3M Response

V. PROJECT DESCRIPTION AND SCOPE OF WORK

The Contractor should provide the following information in response to this solicitation

A. PROJECT OVERVIEW

This solicitation shall cover all materials, equipment, installation, maintenance and relocation of old equipment that shall be required to implement a License Plate Blanking Line. This system shall be defined as a group of machines that handles the raw aluminum material through de-coiling, laminating and plate finishing.

B. PROJECT ENVIRONMENT

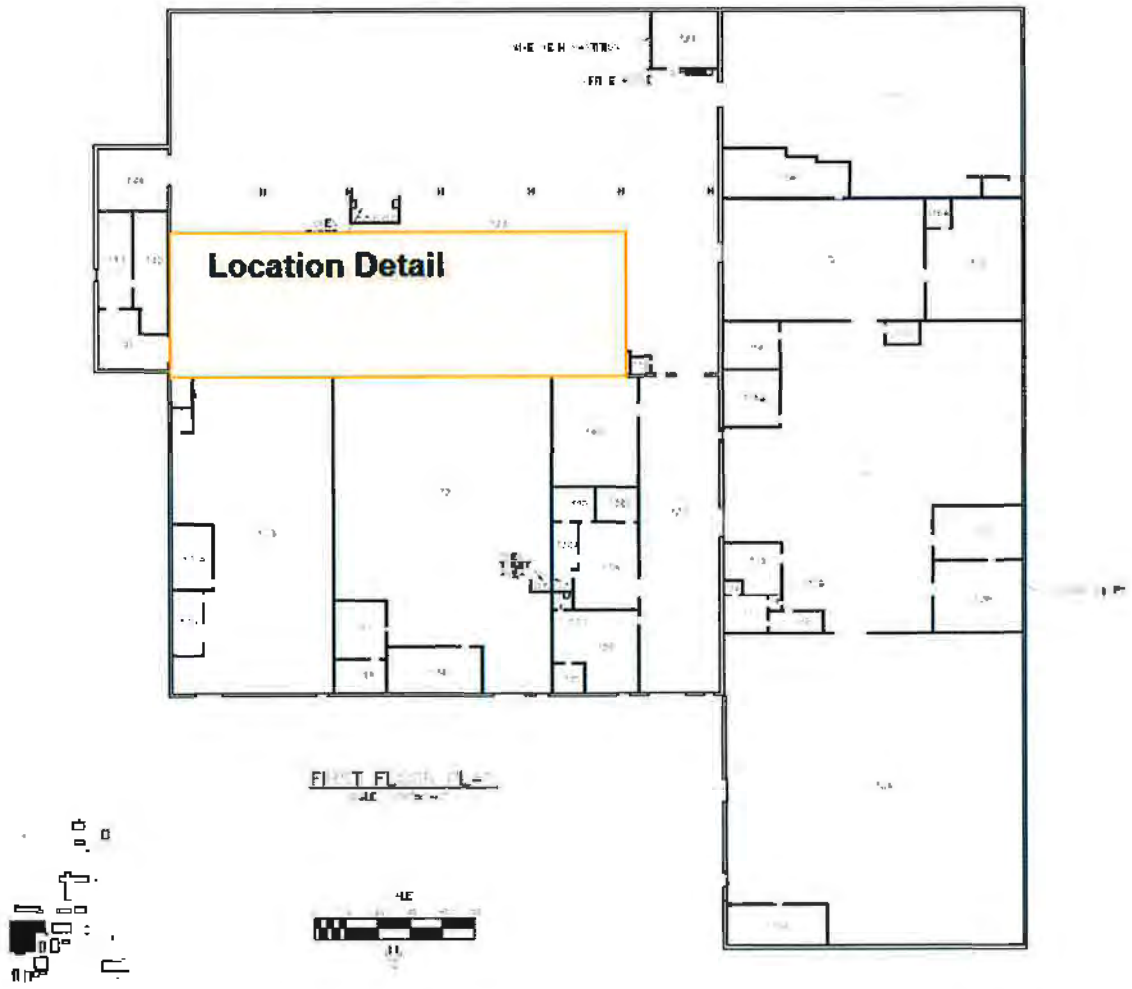
The blanking line will be located within the License Plate Shop on the secure side of the Nebraska State Penitentiary in Lincoln, NE. The Contractor should expect minimal supervised contact with incarcerated individuals.

1. The existing blanking line may be viewed at https://www.youtube.com/watch?v=EyQLZaPh_tQ

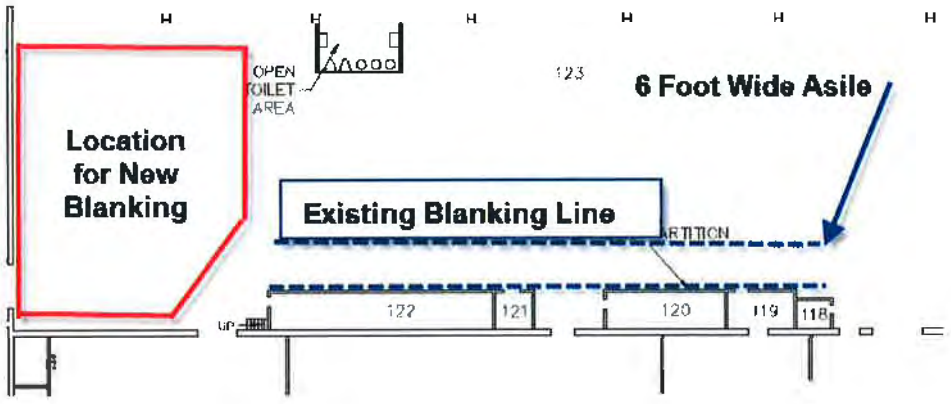
2. Standard Utilities and working conditions in the License plates shop include:
   a. Compressed air at 120 PSI line pressure with enough system head room to supply approximately 20 CFM.
   b. Electrical Power is available in single phase 120V, 3 phase 240. The main connection panel is located approximately 160 feet from the proposed line location. CSI will run electrical drops to the new location as needed
   c. The floor is approximately 8 inch thick concrete slab with some unspecified area(s) of reinforced foundation.
   d. The work area is heated however it is not air conditioned.
   e. A 4000# @ 24 inch electric forklift is available for onsite use.
   f. The ceiling height is 14 feet
   g. The building has doors that are 9 feet, 9 inches wide by 12 feet tall
   h. Aisle is 6 feet clear access to move equipment in.

3. There is one choice for new equipment installation and layout location. See Table 1 Building Floor Plan.
   a. 42"3" x51' open area to place the new line. This location will not require any current equipment relocation.

Table 1. Building Floor Plan



Building Detail



Location detail

4. All work is to be completed under the institution security policies in effect at that time See Section 111.L Site Rules and Regulations. This may include:
   - **a.** All contractor personnel subject to background checks, Security office approvals and searched prior to entry into the facility.
   - **b.** All Trucks and equipment must enter a security gate 16 feet wide by 13 feet tall and any additional motorized equipment must be moved outside the security fence at the end of each work day.
   - **c.** All tools shall be inventoried and secured each day.

3M's Response: 3M understands and acknowledges the project environment requirements.

A. PROJECT REQUIREMENTS

The purpose of this RFP is to procure the turn key, (design, manufacture and installation) of a new License Plate Blanking Line. This manufacturing line shall use the raw materials currently used by CSI license plate manufacturing shop. The equipment identified below contains minimum specifications required. If bidder has alternative equipment that can perform the functions to the same standard, the bidder should submit a response with details to support the assertion. The technical approach shall establish the ability of the Contractor to use raw materials provided by the State. The Contractor shall include detailed specifications for each piece of equipment of the License Plate Blanking Line. Contractor shall be totally responsible for all engineering and integration requirements; relocation of current blanking line installation of all new equipment and accessories, production data and services to end with a functioning manufacturing line with mutually agreeable timeline for interruption of production.

Contractor shall be responsible for the procurement and delivery of all equipment and appropriate accessory items necessary for a complete manufacturing line, functional for its intended use and approved by CSI. This design and installation service by the Contractor shall be in cooperation with Cornhusker State Industries (CSI).

Final Payment shall be due upon CSI final written approval and after meeting the following requirements per the Prompt Payment Act:

1. At the conclusion of work the License Plate Blanking line shall produce:
   - **a.** A takt time of 4000 plates per hour of either motorcycle and/or automotive size laminated license plates;
   - **b.** With no defects or flaws in the final product
     - **i.** Examples of specific defects that are not acceptable are: scratches, bubbles, delamination of the printed material, stretch marks, and sharp edges or burrs;
   - **c.** All mounting and utility connection materials shall be included for hook-up to CSI's distributed utilities;
   - **d.** Contractor shall ensure processing of all warranty information to appropriate entity;
   - **e.** Manufacturing line documentation including, but not limited to: equipment manuals, final blueprints, operator instructions, troubleshooting guides, replacement parts lists, firmware and software backups, suggested replacement parts stock lists, preventative maintenance instructions, maintenance item specifications must be kept up to date on a quarterly basis;
   - **f.** Warranty and support confact list must be provided; and,
   - **g.** All onsite training must be complete prior to final approval.
     - **i.** The setup and operation process shall be repeatable with at least three different detail operators as part of the approval.
     - **ii.** Initially trained individuals must be able to train future workers.

3M's Response: 3M has successfully installed many blanking lines over the past 30 years, most of which are still in use today. Our experience and the equipment we provide allows 3M to meet the requirements as indicated in this section. 3M's blanking line will meet the 4000 plate per hour requirement, with little to no defects as indicated in item A.1.b, using the utility connections provided by CSI as indicated in A.1.c. 3M provides a warranty for its equipment and will provide that information to the appropriate entity. 3M provides various documentation such as a user's manual, maintenance manual, electrical schematics and other miscellaneous documentation for the blanking

equipment. 3M's provides industry leading service and support and is available to resolve any outstanding issues with the 3M blanking line except for blanking die sharpening. CSI will continue to maintain and sharpen the blanking dies as is done today. 3M has a toll-free support number that identified CSI personnel can use to call in for support when needed. We also provide onsite training during and after the install as indicated in item A.1.g.

D. BUSINESS REQUIREMENTS

The State is not required to pay taxes and assumes no such liability as a result of this solicitation. The Contractor may request a copy of the Nebraska Department of Revenue, Nebraska Resale or Exempt Sale Certificate for Sales Tax Exemption, Form 13 for their records. Any property tax payable on the Contractor's equipment which may be installed in a state-owned facility is the responsibility of the Contractor.

3M's Response: 3M understands and acknowledges this requirement

E. SCOPE OF WORK

1. Project Parameters:

a. Sites/Facilities:

Nebraska State Penitentiary
License Plate Facility
14th and Pioneers Blvd.
Lincoln, NE 68542-2500

b. Industry/Products to be manufactured:

Passenger Size, nominal 6"x12" license plates
Motorcycle Size, nominal 4"x7" license plates

2. Equipment Items to Be Furnished and Specifications

No.	Qty.	Description
1	1	Horizontal Pallet Decoiler
2	1	Stock Straightener
3	1	Applicator System
4	1	Registry Feed System
5	1	Blanking Press
6	3	Two Stage Compound Blanking Die
7	1	Main Control System

The equipment and accessories required above should conform to the specifications and shall be provided complete including freight, FOB Destination, to the plant site. Equipment proposed shall be the latest current models in production as of the date of the solicitation and be of proven performance and under standard design, complete as regularly advertised and marketed and shall be delivered complete with all necessary parts, specified accessories, tools, and special features, whether or not they may be specifically mentioned below.

Two sets of operation and parts manuals for each piece of installed equipment shall either be collated into binders and provided to the industry supervisor or provide copies of printable electronic manuals

Warranty from the Contractor for all equipment, materials, and workmanship shall be a minimum of one (1) year with warranty period starting at the completion of equipment installation.
Replacement parts shall be readily available for a min of 12 years after the warranty expiration.

3M's Response: 3M understands and agrees to the E.1 requirements listed above. 3M proposes the equipment as listed in E.2 above except for the stock straightener and the main control cabinet. 3M supplies a powered horizontal unwind decoiler along with a component of the electronic roll feed which eliminates the need for a stock straightener and 3M's blanking line components operate without a main control cabinet. 3M's equipment is currently used in several states and has proven to meet the Project Requirements as identified for producing license plates. 3M's supplies manuals for its equipment and warrants its equipment for one year except for blanking die sharpening. CSI will continue to maintain and sharpen the blanking dies as is done today. We provide replacement parts for 12 years as indicated.

F. **BIDDER REQUIREMENTS**

The Contractor shall be responsible for the coordination of this entire project: engineering, equipment/accessories, installation, and production services (such as training, start-up, troubleshooting, service, maintenance). The following information should be submitted by the bidder for evaluation. Any proprietary or confidential documentation should be submitted as outlined on the first page of this document.

1. Provide Draft Project Plan with proposal for evaluation of the following:

2. Design/Development Services:
   - a. Facilities & Equipment
     - i. Building Preparation - The bidder shall thoroughly review all details for building preparation, including, but not limited to: building structure, floor construction, electrical, compressed air, gas and water, as required.
       - 1). Based on the proposed equipment, bidder shall provide within their proposal a list of all necessary preparations that CSI should make or modification that will need to be made to the building prior to delivery and installation by the Contractor.
       - 2). CSI will be responsible for all building infrastructure modifications and these cost should NOT be included in the bidders response.
     - ii. Custom Equipment Design -Complete detailed design of custom equipment as required. Proposal should include a detailed blueprint of the equipment as designed. If not included within the proposal, bidder will be required to provide within five (5) business days of a written request by DAS.
     - iii. Installation Drawings -Layout drawing(s) should be provided to CSI to assist in the review of equipment installation. Information should include utility connections, assembly and mounting details.
     - iv. Estimated installation timeline, including relocation of existing line, installation, implementation, and training of operators, etc. of new line, including estimated timeline for interruption of production.
   - b. Codes and Environmental Issues

   Contractor shall design and install all equipment in accordance following all applicable codes. Examples might be National Electrical Code, National Fire Protection Association Standards, OSHA, and applicable building code.

3. Complete and return Attachment Two – Requirements Matrix.

3M's Response: 3M has reviewed the current facility details. 3M requests that CSI provide the necessary utility drops to the equipment in which the new blanking line will be installed. Note – the utility requirements for the 3M blanking line components are listed in our attachment two requirements matrix response. The 3M blanking line equipment proposed for CSI is standard in that it has been supplied to other agencies in the past. 3M is not creating custom blanking line equipment for CSI. 3M will supply electrical schematics of the 3M built components. See the attached blanking line layout pdf file for a drawing of the 3M blanking line layout. It typically takes 10 business days to install, confirm successful operation and train blanking line operators. 3M will provide details of the installation timeline as part of the Milestone 1 deliverable as indicated in section I. Deliverables.

G. **PERFORM IMPLEMENTATION – INSTALLATION SERVICES**

The Contractor shall be responsible to provide supervision, labor, rigging and transportation services as necessary to install the new equipment, including but not limited to:

1. Personnel to properly assemble/install all new industrial equipment and accessories.
2. Contractor's personnel shall conduct operational tests to ensure the equipment is operating in the intended manner. The Contractor's personnel shall be thoroughly qualified and experienced in the type of work and the environment in which the work is to be performed. Any personnel working or delivering to the job site will be required to submit Attachment One Personal Information for Security Check NCDS form DCS-A-per-002-pc
3. The Contractor shall be responsible to make repairs, and restore the building and/or facilities to original condition, and for any damage that results from installation of Contractor-installed equipment and relocation of current equipment.
4. To minimize plate production downtime the Contractor will be required to relocate the existing License Plate production line to a new location within the shop to facilitate the new equipment installation.

   Contractor shall coordinate new equipment installation and existing equipment operation to minimize

disruption of manufacturing capabilities.

3M's Response: 3M will provide the supervision, labor, rigging and transportation of the 3M supplied blanking line equipment. 3M's personnel have years of experience assembling/installing blanking lines at many US states and our thoroughly qualified to perform the necessary work. The 3M team will thoroughly test the 3M supplied blanking line to ensure the equipment is operating as intended. 3M understands and agrees to G.3 regarding damage to the building or facilities.

H. PROVIDE POST IMPLEMENTATION SUPPORT

1. The Contractor shall provide CSI with the following data and services to assist in the start-up of operations, ensuring satisfactory implementation of the project:
   a. Manuals - Two complete sets of operation, PLC logic program files and parts manuals shall be provided for all Contractor provided equipment. Manuals should be bound in a heavy-duty three-ring binder with equipment indexed according to the specifications and drawings, or a printable electronic copy may be acceptable.
   b. Training: Technical Services (Equipment) -After the completion of the installation, the Contractor shall provide technical supervision for a period of three (3) man days (8 hour business day) to train the CSI's personnel and detail workers in the operation and maintenance of the new equipment.
   c. If, at end of the designated training period, additional training is required, the Contractor shall provide the necessary services as needed at their standard rates.

2. The Contractor shall provide unlimited telephone technical support as required for the duration of the contract. Telephone support shall be available Monday thru Friday 7am-5pm CT. Calls shall be returned per the CSI Emergency Response Levels listed in Attachment Two.

3M's Response: 3M provides manuals for the equipment included with the 3M provided blanking line. For the 3M blanking line components that use a PLC, 3M's PLC source code is proprietary and as such 3M cannot provide the PLC logic program source code files. 3M will provide all repair equipment parts as indicated in the attached blanking line maintenance and support agreement and as indicated in that agreement, 3M provides industry leading service and support of the entire 3M blanking line except for blanking die sharpening. CSI will continue to maintain and sharpen the blanking dies as is done today for the blanking dies used with the current blanking line. In the event the 3M provided equipment needs service the 3M team will perform the necessary service to restore the equipment to its initial working order per the attached blanking line maintenance and support agreement except for blanking die sharpening. Should Nebraska choose not to purchase the 3M maintenance and support agreement, 3M will sell any needed replacement parts and loaded software copies to Nebraska and there will be a time and material charge for a 3M technician to assist if requested with repairs as indicated in the "work may be needed that was not originally delineated in this RFP" section of the cost proposal. 3M provides the necessary training after the 3M blanking line is installed and operational so that CSI personnel can successfully operate the 3M blanking line. 3M agrees to the 3-man days of training post installation as indicated in H.1.b above and to follow-up training at the 3M rate as specificin the attached cost portion of our response.

See attached, at the end of this RFP response, the 3M Maintenance and Support Agreement for the detailed technical support that 3M provides for the 3M supplied blanking line.

I. DELIVERABLES

Final Project Plan will be due 60 calendar days after award of contract. Final Project Plan must be signed off by both parties.

1. **Milestone One:**
   60 calendar days after award of contract, Contractor shall provide the Final Project Plan to CSI for final approval including but not limited to:
   a. Detailed Project Work Plan
      i. Final Layout Blueprints
      ii. Equipment
         1). Final Detailed List (Manufacture Make and Model
         2). Equipment Installation Plan
            a). Infrastructure Requirements
         3). Construction Schedules and Milestone(s)
         4) Firmware Management Plan
         5). Utility Requirements

b. Implementation Plan
   i. Implementation Timeline and Milestones
   ii. Operational Testing Plan
   iii. Operational Training Plan

c. Change Control Plan

d. Project Status Reporting Plan

e. Business Continuity Plan / Disaster Recovery Plan, etc.

f. Existing Equipment Relocation Plan
   i. Detailed Move Documentation

g. Training
   i. Training Plan
   ii. On-Site Train the Trainer Session(s)
   iii. Training and troubleshooting Materials
   iv. Administrative and User manuals
   v. Online training materials (webinars, etc.)

h. Post Implementation Support Plan
   i. System Maintenance / Warranty Support
   ii. User Documentation and Help Files
   iii. Hardware and Software Product Documentation
   iv. System Go-Live
   v. System Error/Bug Documentation

2. **Milestone 2. Delivery of all equipment to the Site.**

3. **Milestone 3. Full Implementation, Testing and Training Completed with final inspection and written approval.**

3M's Response: 3M agrees to provide a detailed project plan with the items listed per milestone #1 (items I.1.a through I.1.h) within 60 days of contract award. 3M projects the 3M blanking line equipment will be delivered to the CSI site 240 days after contract award. The specific timing details for Milestone 2 will be identified as part of the Milestone 1 deliverables. 3M typically installs a new blanking line, confirms the successful operation and trains the appropriate personnel in 10 business days. The specific details for Milestone 3 will be identified as part of the Milestone 1 deliverables.

Here is a high-level milestone plan that we include as reference:

Milestone	Day
Contract Award	0
Blanking Line Equipment Ordered	30
Detailed Project Plan	60
Blanking Line Equipment Arrives at CSI	240
3M Team Arrives to install Blanking Line Equipment	240
Blanking Installed	250
Testing and Training	255
Blanking line fully operational and COA signed	255

3M Response

VI. CORPORATE OVERVIEW

The Corporate Overview section of the Technical Proposal should consist of the following subdivisions:

a. **BIDDER IDENTIFICATION AND INFORMATION**

The bidder should provide the full company or corporate name, address of the company's headquarters, entity organization (corporation, partnership, proprietorship), state in which the bidder is incorporated or otherwise organized to do business, year in which the bidder first organized to do business and whether the name and form of organization has changed since first organized.

3M's Response: Headquarters address is 3M Company, 3M Center, St. Paul, MN 55144.
3M Company is a global science company formerly known as Minnesota Mining and Manufacturing Company. 3M was founded on the North Shore of Lake Superior in the village of Two Harbors, MN in 1902. 3M is a corporation incorporated in the state of Delaware in 1929. In 2002 the company's name was changed to 3M Company.

b. **FINANCIAL STATEMENTS**

The bidder should provide financial statements applicable to the firm. If publicly held, the bidder should provide a copy of the corporation's most recent audited financial reports and statements, and the name, address, and telephone number of the fiscally responsible representative of the bidder's financial or banking organization.

If the bidder is not a publicly held corporation, either the reports and statements required of a publicly held corporation, or a description of the organization, including size, longevity, client base, areas of specialization and expertise, and any other pertinent information, should be submitted in such a manner that proposal evaluators may reasonably formulate a determination about the stability and financial strength of the organization. Additionally, a non-publicly held firm should provide a banking reference.

The bidder must disclose any and all judgments, pending or expected litigation, or other real or potential financial reversals, which might materially affect the viability or stability of the organization, or state that no such condition is known to exist.

The State may elect to use a third party to conduct credit checks as part of the corporate overview evaluation.

3M's Response: 3M Company is a global, Fortune 500 Company with annual sales in 2018 of approximately $32.8B and over 90,000 employees worldwide.

Because of 3M's size and global breadth, it is impossible to respond to this Section on behalf of all 3M subsidiaries and affiliates. Therefore, 3M limits its certifications to the 3M Company and its officers and directors.

3M Company provides an overview of legal proceedings by federal, state and local government agencies that are deemed material, and any subsequent action resulting therefrom, in its annual report and Form 10-K. At 3M Company, given our size and diversity, government oversight is a routine occurrence. The Company regularly has OSHA inspections; minor fines or penalties may occasionally be assessed. 3M Company also may be assessed minor fines or penalties in other regulated areas, such as health care. However, minor fines are not considered material and, therefore, and not disclosed in our annual report.

3M Company has occasionally been investigated by government agencies as part of its ongoing business operations. In some instances, the company has been assessed penalties or has agreed to stipulated penalties with federal and state environmental and occupational health agencies.

3M Company's Form 10-K for the fiscal year ended December 31, 2018. A copy of 3M's 2018 annual report can be found on 3M's Internet site at www.3m.com. 3M Company's Form 10-K is available on the 3M Company website by searching as following: Investor Relations -> SEC Filings -> then in the "Groupings Filter" search box, choose "Annual Filings" -> then select Form 10-K filed 2/07/19.

c. **CHANGE OF OWNERSHIP**

If any change in ownership or control of the company is anticipated during the twelve (12) months

following the proposal due date, the bidder should describe the circumstances of such change and indicate when the change will likely occur. Any change of ownership to an awarded bidder(s) will require notification to the State.

3M's Response: 3M Does not anticipate a change in ownership during the next 12 months. If there is an unlikely change in ownership, 3M will notify the State of Nebraska.

d. **OFFICE LOCATION**

The bidder's office location responsible for performance pursuant to an award of a contract with the State of Nebraska should be identified.

3M's Response: Office location for 3M Transportation Safety Division is, 3M Company, 3M Center, Transportation Safety Div.-Building 225, Mailstop: 225-4N-14, St. Paul, MN 55144.

e. **RELATIONSHIPS WITH THE STATE**

The bidder should describe any dealings with the State over the previous three (3) years. If the organization, its predecessor, or any Party named in the bidder's proposal response has contracted with the State, the bidder should identify the contract number(s) and/or any other information available to identify such contract(s). If no such contracts exist, so declare.

3M's Response:
Contract Number 14672 (OC) Retroreflective Sheeting for Validation Stickers
November 15, 2016 through November 14, 2020

Contract Number 13465 OC – Reflective License Plate Sheeting
December 26, 2012 through December 25, 2020

Contract Number 55018 04 – DLP Equipment Service
February 1, 2013 through 2019

Contract Number 14698 (OC) Reflective Sign Sheeting for the State of Nebraska
February 1, 2017 through January 31, 2021

f. **BIDDER'S EMPLOYEE RELATIONS TO STATE**

If any Party named in the bidder's proposal response is or was an employee of the State within the past twelve (12) months, identify the individual(s) by name, State agency with whom employed, job title or position held with the State, and separation date. If no such relationship exists or has existed, so declare.

3M's Response: 3M Company is a global, publicly traded company with annual sales of $32.8B in 2018, and over 90,000 employees worldwide. Because of 3M's size and the broad nature of the certification requested ("any Party named in the bidder's proposal"), 3M cannot state with certainty whether any 3M employee has been an employee of the State within the past twelve (12) months. That said, 3M is unaware of any such relationship that would create a conflict of interest in 3M's performance of this contract.

If any employee of any agency of the State of Nebraska is employed by the bidder or is a subcontractor to the bidder, as of the due date for proposal submission, identify all such persons by name, position held with the bidder, and position held with the State (including job title and agency). Describe the responsibilities of such persons within the proposing organization. If, after review of this information by the State, it is determined that a conflict of interest exists or may exist, the bidder may be disqualified from further consideration in this proposal. If no such relationship exists, so declare.

3M's Response: 3M Company will not utilize subcontractors employed by the State of Nebraska.

g. **CONTRACT PERFORMANCE**

If the bidder or any proposed subcontractor has had a contract terminated for default during the past five (5) years, all such instances must be described as required below. Termination for default is defined as a notice to stop performance delivery due to the bidder's non-performance or poor performance, and the issue was either not litigated due to inaction on the part of the bidder or litigated and such litigation determined the bidder to be in default.

It is mandatory that the bidder submit full details of all termination for default experienced during the past five (5) years, including the other Party's name, address, and telephone number. The response to this section must present the bidder's position on the matter. The State will evaluate the facts and will score the bidder's proposal accordingly. If no such termination for default has been experienced by the bidder in the past five (5) years, so declare.

If at any time during the past five (5) years, the bidder has had a contract terminated for convenience, non-performance, non-allocation of funds, or any other reason, describe fully all circumstances surrounding such termination, including the name and address of the other contracting Party.

3M's Response: 3M limits its certification to 3M Company, its officers and directors, and to 3M's Transportation Safety Division, the 3M entity that is responsible for the preparation of this bid and the performance of any resulting contract. 3M's Transportation Safety Division has not had a contract terminated for default, convenience, non-performance, or non-allocation of funds during the past five (5) years.

h. **SUMMARY OF BIDDER'S CORPORATE EXPERIENCE**

The bidder should provide a summary matrix listing the bidder's previous projects similar to this solicitation in size, scope, and complexity. The State will use no more than three (3) narrative project descriptions submitted by the bidder during its evaluation of the proposal.

3M has worked with many government agencies for license plate production. 3M has installed Blanking lines as the prime contractor in the following facilities.

Center Industries, 2505 South Custer, Wichita, KS
John Kalal, ph: 316-942-8555
TIME PERIOD of project: 6/12-6/21/2018
SCHEDULED AND ACTUAL COMPLETION DATES: 6/21/2019 - 6/21/2019
Responsibilities performed as prime contractor:

- Install new blanking line equipment to coincide with the implementation of the new DLP system.
- Equipment and installation parts were loaded in Minnesota and arrived in Wichita. Unload at Center Industries.
- Removal of existing blanking line equipment. Set blanking line equipment in place and connect to utilities.
- Begin the installation. Test ran the line. Training of supervisors and operators on new equipment.
- Documented operating parameters and serial numbers.

Montana Correctional Enterprises, 300 Conley Lake Road, Deer Lodge, MT 59733
Laura Drescher, ph: 406-846-1320
TIME PERIOD of project: 7/11 – 7/20/2019_
SCHEDULED AND ACTUAL COMPLETION DATES: 7/20/19 – 7/20/2019
Responsibilities performed as prime contractor:

- Installed new blanking line – conveyor system, blanking press, roll feed, laminator, and unwind stand.
- Reviewed line layout and discussed the position of equipment. Reconfigured line layout.
- Began installation. Line started and sample plates ran. Adjusted parameters.
- Trained personnel and ran production plates.

Wyoming Department of Transportation
5300 Bishop Blvd., Cheyenne, WY 82009-3340
Steven Lund, ph: 307-777-3908
TIME PERIOD of project: 3/7 – 3/20/2002
SCHEDULED AND ACTUAL COMPLETION DATES: 3/18/2002 – 3/20/2002
Responsibilities performed as prime contractor:

- Installed new blanking line – conveyor system, blanking press, roll feed, laminator, and unwind stand.
- Reviewed line layout and discussed the position of equipment. Reconfigured line layout.
- Began installation. Line started and sample plates ran. Adjusted parameters.
- Trained personnel and ran production plates.

i. **SUMMARY OF BIDDER'S PROPOSED PERSONNEL/MANAGEMENT APPROACH**

The bidder should present a detailed description of its proposed approach to the management of the project.

The bidder should identify the specific professionals who will work on the State's project if their company is awarded the contract resulting from this solicitation. The names and titles of the team proposed for assignment to the State project should be identified in full, with a description of the

3M professional staff would include the following.
Neal Filla, Technical Services Supervisor
Mike Schwartz, Senior Technical Service Engineer
Jeff Johnas, Technical Service Engineer
Nick Perrin, Project Manager
3M Government Services Manager for Nebraska, Kyle Kovar, is within an hour of the Nebraska State Penitentiary, License Plate Facility. Kyle is familiar with the facility operations and available for onsite management of the project.
Detailed resumes are included in the 3M Attachment section of this response.

j. **SUBCONTRACTORS**

If the bidder intends to subcontract any part of its performance hereunder, the bidder should

3M's Response:3M Company will utilize subcontractors (Riggers) to unload and place the Blanking Press in position.

Attachment Two
Requirements Matrix
Request for Proposal Number 6152 Z1

Firm Name: _3M Company_____

Bidders are instructed to complete a Requirements Matrix for a License Plate Blanking Line. Bidders are required to describe in detail how their proposed solution meets the conformance specification outlined within each Business Requirement. The State requires the bidder to describe "how" the components they are bidding will achieve success on this contract. Bidders should not infer that the absence of detailed requirements means that the State does not consider a specific area or activity important or unnecessary. The State requires the bidder to propose solutions and services that meet the State's requirements.

The requirements matrix is used to document and track the requirements from the proposal through testing to verify that the requirement has been completely fulfilled. The Contractor will be responsible for maintaining the contract set of Baseline Requirements.

The matrix should indicate how the bidder intends to comply with the requirement and the effort required to achieve that compliance. It is not sufficient for the bidder to simply state that it intends to meet the requirements of the RFP. The State will consider any such response to the requirements in this RFP to be non-responsive and the bid may be rejected. The narrative should provide the State with sufficient information to differentiate the bidder's solution from other bidders' solutions.

I. ITEM 1 - ONE (1) - HORIZONTAL PALLET DECOILER

- **A.** The de-coiler shall be designed to stage and process aluminum coils at a minimum of 5" wide to 12.125" wide and from 0.018" to 0.032" thick, stored on pallets.
- **B.** Motor driven table capacity shall be nominally 60" diameter x 6000 pound minimum load with a maximum stack height of 37".
- **C.** The machine should be suitable for front or side loading.
- **D.** The machine should incorporate numerous features (dancer arm, material sensors, heavy duty control arm roller, automatic acceleration and deceleration controls, independent controls for payoff speed and dancer sensitivity, core expander, etc.) to eliminate jerking and edge damage.
- **E.** To minimize damage to raw materials, polyurethane (or equivalent) coatings should be incorporated to reduce material damage as it is processed.
- **F.** Unit should be configurable for clockwise or counterclockwise rotation and Right-to-Left or Left-to-Right operation.

Proposal Instructions: Item #1 Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe any additional or alternative specifications in detail. Describe the utility requirements of the equipment.
Bidder Response: 3M currently uses a manufacturers palletizer in several states serviced. The specifications for the palletizer are below. Utility requirement: 230vac, 20 amp, single phase. Please see equipment literature, pages 69-84, for details regarding the Horizontal Pallet Decoiler.

SPECIFICATIONS:

Weight Capacity	6,000 lbs(2727kg)
Table Diameter	52"(1.32m)
Coil Stacking Height	36"(915mm)
Maximum Material Width	6"(150mm)
Material Thickness Range	0.005"-0.063"(0.13mm-1.60mm)
Table RPM Range	0-16
Motor	1.5HP(1.12kW) AC
Voltage	220 VAC
Loop Control Travel	12"(305mm)
Shipping Weight & Dimensions	857lbs, 62"(1.57m) x 62"(1.57m) x 40"(1.02m)

OPTIONS**:

1. Inside Diameter Coil Supports - 8"-10"(200-250mm), 12"-16"(300-400mm), 16"-20"(400-500mm), 20"-24"(500-600mm) Range
2. Special Material Guide Drum for Wider Material:
   a. 9"(229mm), 12"(305mm) or 15"(381mm)
   b. 18"(457mm) or 23"(580mm)
3. Swivel Head – Angles adjustable to conform to angle of strip for stiffer materials
   a. Weight System to force loop into loop, needs swivel head option
4. Urethane Coated 6"(150mm) Guide Drum
5. Extended 18"(450mm) Loop Control Travel for additional loop storage
6. Heavy Duty Loop Control Guide Rod (20mm vs. 12mm)
7. 60"(1.52m) Diameter Sub-Plate table top (welded to base pan)

** = Highlighted options are upgrades to meet the State of Nebraska's requirements.

II. **ITEM 2- ONE (1) STRAIGHTENER, POWER DRIVEN, 12"**

A. The straightener should be a power-driven, cabinet-mounted unit designed for straightening coil stock.

B. The machine shall have the capability to straighten coil stock of up to approximately 12" wide with a thickness capacity of approximately .018"-.125".

C. To ensure best quality, a minimum of seven individually adjustable hardened and ground straightening rolls with a minimum diameter of 2" should be incorporated.

D. At the exit of the straightener, a free stock storage loop should control the modulating drive motor to regulate feed between straightener and applicator using position sensing components to detect loop position.

E. Controls for forward and reverse travel as well as end of aluminum detector to stop the unit in the event material supply is empty shall be included.

F. Machine guarding shall protect all pinch points.

Proposal Instructions: Item #2
Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe any alternative specifications in detail. Describe the utility requirements of the equipment..

Bidder Response:

A 3M blanking line does not require a straightener to operate properly. Currently, there are a number of customer sites that are operating without a separate metal straightener. Advantage – This will shorten the blanking line footprint.

III. ITEM 3 - ONE (1) GRAPHIC LICENSE PLATE APPLICATOR

A. This unit should be preassembled on a structural frame and designed to be integrated into a new or existing license plate blanking system for the purpose of applying plain or graphic reflective sheeting to aluminum substrate for passenger or motorcycle plates.

B. The applicator shall be designed to permit the application of reflective sheeting in rolls at least 200 yards long, with a minimum width of 6.75" to a maximum width of 13" and wound on either 3" or 6" I.D. cores as required to be consistent with the reflective sheeting materials used.

C. The laminating machine shall be equipped with either a 3" or 6" diameter expansion mandrel to allow quick and safe set-up.

D. This machine should be capable of stretching the preprinted reflective sheeting from 1 - 2%" at a fixed repeat spacing using a variety of tension modes and other control features as required to ensure the best possible quality of the finished license plates:

1. Operation modes
   - **a.** The line is desired to be run in either an auto run mode or manual mode
     - **i.** Automatic Mode
       In this mode, tension is automatically controlled based on measured distance between registration marks using an optical sensor and PLC software.
     - ii. Manual-Stretch Mode
       In this operating mode, tension is constantly adjustable as a percentage of full tension which allows the tension to be constant independent from the winding diameter of the remainder of the coil.
   - **b.** The applicator / graphic laminator must be capable of a variety of program capabilities and shall be capable of automatic guiding edge control with the ability to adjust lamination to the middle, or to the left or right edge of the aluminum strip if required. All necessary parameter adjustments shall be accomplished through a central operator control panel.

2. Basic Parameters
   - **a.** These items are listed as basic requirements necessary to facilitate installation with existing infrastructure and are listed to simplify implementation.
   - **b.** Maximum laminator speed approximately 0.7 meters/second
   - **c.** Maximum laminating width 13"
   - **d.** Compressed air supply 90 to 120 PSI
   - **e.** In feed loop control included
   - **f.** Out feed loop control included
   - **g.** IEC 61131-3 PLC controlled
   - **h.** Warning indicators

3. Storage Loop
   Between the laminator and roll feeding device, a storage loop control system should control the amount of material in the buffer loop to avoid stopping the laminating process during the cut cycle in the blanking press. The height of the loop is continuously measured by a contactless sensor to automatically synchronize the speed for a smooth material output from the laminator. A heavy duty servo controlled drive system automatically regulates the output speed to match demand, providing smooth delivery of material to the roll feed system.

Proposal Instructions: Item #3
Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe any alternative specifications in detail. Describe the utility requirements of the equipment.

Bidder Response:

3M proposes a 3M designed sheeting laminator. The 3M laminator has the latest design updates and is currently working in many states serviced by 3M. Utility requirements: 120vac, 15amp, 100 psi air. Please see equipment literature, page 67, for details regarding the Graphic License Plate Applicator.

3.1 Web Line Specifications	
3.1.1 Web widths:	3.5 – 16 inches
3.1.2 Line Speeds:	Typical 10 – 50 feet/Min
3.2 Product Specifics	
3.2.1.1	Automatic web steering of sheeting
3.2.1.2	Automatic steering placement sensor – infrared (to ignore clear over laminate)
3.2.1.3	Stretch control within .010" +/- of target length
3.2.1.4	Sheeting stretch control from .5% to 4%
3.2.1.5	Loop control on out feed
3.2.1.6	Password protection for HMI (minimum 3 levels)
3.2.1.7	Footage counter/plate counter
3.2.1.8	Graphic mode / Standard Mode Standard mode should be considered fixed stretch mode. Percentage stretch should be adjustable in this mode. Graphic mode based on requested stretch equaling the measured stretch.
3.2.1.9	Sensor or device to shut off the laminator when loss of substrate loop entering the laminator occurs.
3.2.1.10	Ability to electrically interlock with the blanking press
3.2.1.11	Warning indicator for out of tolerance and no tic mark seen (18 inches without Identifying a registration mark).
3.3 General Equipment Requirements	
3.3.1	All equipment is designed and constructed with user's safety as a top priority and meets applicable OSHA safety and machine guarding standards.
3.3.2	NRTL (National Recognized Testing Laboratory) listing or label. Example UL/cUL.
3.3..3Wiring practices must follow NEC and more specially NFPA 79 for the machine Wiring.	
3.3.4	Panels built to comply with UL 508A standards.

IV. ITEM 4 - ONE (1) GRAPHIC REGISTRY SERVO FEED SYSTEM

A. The Servo Driven Electronic Roll Feeding device is recommended to ensure proper positioning of the laminated strip into the blanking press.

1. This shall be a field-proven, microprocessor controlled system capable of operating at speeds up to approximately 1 meter per second and must coordinate with the blanking press.
2. Footage and plate counter options should also be included.

Proposal Instructions: Item #4
Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe the utility requirements of the equipment. Describe any alternative specifications in detail.

Bidder Response:
3M proposes a 3M graphic registry feed system which is currently used in many states. Utility requirements: Electrical power supply to match US standard voltages: 208/230vac, single or 3 phase,20 amp, 100 psi air. Please see equipment literature,page 68, for details regarding the Graphic Registry Servo Feed System.

3.1 Web Line Specifications
- 3.1.1 Web widths: 3.5 – 13 inches
- 3.1.2 Line Speeds: Typical 10 – 50 feet/Min

3.2 Product Specifics
- 3.2.1.1 Operate in GRAPHIC MODE and STANDARD MODE (no sheeting or plain sheeting without graphic design)
- 3.2.1.2 HMI: Programmable parameters to change plate length, registration distance for parameter changes
- 3.2.1.3 Accept clear to feed signal from outside source (blanking press) which will start roll feed cycle (Considered as operating in continuous mode)
- 3.2.1.4 Provide signal to outside source (blanking press) that feed is ready.
- 3.2.1.5 Ability to stop blanking press at top stop position.
- 3.2.1.6 GRAPHIC mode: Adjust feed length to compensate for variable sheeting stretch while centering graphic design in center of cut blank
- 3.2.1.7 STANDARD mode: Feed length based on requested HMI plate length
- 3.2.1.8 Password protection for HMI (minimum 3 levels)
- 3.2.1.9 Capable of identifying registration TIC mark on sheeting border, and or being able to register within graphic design while ignoring similar colored items within graphic design (If TIC marks are not on sheeting, 3M to provide a useable registration mark within graphic design. A one-inch window (spacing) within graphic design with no similar color may also be used to trigger registration)
- 3.2.1.10 Top stop press if no registration mark located after the 3rd roll feed cycle (In GRAPHIC MODE)
- 3.2.1.11 Top stop press, if registration mark is more than .500 inch out of registration
- 3.2.1.12 HMI to list all shutdown or fault information to simplify troubleshooting of failures.
- 3.2.1.13 Electrical power supply to match US standard voltages: 120 VAC, 1 phase, 208/230 VAC, 1 phase or 3 phase

3.3 General Equipment Requirements
- 3.1 All equipment shall be designed and constructed with user's safety as a top priority and meet applicable OSHA safety and machine guarding standards.
- 3.2 NRTL (National Recognized Testing Laboratory) listing or label. Example UL/cUL.
- 3.3 Wiring practices must follow NEC and more specially NFPA 79 for the machine Wiring.
- 3.4 Panels built to comply with UL 508A standards.

V. ITEM 5 - ONE (1) BLANKING PRESS

A. The Blanking Press shall be robust, with a high quality rigid frame designed to maintain high accuracy and provide increased tooling life by minimizing deflection.

B. All moving parts shall be precision machined and designed for smooth power transmission, quiet operation and long life.

C. Press shall have sufficient blanking force to complete a finished license plate blank each stoke, including punching all mounting holes, cutting radius corners, cutoff of blank and forming of the plate rim.

D. It is desired that the plates be stamped to size with a hydraulically actuated press. Our recommendation for the manufacturing line is an electric motor driven hydraulic press with a pump to produce a maximum working pressure of 45 ton at approximately 70 cycles per minute powering a 1" diameter, double acting hydraulic cylinder.

E. Press should be able to be operated in a variety of modes including slow manual operation, manual single stroke, and automatic continuous.

F. Minimum 40 gallon reservoir should be included with the hydraulic pump. A forced air cooling system should ensure proper operating temperatures.

G. Operating controls shall be designed to provide safe and simple operation. All necessary features to operate the press shall be integrated into the central control panel. The central control panel will provide all necessary operating controls as well as a system to display error codes / messages and other diagnostic information.

H. A reliable scrap ejection system shall eject scrap materials with each stroke of the press. Waste removal shall not require tools or disassembly of the blanking line.

I. A belt conveyor with integral plate counter shall remove finished blanks from the press area for subsequent manual or automated handling and processing

Proposal Instructions: Item #5 Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe the utility requirements of the equipment. Describe any alternative specifications in detail.
Bidder Response: 3M will supply a SN1-66 ton press. This type of press is currently being used in many of the blanking lines serviced by 3M. The proposed model is the latest design with many operator and maintenance improvements. Utility requirements: 240vac 3-phase, 30 amp, 90 psi air supply. This press has variable speed up to 100 plates a minute. Please see equipment literature, pages 85-87, for details regarding the Blanking Press. Here are the blanking press specifications: SEYI 66 Ton Single Point Gap Frame Press with the following standard features: - 66 US (60 metric) Ton Capacity - SEYI Combination Wet Clutch & Brake - 3.15" (80 mm) Stroke Length - Variable Speed - 55 to 110 SPM - 0.16" (4 mm) Tonnage Capacity Rating Point - 10.63" (270 mm) Die Height to Top of Bolster (SDAU) - 2.76" (70 mm) Motorized Die Height Adjustment - 18.90" x 15.75" (480 x 400 mm) Slide Area (L to R, F to B) - 35.43" x 20.47" (900 x 520 mm) Bolster Area (L to R, F to B) - 5.12" (130 mm) Bolster Thickness - 7.5 Hp Main Motor w/Vairable Frequency Drive (specify voltage on Purchase Order) - Wintriss WPC2000-S6 Press Control - Maximum Upper Die Weight of 198 lbs (90 kg) @ 72 psi. - Weight - 11,000 lbs (5,000 kg) (approximate)

VI. ITEM 6 -THREE (3) TWO STAGE COMPOUND BLANKING I RIMMING DIE

A. The compound blanking and rimming die will be customized to the requirements of the application.

1. It shall produce one size of depressed flange license plate blanks with radius corners, four mounting holes and depressed flange border.
2. Hole punching and forming of the depressed flange border will occur in the first stage.
3. The second stage will perform the cutting processes and deliver the plate to the discharge conveyor for takeaway from the press.

B. The cutting / embossing tools will be made of high quality tool steel with anti-adhesive coatings and hardened working elements to cut aluminum either with or without conversion coatings with a tolerance of <± 0.010.

C. Two compound blanking dies for passenger size plates and one for Motorcycle size plates will be provided.

1. All final drawings and BOM will be included in the documentation package after award of contract.
2. The compound blanking and rimming die shall be designed for quick removal for easy switching between plate sizes as required.

Proposal Instructions: Item #6

Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe the utility requirements of the equipment. Describe any alternative specifications in detail..
Bidder Response: 3M proposes the following blanking dies: 1. The tonnage required for the dies is a 60 ton mechanical press 2. The shut height of the tools is 10.500 inches in a closed position 3. The die cutting steels are made of D2 material at 60-62 Rockwell hardness which offers the best wear resistant and toughness for this stamping application 4. The dies are equipped with ball lock retainers and ball lock coated punches and die bushings for easy removal for maintenance /sharpening of the 4 internal holes The Dies will be custom designed for Nebraska. • Quick die change system with locator pegs installed on press/dies.

VII. ITEM 7 - ONE (1) MAIN CONTROL SYSTEM

A. The main control cabinet / panel shall contain all electronic elements required to operate and control this license plate blanking equipment and to diagnose any faults.

B. This system shall be equipped with high-quality electrical and electronic components including IEC61131-3 compatible Programmable Logic Controls (PLC) and features to enable remote diagnostics via internet connections.

C. The operator panel shall be equipped with a color touch screen, which displays all messages and operational parameters of the line.

D. Intuitive menu handling and access to the implemented library of adjustments and configuration of the line (for a certain license plate dimension) enable an efficient adjustment of the line in order to produce different types of license plates.

E. In addition to features identified above, the control system shall also incorporate different password levels for Administrators and Operators as well as output of general information such as quantities produced, end of roll, end of aluminum coil, etc.

F. Electrical protection shall be provided for electrical components, drives and PLC's per UL 508 or similar recognized standard.

Proposal Instructions: Item #7 . Explain how the equipment being bid meets each of these specifications. Bidder should submit detailed specifications, drawings and/or literature that shows how the equipment meets these specifications. Describe the utility requirements of the equipment. Describe any alternative specifications in detail..
Bidder Response: The 3M blanking line does not require a centralized main control system to operate the entire blanking line. Each device is a stand-alone unit, allowing easier trouble shooting of each component and the overall blanking line. Also, this approach enables Nebraska to add or change a component in the blanking line with future 3M technology. In addition, not having a main control system unit, decreases the footprint of the blanking line.

VIII. Installation;

Please provide detailed information on your installation process, including any potential need for building modifications and utilities needed. Describe your understanding of the environment and processes necessary to design and install a blanking line in a secured facility. Bidder Response: 3M has installed and setup many blanking lines in secured facilities over the last 15 to 20 years. 3M has the experience and technical know-how to successfully install the 3M blanking line equipment indicated above in such an environment. From what we can tell **from the** Nebraska provided drawing, building modifications will be minimal, if any at all. We list the utilities for each component of the blanking line above.

Given our experience with installing blanking lines, we do not see any major issue successfully installing a 3M supplied blanking line in the CSI secured facility. All blanking line equipment 3M provides will be scheduled to arrive at the CSI facility at approximately the same time. The 3M team, with help from CSI personnel, will move each piece of equipment into position, set up each piece, align each piece so the complete blanking line operates as it should and then test it to confirm its successful operation.

IX. Operation:

Please describe equipment operation process, including change over time, materials waste, start up and shut down process/time, and operator training needs.

Bidder Response:

1) Aluminum is supplied by the horizontal palletizer.
2) Laminator applies reflective sheeting to the aluminum.
3) The Electronic Roll Feed supplies the press the correct length aluminum.
4) The Press and die will rim and cut the license plate. The conveyor will move plates from press to catch tray for inspection.

Change over time from passenger plates to motorcycle plates is 3 hours, but changing between the two passenger dies takes about 1.5 hours. Less than 1% waste is typical. 10 minutes for start up or shut down.

During the installation of the blanking line, 3M will provide training to CSI personnel. 3M typically schedules 1.5 days of specific blanking line training.

X. Service and Support;

Please describe the designed run rate of the license plate blanking line being bid. Describe the service and support that will be provided as a part of this response.
CSI Emergency Response Levels:

Critical – Line down with order backlog
Requires 2 hour maximum call back response
Next Day AM parts delivery
48 hour maximum lead time to have on-site support if needed to resolve issue

Urgent – Line down No / Minimal order backlog
Requires 2 hour maximum call back response 7 am to 5 pm Monday to Friday non Holiday
Next Day parts delivery
48 hour Monday to Friday non Holiday on-site support if needed to resolve issue

Issue – Line malfunction or non-optimal operation
8 hour maximum call back response 7 am to 5 pm Monday to Friday non Holiday
2 day parts delivery
1 week Monday to Friday non Holiday on-site support if needed to resolve issue

Information request –
Service, maintenance, how to or operational questions
8 hour maximum call back response 7 am to 5 pm Monday to Friday non Holiday.

Bidder Response:

3M can meet the service and support requirements. See attached at the end of this response the Blanking Line Maintenance and Support Agreement for details of 3M's blanking line maintenance and support.

3M's blanking line, as indicated in the above sections, is able to produce up to 100 plates per minute.

XI. Describe all extended warranties available for each piece of equipment below excluding costs.

Bidder Response:
3M provides a 12 month warranty on all 3M supplied blanking line equipment.

Form A
Bidder Point of Contact
Request for Proposal Number 6152 Z1

Form A should be completed and submitted with each response to this solicitation. This is intended to provide the State with information on the bidder's name and address, and the specific person(s) who are responsible for preparation of the bidder's response.

Preparation of Response Contact Information	
Bidder Name:	**3M Company**
Bidder Address:	**3M Center, Transportation Safety Div. Building 225, mailstop 225-4N-14**
Contact Person & Title:	**Leslie O'Hara, Proposal Coordinator**
E-mail Address:	**laohara@mmm.com**
Telephone Number (Office):	**651-736-3528**
Telephone Number (Cellular):	**n/a**
Fax Number:	**651-733-2574**

Each bidder should also designate a specific contact person who will be responsible for responding to the State if any clarifications of the bidder's response should become necessary. This will also be the person who the State contacts to set up a presentation/demonstration, if required.

Communication with the State Contact Information	
Bidder Name:	**3M Company**
Bidder Address:	**3M Center, Transportation Safety Div. Building 225, mailstop 225-4N-14**
Contact Person & Title:	**Craig Lorence, Proposal Manager**
E-mail Address:	**cslorence@mmm.co**
Telephone Number (Office):	**651-737-9011**
Telephone Number (Cellular):	**651-230-6664**
Fax Number:	**651-733-2574**

REQUEST FOR PROPOSAL FOR CONTRACTUAL SERVICES FORM

BIDDER MUST COMPLETE THE FOLLOWING

By signing this Request for Proposal for Contractual Services form, the bidder guarantees compliance with the procedures stated in this Solicitation, and agrees to the terms and conditions unless otherwise indicated in writing and certifies that bidder maintains a drug free work place.

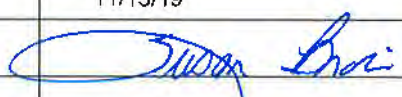
Per Nebraska's Transparency in Government Procurement Act, Neb. Rev Stat § 73-603 DAS is required to collect statistical information regarding the number of contracts awarded to Nebraska Contractors. This information is for statistical purposes only and will not be considered for contract award purposes.

_x_ NEBRASKA CONTRACTOR AFFIDAVIT: Bidder hereby attests that bidder is a Nebraska Contractor. "Nebraska Contractor" shall mean any bidder who has maintained a bona fide place of business and at least one employee within this state for at least the six (6) months immediately preceding the posting date of this Solicitation.

_____ I hereby certify that I am a Resident disabled veteran or business located in a designated enterprise zone in accordance with Neb. Rev. Stat. § 73-107 and wish to have preference, if applicable, considered in the award of this contract.

_____ I hereby certify that I am a blind person licensed by the Commission for the Blind & Visually Impaired in accordance with Neb. Rev. Stat. §71-8611 and wish to have preference considered in the award of this contract.

FORM MUST BE SIGNED USING AN INDELIBLE METHOD (NOT ELECTRONICALLY)

FIRM:	3M Company
COMPLETE ADDRESS:	3M Center, 0225-4N-14, St. Paul, MN 55144
TELEPHONE NUMBER:	651-737-1669
FAX NUMBER:	
DATE:	11/13/19
SIGNATURE:	
TYPED NAME & TITLE OF SIGNER:	Susan Broin, Manager, Contracts

ATTACHMENT THREE

NEBRASKA DEPARTMENT OF CORRECTIONAL SERVICES

Receipt of NDCS Rules and Regulations

_____ _____

Name (Please Print) Facility/Program

My initials and signature verify I have received the following laws, administrative regulations and employee handbook; understand their significance; and that it is my responsibility to read these documents in their entirety. I will remain in compliance with the following requirements. I further understand this acknowledgement will be entered into my personnel file.

INITIALS

_____ 1. **A.R. 112.13, *NE Department of Correctional Services Drug Free Workplace Policy*** (See Training Manual – Orientation Materials Section)

_____ 2. **A.R. 112.17, *NE Department of Correctional Services Employee Dress and Grooming Standards*** (See Training Manual – Orientation Materials Section)

_____ 3. **A.R. 112.31, *NE Department of Correctional Services Code of Ethics and Conduct*** (See Training Manual – Section 1)

_____ 4. **A.R. 112.06, *NE Department of Correctional Services* Management of Employee Performance** (See Training Manual – Section 1) **RFP 6152 Z1, Page 48**

_____ 5. **A.R. 112.07, *NE Department of Correctional Services Equal Employment Opportunity and Policies Against Workplace Discrimination and Harassment*** (See Training Manual – Section 2)

_____ 6. **A.R. 104.06, Computer Equipment and Telephone Usage Policy** (See Training Manual – Orientation Materials Section)

_____ 7. **A.R. 112.33, Leave Provisions** (See Training Manual – Orientation Materials Section)

_____ 8. **A.R. 115.10, Pharmacy Medication Distribution, Access and Training** (See Training Manual – Orientation Materials Section)

_____ 9. **Neb. Rev. Stat. §§83-415 and 417, *Laws Pertaining to Employees of the NE Department of Correctional Services*** (See Training Manual – Orientation Materials Section)

_____ 10. I have received a copy of the Rights and Responsibilities under the State Effectiveness Act.

_____ 11. ***NE Department of Correctional Services Employee Handbook*** (DCS-A-per-019, Current edition)

_____ 12. ***Inmate Con-Games handout*** (See Training Manual – Section 14)

_____ 13. If having secondary employment or changing secondary employment, I know I am required to secure prior supervisory approval by completing an Outside Employment and Private Business Interest/Ownership Request form (DCS-A-per-026-pc), with the completed, signed form filed with my worksite's Human Resources office.

_____ 14. I understand my responsibilities if I or a family member has a private business interest/ownership, which includes notice to my supervisor, Program Administrator or Deputy Director and completion of an Outside Employment and Private Business Interest/Ownership Request form (DCS-A-per-026-pc), with the completed, signed form filed with my worksite's Human Resources office.

_____ 15. When requested, I understand I am required to provide required documentation of proof for eligible dependents covered under my health, dental, and/or vision. Failure to do so may result in disciplinary action, up to and including termination.

_____ 16. I have received written notice of the Hatch Act, and understand my responsibilities under the Act.

_____ 17. I am required to immediately report, in writing, any arrest or citation for law violations (other than minor traffic offenses) to my Warden/Program Administrator.

_____ 18. I am required to immediately report, in writing, through my supervisor, the arrival of any inmate to whom I am related or whose social relationship with me could result in real or perceived problems.

_____ 19. I am required to return all state property, to include but not limited to, badge, insignia, I.D., key(s), and uniforms for personnel changes, e.g., promotions, and at the termination of my employment. I also understand failure to do so may result in discipline, or if terminating my employment, my personnel records will show I did not leave in good standing.

_____ 20. I understand disciplinary actions may be imposed for violations of the above laws, Administrative Regulations and other ARs/policies, as outlined in Chapter 14 of the State of NE Classified Systems Personnel Rules and Regulations, Article 10 of the Labor Contract between the State of Nebraska and the NE Association of Public Employees (NAPE/AFSCME) AND Article 3 of the Labor Contract between the State of Nebraska and the State Code Agencies Teachers Association (SCATA). (See Training Manual Sections 1 and 2)

_____ _____

Employee Signature Date

NOTE: A *Personnel Manual,* containing Classification Specifications, Rules and Regulations, Labor Contracts, Statutes, and Employee Handbook is located in the Human Resources section of each facility and is available for all employees to view.

Original: Employee Personnel file

NOTE: Based on language in the RFP, 3M understands that its employees may only be required to sign returned documentation NDCS policy 112 31

Attachments

3M

3M Attachments

Neal Filla

Technical Service Supervisor

EDUCATION

B.S. in Electrical Engineering Technologies, DeVry University

PROFESSIONAL PROFILE

Hardware technical service supervisor working with a team of field service engineers to perform installations of new equipment, preventive maintenance and address customer repairs onsite or by phone. Working with customers to increase production and lowering customer costs in the Vehicle Registration department.

PROFESSIONAL EXPERIENCE

3M Company, St. Paul, MN

Technical Service Supervisor, 2018 – Present

Responsibilities:

Work with field service team to address customer requirements like: Preventive maintenance trips, repairs, updates to current equipment, replacement of equipment and improving customer experience with 3M hardware products. Work with Project management on new installations at current or new customer sites. Research new equipment innovations and develop methods to integrate them into current and future 3M equipment.

3M Company, Oakdale, MN

Technical Service Engineer, 2015 – 2018

Responsibilities:

Develop systems/methods to move medical device hardware from 3M manufacturing plant to the Healthcare Service Center to improve customer repair costs, turnaround times and tracking for a better customer experience. All aspects of servicing customer medical hardware.

Delta Airlines, Eagan, MN

Component Repair, Purchasing and Inventory Supervisor, 2007 – 2014

Responsibilities:

Working with a team of Simulator Technicians to repair, test and certify flight simulator hardware. Manage parts and component purchasing along with the vendors suppling the pilot training department. Accomplish inventory management with an eleven-million-dollar catalog in the supply department.

CLIENT REFERENCES

Louisiana State Prison
State Highway 66, Angola, LA 70712
Austin Calvert, Phone: 225-655-2722 ext.2066
Onsite supervisory services provided for Laminator Installation project.

Macon Resources Inc.
2121 Hubbard Avenue, Decatur, IL 62524
Brad Auten, Phone: 217-875-8810
Onsite supervisory services provided for Condor printer installation project.

TRICOR
7361 Cockrill Industrial Blvd., Nashville, TN 37209
Theresa Carter, Phone: 615-253-4923
Onsite supervisory services provided for PPS printer installation project.

Michael J. Schwartz

Senior Technical Service Engineer

EDUCATION

St. Paul College Technical School, Electrician (2-year degree)

PROFESSIONAL PROFILE

Technical support technician for 3M owned and serviced license plate blanking lines and peripheral equipment.

SKILLS

Electrical and mechanical installation, maintenance, troubleshooting, and repairs. Efficient under pressure to complete preventative maintenance and solve production issues in a timely manner.

PROFESSIONAL EXPERIENCE

3M Company, St. Paul, MN

Senior Technical Service Engineer, April 2018 – Present

Achievements:

Technical Service Engineer responsible for maintaining, and installing license plate blanking lines in 35 states, Canada and Puerto Rico. NFPA 70E certification.

Responsibilities:

Personally committed to provide exceptional technical and field service for 3M owned and maintained blanking line equipment. Includes traveling to customer sites for preventative maintenance visits, and emergency repair visits. Provide technical assistance over the phone to resolve service issues, or determine if an emergency repair visit is necessary. Installation of new and refurbished components in existing lines and in new facilities. Train onsite personel on how to safely and efficently operate, and maintain blanking line equipment.

Powers Electric, South St. Paul, MN 55075

Electrician and Technical Service specialist. July 1995 - April 2018

Achievements:

20 years experience in technical and field service of blanking lines and blanking line equipment.

Responsibilities:

- Maintain license plate equipment in over 50 locations worldwide.
- In-depth knowledge of: 3M Squeeze Roll Applicators, 3M Electronic Roll Feed Systems, Utsch GPS Systems, Kurz DRC Machines, Precision Blanking Presses, JRW M31 Roll Coaters, CWP Roll Feeds, CWP Metal Straighteners, PA Industries horizontal unwind stands, Dorner conveyors, and Barricade Board Laminators.
- Responsible for installing safety equipment, barricades and interlock devices.
- Anticipate all parts needed to perform repairs and maintenance in remote locations.
- Coordinate, stage and ship equipment for installations.
- Maintain a complete inventory of spare parts for the 3M owned equipment in the field.
- Locate viable replacement parts for obsolete components.
- Communicate regularly with customers to troubleshoot equipment failures.
- Manufacture license place equipment to UL standards.
- Proficient in translating electrical schematics and wiring diagrams to solve issues.
- Train supervisors and line operators to safely run and maintain equipment.
- Foster excellent working relationships with customers.

CLIENT REFERENCES

Center Industries, 2505 South Custer, Wichita, KS
John Kalil, ph: 316-942-8555
Services provided:

- Install new blanking line equipment to coincide with the implementation of the new DLP system.
- Equipment and installation parts were loaded in Minnesota and arrived in Wichita. Unload at Center Industries.
- Removal of existing blanking line equipment. Set blanking line equipment in place and connect to utilities.
- Begin the installation. Test ran the line. Training of supervisors and operators on new equipment.
- Documented operating parameters and serial numbers.

Texas Department of Corrections, 810 FM 2821, Huntsville, TX 77349
Kelly Pagoda, ph: 936-291-5138
Services provided:

- Installed four laminators and four passenger dies. Installed one motorcycle die.
- Meet with tag shop personnel and begin installation.
- Old dies, spare parts, and cutting steels removed from site.
- Crated motorcycle die to be returned to manufacturer.

Montana Correctional Enterprises, 300 Conley Lake Road, Deer Lodge, MT 59733
Laura Drescher, ph: 406-846-1320
Services provided:

- Installed new blanking line – conveyor system, blanking press, roll feed, laminator, and unwind stand.
- Reviewed line layout and discussed the position of equipment. Reconfigured line layout.
- Began installation. Line started and sample plates ran. Adjusted parameters.
- Trained personnel and ran production plates.

Jeffrey A. Johnas

Technical Service Engineer

EDUCATION

University of Wisconsin Stout, Mechanical Design (Bachelors in Engineering Technology)
Chippewa Valley Technical College, HVAC-R Heating and Cooling (Associates Degree)

PROFESSIONAL PROFILE

Technical support technician for 3M owned and serviced license plate blanking lines, Precision Plate System printers and peripheral equipment.

SKILLS

Advanced technical skills. Installation, maintenance, troubleshooting, and repairs of complex automated equipment. Efficient problem solving under pressure to accomplish tasks. Ability to learn new systems and equipment quickly.

PROFESSIONAL EXPERIENCE

3M Company, St. Paul, MN

Technical Service Engineer, April 2018 – Present

Achievements:

Research and development of upgraded applicator PLC and programming.

Responsibilities:

- Provide technical and field service for 3M owned and maintained blanking line equipment and PPS printers.
- Travel to customer sites for preventative maintenance visits and emergency repair visits.
- Provide technical assistance over the phone to resolve production issues.
- Installation of new and refurbished components in existing lines and in new facilities.
- Train onsite personel on how to safely and efficently operate, and maintain blanking line equipment.
- Research and implementation for the replacement of obsolete parts.

Powers Electric, South St. Paul, MN

Mechanical Designer and Technical Service Specialist. June 2016 - April 2018

Achievements:

Research, development and integration of upgraded applicator user interface and programming.

Responsibilities:

- Drawing and modeling of 3D replacement/revised parts and electrical schematics
- In-depth knowledge of: 3M Squeeze Roll Applicators, 3M Electronic Roll Feed Systems, Utsch GPS Systems, Kurz DRC Machines, Precision Blanking Presses, CWP Roll Feeds, CWP Metal Straighteners, PA Industries horizontal unwind stands and Dorner conveyors.
- Anticipate all parts needed to perform repairs and maintenance in remote locations.
- Coordinate, stage and ship equipment for installations.
- Maintain inventory of spare parts for the 3M owned equipment in the field.
- Locate viable replacement parts for obsolete components.
- Communicate regularly with customers to troubleshoot equipment failures.
- Manufacture license place equipment to UL standards.
- Proficient in translating electrical schematics and wiring diagrams to solve issues.
- Train supervisors and line operators to safely run and maintain equipment.

CLIENT REFERENCES

MinnCor Industries, 7600 525th St, Rush City, MN 55069
Joe Beise, ph: 320-358-1633

Services provided:

- Install upgraded applicator controls for research and development field testing.
- Equipment and installation parts assembled and pre-tested.
- Removal of existing applicator controls with minimal invasiveness according to a plan for catastrophic failure.
- Installation and testing with minimal production down-time and no waste.
- Training of supervisors and operators on new equipment.

Tricor, Tennessee Corrections Industries, 7361 Cockrill Bend Blvd, Nashville, TN 37209
Theresa Carter, ph: 615-253-4923

Services provided:

- Installation of 3M Precision Plate System printer and roll rewinder.
- Partial removal of old equipment to allow continued production from old equipment.
- Training of supervisors and personnel on new equipment.
- Troubleshooting and technical assistance on the printer and blanking line during commission and start-up.

Montana Correctional Enterprises, 300 Conley Lake Road, Deer Lodge, MT 59733
Laura Drescher, ph: 406-846-1320

Services provided:

- Prepared equipment for installation and resolved a conveyor speed miscalculation prior to being on-site.
- Installed new blanking line: conveyor system, blanking press, roll feed, applicator, and unwind stand.
- Completed installation. Line commission, start-up and sample plates ran. Adjustments to parameters.

3M Supplied Blanking Line Maintenance and Support Agreement

1. Introduction

This Maintenance Agreement sets forth the maintenance and support services that 3M will provide to Cornhuskers State Industries (CSI) on an annual term basis, if mutually agreed by the parties, for the 3M Blanking line equipment listed on Exhibit A. These terms will supersede any conflicting terms in any prior written agreements between CSI and 3M relative to 3M's provision of the 3M blanking line equipment.

2. Definition

2.1. 3M: means 3M Company.

2.2. 3M System: means the 3M blanking line equipment listed on Exhibit A.

2.3. 3M Support Team: means those resources providing operational troubleshooting assistance on 3M's behalf for Customer under this maintenance and support agreement.

2.4. Customer: means the Cornhuskers State Industries contracting with 3M for support services under this maintenance and support agreement.

2.5. Customer Primary Contact(s): means two to four main contacts designated by Customer for purposes of communicating with 3M under this maintenance and support agreement. One contact will have decision making ability for expense issues. A second contact will have decision making ability for operational issues and a third (and fourth) contact will have technical capabilities to assist troubleshooting.

2.6. Product(s): means the 3M blanking line equipment covered by this maintenance and support agreement as further identified on Exhibit A.

2.7. Remote: means access made by a member of the 3M Technical Support Team from an off-site location.

2.8. Initiation: means the point in time at which 3M is made aware of an issue/request by the Customer or Customer's agent. Customer initiation can occur via an email or phone call to 3M.

2.9. Notification: means 3M's reply, verbal or electronic, to Customer regarding confirmation/ acceptance of the initiated issue into 3M's work queue.

2.10. Response: means the point in time at which 3M begins, and continues, to work the issue/request.

2.11. Repaired: means that the issue/request is resolved and completed by 3M.

2.12. Cancelled: the issue is withdrawn by Customer, or by mutual agreement between 3M and the Customer the issue no longer needs to be addressed.

2.13. Severities: See the Incident Response Table below.

3. Scope of Services

3.1. 3M reserves the right to confirm all maintenance or support service requests with a Customer Primary Contact before beginning resolution efforts.

3.2. Planned Maintenance

3.2.1. 3M will manage the maintenance of the 3M blanking line equipment identified in Exhibit A except for blanking die sharpening and maintenance.

3.2.2. Planned maintenance of the 3M blanking line equipment will be provided once per year at the customer's site except for the blanking die sharpening and maintenance. Nebraska will continue to sharpen and maintain the blanking dies.

3.2.3. For equipment maintenance event, 3M will: (i) announce to Customer the schedule of the event at least 48 hours in advance; (ii) announce to Customer the closure of the event within 2 Business hours upon completion of work; and (iii) document the planned maintenance activities and results of the completed event within 48 hours of completion.

3.2.4. Evaluation. 3M will evaluate the performance of the 3M blanking line during maintenance events and make any adjustment as needed for the 3M blanking line to continue to operate to its written specifications.

3.3. Incident Remediation (unexpected and unplanned events)

3.3.1. In the event of an unexpected or unplanned disruption the Customer shall contact 3M through the 3M Technical Support Center by phone at 1-877-777-3571. The Contact Center will start an incident report and contact the appropriate 3M Service Personnel. Except for blanking die sharpening and maintenance. Nebraska will continue to sharpen and maintain the blanking dies.

3.3.2. 3M will contact the Customer Primary Contact by phone in response to each incident affecting the 3M System, within the timeline set forth in Incident Response Table below.

3.3.3. 3M will document the key information of each alert, including a measurement of priority as suggested by Customer.

3.3.4. 3M will update this incident documentation from the beginning of the alert, continuing through completion of remediation efforts.

3.3.5. 3M may alter the measurement of priority as originally suggested by a Customer Primary Contact.

3.3.6. 3M will notify Customer when a resolution is identified. 3M will request Customer approval prior to closing each incident, allowing Customer a minimum of 2 Business days to confirm acceptance of resolution.

3.3.7. All 3M blanking line issues will initially be diagnosed remotely. If the issue can be resolved via the Customer supplied contact, 3M will do so. 3M will

utilize the Incident Response Table shown below in determining the final process for resolving any equipment incident. When remediation requires equipment updates, 3M will identify ownership of hardware and equipment (as applicable to the system installed) and define and communicate an action plan with a Customer Primary Contact per the Incident Response Table shown below.

3.3.8. 3M does not guarantee timing for completion of repairs; however, 3M will use commercially reasonable efforts to complete repairs in a timely manner to minimize the impact on operation of the 3M blanking line. 3M's responses and efforts will be based on the severity of the incident as described in the Incident Response Table below.

3.4. Reporting and Controls

3.4.1. 3M will establish, in cooperation with one or more Customer Primary Contacts, a process by which the 3M blanking line will be maintained, and operational status will be communicated.

3.5. 3M Support Team. 3M reserves the right to provide maintenance and support services through its own staff or 3M-authorized contractors.

4. Hours of Operations

4.1. Business hours: defined as 3M's standard hours for operation on Business days, 7 a.m. – 5 p.m. Central Time.

4.2. Business days: defined as the days when 3M normal in-office business operations are undertaken, Monday through Friday, excluding Holidays.

4.3. Non-business days: defined as the weekend days, Saturday and Sunday, and Holidays.

4.4. Holidays: defined as 3M-recognized days when 3M business operations will, in 3M's discretion, either be restricted or completely unavailable.

5. Incident Response Table; 3M Contact Information; Resolution Plan

5.1 Incident Response Table:

Severity Level of Incident	Severity Definition	Occurring during	Notification to be sent	Response to be started	Equipment, Hardware and Software Action Plan
1	An incident with significant scope and negative impact to the Customer's business, typically effecting product/revenue producing activities, worker safety or immediate information security.	Business hours	Within 1 Business hour of Initiation	Within 1 Business hour of Initiation	1) 3M to contact Customer. 2) 3M seeks to resolve issue remotely. 3) If unable to resolve within 8 Business hours, 3M provides a resolution plan within 4 Business hours following initial resolution attempt which may include sending a 3M engineer within 48 hours and/or repair parts for next day am delivery
2	An incident with limited scope or negative impact to the Customer's business, degraded operations or noted potential to quickly increase in urgency or scope	Business hours	Within 1-2 Business hour of Initiation	Within 4 Business hours of Initiation	1) 3M to contact Customer. 2) 3M seeks to resolve issue remotely. 3) If unable to resolve within 8 Business hours, 3M provides a resolution plan within 8 Business hours following initial resolution attempt which may include sending a 3M engineer within 48 hours and/or repair parts for next day delivery
3	An incident having limited scope or negative impact to the business, unlikely to quickly increase in urgency or scope	Business hours	Within 2-3 Business hour of Initiation	Within 8 Business hours of Initiation	1) 3M to contact Customer. 2) 3M seeks to resolve issue remotely. 3) If unable to resolve within 16 Business hours, 3M provides a resolution plan within 16 Business hours following initial resolution attempt which may include sending a 3M engineer within one week and/or repair parts for two day delivery
4	An incident, question or request to 3M that has minimal to no impact to business operations. Incident may be an improvement request, feature inquiry or functionality concern with limited operational scope.	Business hours	Within 3-4 Business hour of Initiation	Within 16 Business hours of Initiation	1) 3M to contact Customer. 2) 3M seeks to resolve issue remotely. 3) If unable to resolve within 40 Business hours, 3M provides a resolution plan within 24 Business hours following initial resolution attempt.

5.2 Customers can call the toll-free number: 1-877-777-3571 to report an incident. 3M will respond in accordance with the Incident Response Table

5.3 3M's resolution plan will include details on how 3M will seek to resolve the issue, initially via diagnostics with the CSI supplied contact, and if necessary, to include sending repair parts to the Customer, and additionally, if the issue resolution requires it, travel by a 3M technical service engineer to the Customer's location to resolve the incident as indicated above in the incident response table. The Customer must provide access to the CSI identified contact as 3M will always attempt to resolve any issue via the phone with the C5I contact before any other actions are taken. In addition, the customer must provide physical access to the system should a 3M engineer need to travel to the customer's site. Note – if the issue is caused by an equipment failure covered by this agreement, 3M travel is covered to the customer site. If the incident is caused by customer negligence or is not the fault of the 3M equipment (power outage, power surge, natural disaster, etc.), customer agrees to pay 3M an hourly rate of $225 for a 3M employee to travel to and work at the customer's site.

6. Customer Responsibilities

6.1 Access.

6.1.1 Phone access must be provided to the CSI identified contact for 3M to perform maintenance or resolve an issue. Physical access to the 3M blanking line may also be required should an issue not be resolvable via phone access. Failure to provide phone support via a CSI identified resource will result in all SLAs for 3M support services being converted to "as time permits" and all support services will be billed as time and materials per 3M's then current time and materials rates until phone access is reestablished, including travel costs, should travel to the customer site be necessary as a result of 3M not being allowed to connect to the CSI identified technical contact.

6.2 Customer Communication Requirements

6.2.1 Customer will immediately alert the 3M Technical Support Team of any concerns regarding 3M blanking line errors, availability, security, confidentiality or reliability.

6.2.2 Customer will notify the 3M Technical Support Team in writing of any changes to Customer Primary Contacts.

6.3 Issue Detail; Replicability. Customer shall provide the 3M Technical Support Team with enough detail for 3M to troubleshoot and resolve the issue.

7. Out of Scope Services

7.1 Service requested by the Customer as the result of the following events is outside the scope of maintenance services to be provided under this SOW and unless the parties agree mutually otherwise in writing, 3M shall have no responsibility therefor: (i) unauthorized modification of Exhibit A equipment or software; (ii) Issues or damages caused by misuse, abuse, accidental damage, theft, excessive heat, cold or moisture, power failures or fluctuations, or telecommunications faults or failures; (iii) issues related to equipment not listed on Exhibit A, including but not limited to the introduction of non-3M approved equipment into the 3M blanking line. Additionally, 3M shall not be responsible for monitoring of 3M blanking line equipment components listed on Exhibit A.

EXHIBIT A

3M Blanking Line Components:

Description of Blanking Line Equipment	Serial Number for Hardware	Quantity
Horizontal Unwind stand (Powered)		1
Sheeting Applicator		1
Electronic Roll Feed		1
Blanking Press, (includes slug collector and two conveyors – one for passenger plates and the other for motorcycle plates)		1
6 inch by 12 inch passenger plate die		2
4 inch by 7 inch motorcycle plate die		1

STATE OF NEBRASKA
STATE PURCHASING BUREAU
LICENSE PLATE BLANKING LINE
REQUEST FOR PROPOSAL NO. 6152 Z1
3M'S COMMENTS AND QUALIFICATIONS

COMMENT NUMBER	SECTION NUMBER	PAGE NUMBER	COMMENT
II. TERMS AND CONDITIONS			
1	M. Indemnification 1. General	Page 13	3M agrees to defend, indemnify, and hold and save harmless the State and its employees and officials from and against third party claims, including reasonable attorney fees, caused solely by the willful misconduct or negligence of 3M and its employees arising from 3M's performance of this contract.
	2. Intellectual Property		This intellectual property infringement provision shall not apply to any infringement or alleged infringement which is the result of or arises out of the State's or its employees or agents modifying or altering any part or component, alone or in combination with any other part or component, except as consented to in writing by Contractor.
III. CONTRACTOR DUTIES			
2	I. Antitrust	Page 22	3M agrees to assign to the State any material claims for overcharges resulting from antitrust violations as to goods and/or services provided in connection with this contract.
3	J. Conflict of Interest	Page 22	3M Company is a global, publicly traded company with annual sales in 2018 of $32.8B, over 90,000 employees worldwide and numerous business units. Because of 3M's size and the broad nature of the certification requested, 3M cannot state with certainty that no relationship exists between 3M and any person or entity that is or gives the

COMMENT NUMBER	SECTION NUMBER	PAGE NUMBER	COMMENT
			appearance of a conflict of interest related to this Request for Proposal. That said, 3M is unaware of any such relationship that would create a conflict of interest in 3M's performance of this contract.
IV. PAYMENT			
4	H. Right to Audit	Page 26	3M agrees to cooperate with authorized representatives of the State by providing access to its non-proprietary records involving the performance of this contract during an audit. The records subject to audit to not include the disclosure of 3M's labor costs, processes or any other proprietary information. These records and any or all copies remain the property of 3M. State auditors who review the records will maintain strict confidentiality of these records and disclose such records only to those employees, officers and agents of the State who are required to review these records in connection with this contract.

3M Company Government Contracts
Power of Attorney

By the authority granted the undersigned by the Corporate Secretary, the individuals listed below are hereby appointed as 3M's or its designated subsidiaries, true and lawful attorneys-in-fact for it, and its name, for commercially available products and services and government unique products and services for which 3M or its designated subsidiaries will be a prime contractor, subcontractor or higher tier subcontractor to any federal, state or municipal governmental agency in the United States ("Government Contracts"), to perform acts specified on behalf of this Corporation.

Except as provided below, authority is granted to submit or execute proposals, bids, binding purchase orders, contracts and subcontracts, certifications, representations and warranties, and documents related thereto for Government Contracts; however, this authority does not include (a) research and development services;* (b) executing country of origin certifications**; or (c) any other authority that is not expressly granted in this document. 3M executives (Vice President, General Manager, etc.)****, have authority to sign on behalf of their respective Business Unit/staff function, through 3M's Director of Government Contract Compliance subdelegation authority. Authority for the individuals below is limited to the specific Business Unit or staff function indicated and such authority may not be subdelegated.

3M Unitek Corporation Gregg, Shawn McCloskey, Molly Advanced Materials Division Davis, Scott Hanson, Scott Lockhart, Bruce Moeller, Kent Morin, Eric Pearson, Claudia Race, Robert Utley, Elizabeth Ward, Charles Aearo Technologies LLC. Hinko, David Automotive and Aerospace Solutions Division *see Government Marketing-Sales* Display Materials & Systems Division Summers, Micki Electrical Markets Division Disanayaka, Bimsara Irwin, Mike James, Brent Kieffer, John Larson, Loren McGurran, Dan	Electronics Materials Solutions Division Anderson, Kevin Food Safety Department Wadie, John Government R&D Contracts Department* Kays, Steven Martinez, Rita 3M Health Information Systems Black, Lisa Garrison, Garri Graves, Terri Jennings, Gerald Kim, Myung Mason, Deborah Mathison, John McDonough, James Mitchell, Brian Peddicord, Kyle Stadther, Joseph Industrial Adhesives & Tapes Division *see Government Marketing-Sales* (FSS Contracts Only)	Industrial Mineral Products Division Erickson, Scott Medical Solutions Division Heataja, Brian (Service Support only) McDonald, Michael Oral Care Solutions Division Gregg, Shawn McCloskey, Molly McDonald, Michael Personal Safety Division *see Government Marketing-Sales* Separation & Purification Towne, Richard Stationery & Office Supplies Division Rihm, Diana Transportation Safety Division Broin, Susan Do, Thanh-Huong*** Frampton, Steven Lorence, Craig Seputis, Julie*** Trac, Phu***

Authority Applies to any Business Unit or Staff Function		
Global Channel Services Constantine, Lauri U.S. Pacific Branches Mathers, Stephanie Kawasaki, Heidi	Government Marketing-Sales Weller, Greg Keeler-Ramacier, Kelly	Government Contract Compliance Agoye, Jenna Bordas, Rich Carr, Terrance Horwitz, Charles Paraschou, Maria Robinette, Thomas

**Authority to Make Country of Origin Certifications		
Trade Compliance Department Goebel, Kathleen	LaMere, Pierre	Mulinix, Jonathen

For all appointments, authority may be withdrawn or modified at any time, including upon an individual's change in responsibility.

This Power of Attorney revokes all prior Powers of Attorney with respect to the same matters and shall remain in effect until terminated by the undersigned or any other person authorized to grant powers of attorney on behalf of 3M.

By: Charles Horwitz

9. 25. 19

Charles Horwitz
Director, Government Contract Compliance
3M Company

Date

* Authority is delegated by 3M's Senior Vice President, Research and Development, and Chief Technology Officer, to the Vice President, Research and Development, for their respective 3M Business Groups, and to certain specified employees in Government Research & Development Contracts, to execute proposals, contracts, subcontracts (including certifications, representations and warranties to comply with certain laws and regulations) for government R&D services.

*** Authority expressly limited to executing Certificates of Conformance.

**** 3M executives may assign attorney-in-fact authority to their respective business personnel, upon successful completion of Government Contract Compliance Power of Attorney training.

3M Science. Applied to Life.™

Squeeze Roll Applicator Features and Specifications

Requirements

- 120 VAC, 15 Amp
- 100 psi Air Supply

Web Line Specifications

- Web widths:
  3.5 – 16 inches
- Line Speeds:
  Typical 10 – 50 feet/min

Product Features

Automatic web steering
Stretch control within +/- 0.010 of target
Stretch range from 0.5% to 4%
Automatic outfeed loop control
Graphic / Standard stretch modes
Interlocking Capabilities
6 inch password protected touch display
Product counter (total and batch)
Alarms and warning indicators
Automatic shutoff with web/substrate loss
Automatic shutoff with registration loss
Display screen diagnostics

All equipment is designed and constructed with user's safety as a top priority and meets applicable OSHA safety and machine guarding standards.

NRTL (National Recognized Testing Laboratory) listing or label. Example UL/cUL.

Wiring practices must follow NEC and more specially NFPA 79 for the machine Wiring.

Panels built to comply with UL 508A standards.

3M Science. Applied to Life.™

Electronic Roll Feed Features and Specifications

Requirements

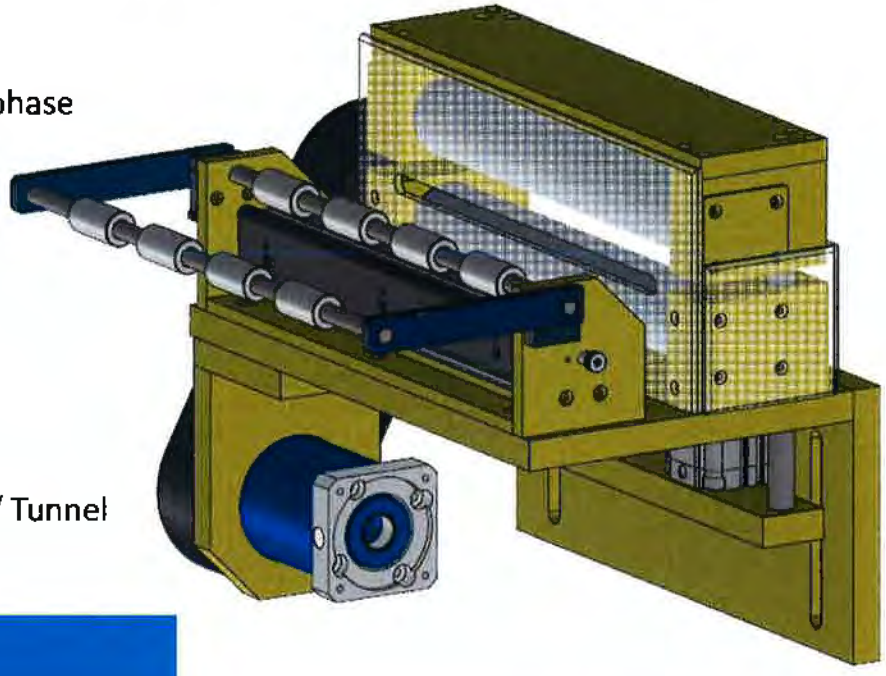
- 208/230 VAC, 20 Amp, 1 or 3 phase
- 100 psi Air Supply

Web Specifications

- Web widths:
  3.5 – 13 inches
- Line Speeds:
  Typical 10 – 50 feet/min

Dimensional Footprint

- 21in W x ≈ 32in D Roll Feed w/ Tunnel
- 32in W x 10in D Control Panel



Product Features

Graphic Mode
(Centers graphics with stretch variations)

Standard Mode
(Feeds User Defined Length)

Alarms and Warning Indicators

Password Protected Display for Faults and Troubleshooting

User Defined Parameters with Display

Interlocking Capabilities

Product counter

Photoelectric Contrast Registration Sensing

Automatic shutoff with registration loss

Blanking Press Top Stop and Emergency Stop Capabilities

Product Features Continued

Accepts Clear to Feed Signal from Press

Provides Feed Complete Signal to Press

All equipment is designed and constructed with user's safety as a top priority and meets applicable OSHA safety and machine guarding standards.

NRTL (National Recognized Testing Laboratory) listing or label. Example UL/cUL.

Wiring practices must follow NEC and more specially NFPA 79 for the machine Wiring.

Panels built to comply with UL 508A standards.

INDUSTRIES

INSTALLATION & OPERATING INSTRUCTION MANUAL

Form No. 1114 3-08

PALLETIZER

Model PR-4
Model PR-5
Model PR-6
Model PR-8
Model PR-10

PALLETIZER

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PALLETIZER

SAFETY INSTRUCTIONS

Throughout this manual, each section will emphasize certain safety precautions that should be adhered to by all personnel who are setting up, operating, maintaining, and repairing your **P/A Pallet Reel**.

It is impossible to mention all the precautions that should be taken in a working environment, therefore, it is **YOUR** responsibility to "**BE ALERT**" while working on, or operating this equipment.

CAUTION - PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED

1) DO **NOT** OPERATE THE MACHINE UNTIL THE MANUAL HAS BEEN READ.

2) STAY CLEAR OF ALL MOVING PARTS.

3) STOP MACHINE BEFORE CLEANING.

4) DISCONNECT MACHINE BEFORE OILING OR PERFORMING MAINTENANCE.

5) MAKE SURE MACHINE IS PROPERLY GROUNDED.

6) BE AWARE THAT ONLY QUALIFIED PERSONNEL SHALL OPEN ELECTRICAL CABINET.

7) DO NOT PUT HANDS UNDER PLATFORM TO ROTATE MANUALLY.

PALLET REEL DESCRIPTION

The *Pallet Reel* pallet decoiler is specifically designed to automatically feed strip stock directly from a palletized stack of coils. The *Pallet Reel* series are designed and built to handle a variety of stock widths, thickness and stacked weights. This is accomplished by three major components of the Pallet Reel system: **Base, Control Arm, and Drive.**

BASE

The BASE of the Pallet Reel is a series of urethane casters equally spaced. These casters are positioned on the outside edge of the rotating top to insure the unit will rotate smoothly under great loads. This design is the reason your Pallet Reel can effectively handle up to 10,000 Lbs. (depending on model) and still be easily positioned on line. This low profile design also saves on valuable shop floor space.

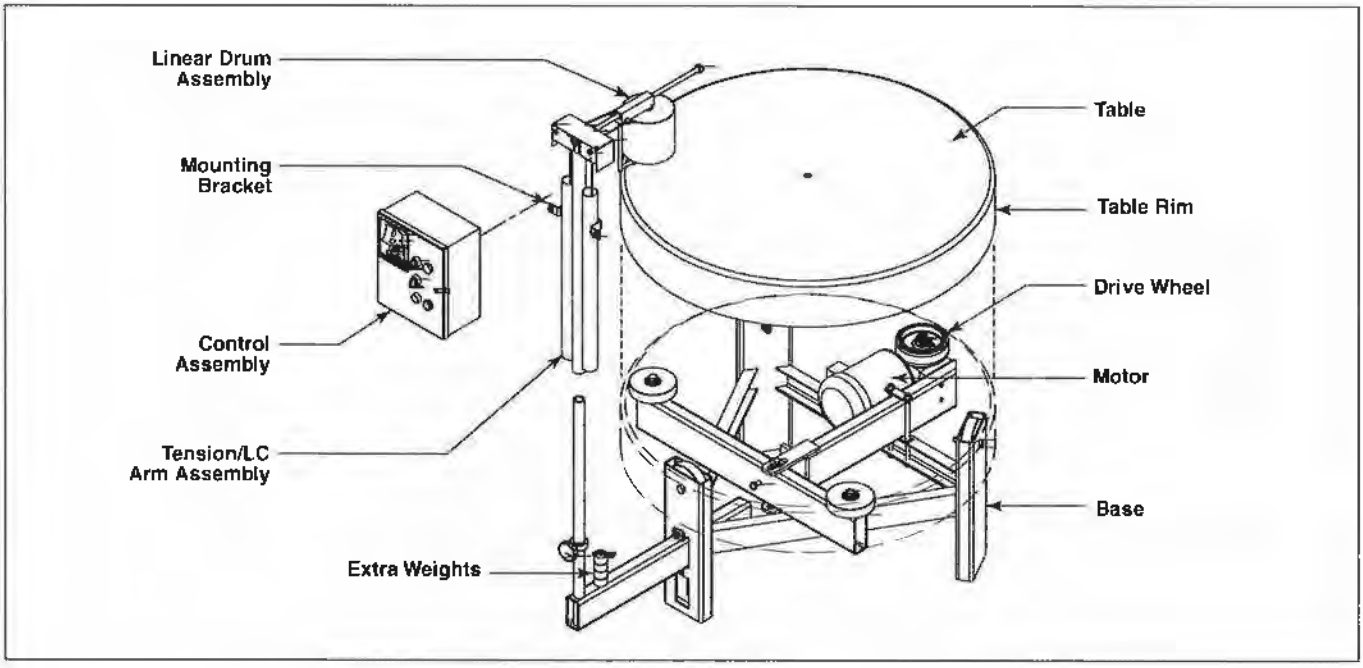
CONTROL ARM ASSEMBLY--

The CONTROL ARM is the most important and critical element to your horizontal Pallet Reel. It guides the material, controls the turntable speed, and provides consistent and constant material tension to your press or forming equipment. This unique design to the Pallet Reel is the most effective available to the industry.

It has a hollow, lightweight feed pulley that slides horizontally on linear bearings so that the weight of the drum is supported. Weights are attached to the drum to minimize their inertia affect and to give constant tension to the material being controlled. With this system, it is possible to achieve very accurate tensioning of thin and thick stock without bending or distortion by adding or subtracting weights.

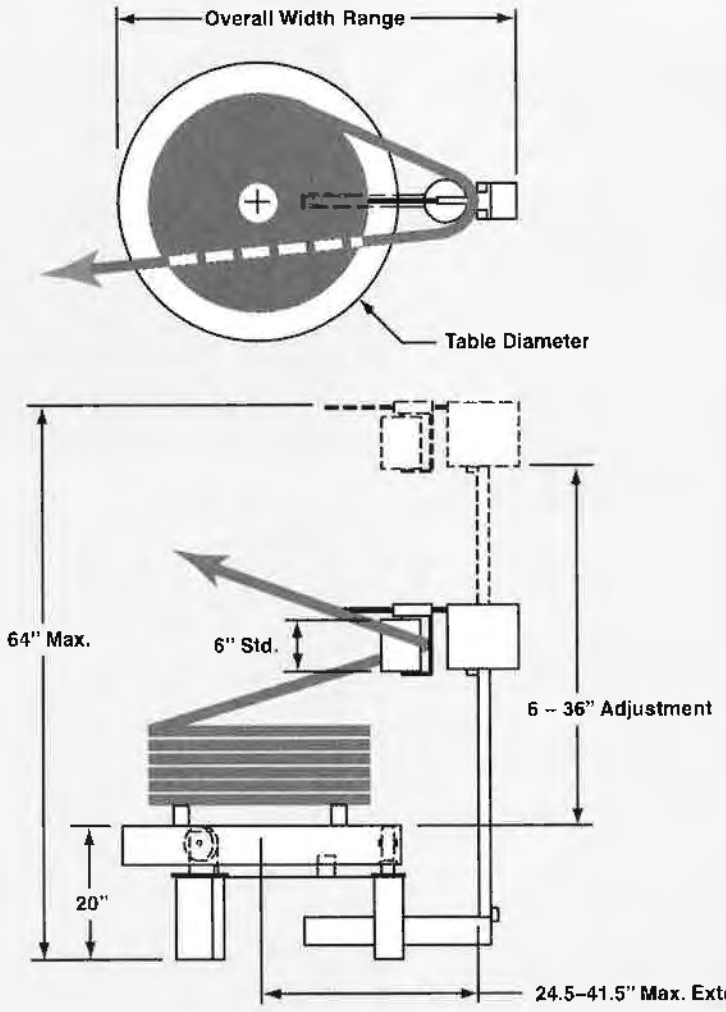
DRIVE

A high torque, AC motor, with a right angle worm gear reducer, drives a solid rubber wheel against the inside rim of the table.



PALLETIZER

DIMENSIONS



SPECIFICATIONS

Model		PR4	PR5	PR6	PR8	PR10
Pallet Coil Weight		4000 Lbs.	5000 Lbs.	6000 Lbs.	8000 Lbs.	10000 Lbs.
Table Diameter		42"		52"		
Overall Width Range		46–63"		56–73"		
Coil Stacking Height		36"				
Table RPM	- Standard	0–12				
	- Optional	0–24				
Stock Width	- Standard	0–6"				
	- Optional	0–9"	0–12"	0–15"	0–18"	0–24"
Stock Thickness Range		.004–.065"				
AC Drive Motor, HP		3/4	1	1-1/2 (High Speed 2)	2	3
Electrical Input		120 VAC, 1 Phase, 60 Hz		240 VAC, 1 Phase, 50/60 Hz		
(Optional Voltage Available)		230 VAC, 1 Phase, 50/60 Hz		400V, 50 Hz and 460V, 60 Hz		

UNIT INSTALLATION

Receiving

Inspect the Pallet Reel for shipping damage immediately upon receipt. If damage is observed, make a note of the damage on the carrier's delivery receipt before signing. Then notify your local carrier terminal and P/A Industries.

The Pallet Reel is shipped disassembled and packaged for protection during transit. Care should be taken during unpacking so that all paper work and parts are collected and accidental damage is avoided. The stretch wrap around the head assembly should be removed after assembly, not before.

Assembly

The Control Head Assembly Base Arm must be inserted into one of the two holes provided in the leg (Figure 1). For shipment, a rubber band is placed around the Base Arm Tightening Assembly. Remove this rubber band. Select which mounting hole to use by identifying the job to be run. General guidelines are as follows:

The following drawing displays Control Head capacity dimensions:

Use Lower Mounting Hole (Figure 2) for:

- Very narrow strip stock less then 2" where parallel pull-off is preferred.
- Coil stack height does not exceed 30".

Use Upper Mounting Hole (Figure 3) for:

- Tall coil stacks where maximum elevation of Guide Drum Assembly is required.
- Wider strip materials where near parallel UN-winding is not a concern.

Lift the Control Head Assembly from the tabletop, leave wrapped until inserted, and slide the base arm into the selected mounting hole. The Base Arm slides in and out of the leg to allow adjustable clearance for different size pallets rotating on the tabletop.

Position Base Arm to desired location and tighten the one hex head bolt to wedge the base arm in a fixed position. If using the upper mounting hole, simply unthread the wedge-tightening bolt and reinstall the assembly at the upper hole.

Base arm position drawing

Remove stretch wrap protecting the Control Head Assembly and remove corrugated retainers located in Weight Channels.

Electrical Power

The electrical power requirement of your Pallet Reel is clearly marked on the Control Box and on the tag attached to the end of the power cord.

Models requiring 220V (and up) power are shipped without a supply power connection.

Please ensure the Pallet Reel is connected to the correct power source and that all wire, cable, etc. are installed in accordance with all prevailing codes. Refer to schematic for proper fuse or circuit breaker size.

Figure 1

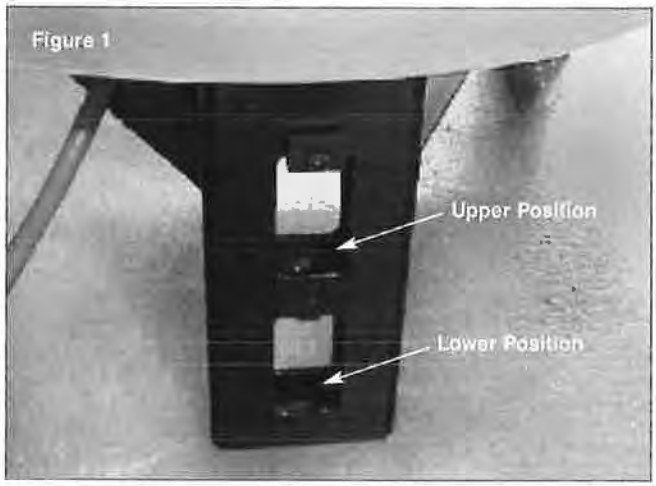


Figure 2

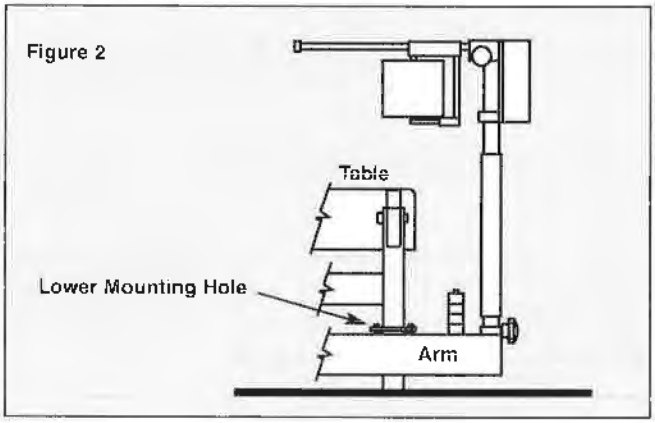
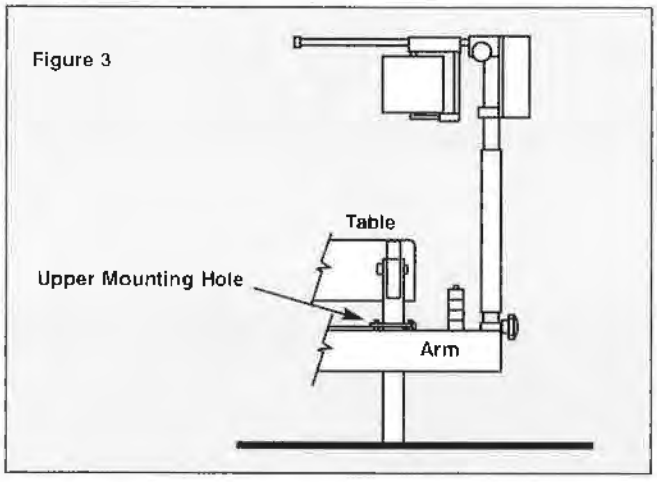


Figure 3



Safety Interlock Circuit

Each Pallet Reel is equipped with a pre-wired Safety Interlock Circuit.

NOTE: FAILURE TO ENSURE OPERATIVE INTERLOCK CIRCUIT CAN RESULT IN PERSONNEL INJURY TO PRODUCTION EQUIPMENT, AND VOIDING OF THE PALLET REEL WARRANTY.

The Safety Interlock Circuit will allow you to shut down the production equipment used in conjunction with the Pallet Reel if the Pallet Reel detects a Drive Fault or a material tight loop condition. There is a pre-wired circuit in the Pallet Reel that requires connection to associated production equipment.

Control Head Position (Figure 4)

The Control Head should always be aligned with the production equipment feed entry so that the strip loop will follow a straight run from the Pallet Reel Guide Drum directly to the forming equipment entry. This alignment can be done by visual line of sight from Control Head Mast to feed entry.

Table Position (Figure 4)

The diagrams demonstrate the various material flow options available. Although feeding the coil strip directly back over the coil stack (Position 3) is a feasible option, it is not highly recommended. Unwinding off to either side is preferred since this reduces the opportunity for tangling the strip on the coil stack and damaging the strip edge. Also, off center feeding will allow a more parallel pull of the strip from the coil.

Distance from Forming Equipment

The distance required between the Pallet Reel and the forming equipment will depend on the characteristics of the coil strip being used. There is no specific rule or formula for this determination.

The strip material passes around the Pallet Reel Guide Drum in a vertical position. As it feeds to the forming equipment it will transition to a horizontal plane requiring a 1/4 turn or twist either to the left or right. The distance required to achieve this twist easily, without kinking or bending, will determine the position for the Pallet Reel.

Lighter, thinner materials will transition very easily and will require little more than the 42" footprint of the Pallet Reel itself. Heavier, thicker materials will require more loop length to achieve the 1/4 twist and more set back will be required.

You may estimate this distance before positioning the Pallet Reel by pulling off a strip from the coil to be used, manually twist to 1/4 turn and measure the distance needed to achieve an easy transition. Place the Control Head of the Pallet Reel at this approximate measured distance from the forming equipment.

OPERATIONS START-UP

Before beginning production with the Pallet Reel, complete the following steps to ensure a safe and successful start-up.

Positioning (Refer to Figure 4))

Make sure the Pallet Reel is oriented so that the Control Head Mast is aligned with the feed entry to the forming equipment. Also, make sure that the table is placed to accommodate the wind direction of the coils to be fed.

It is best to check positioning at this stage rather than later when the pallet load is on the turntable.

Clockwise/Counter-Clockwise (CW/CCW) Rotation

Examine the coils to be fed to determine the unwind direction. Determine if the coil will rotate in a CW direction or a CCW direction.

Set the CW/CCW Switch on the Motor Control Box to the appropriate setting. Change setting of this switch only when table rotation has stopped.

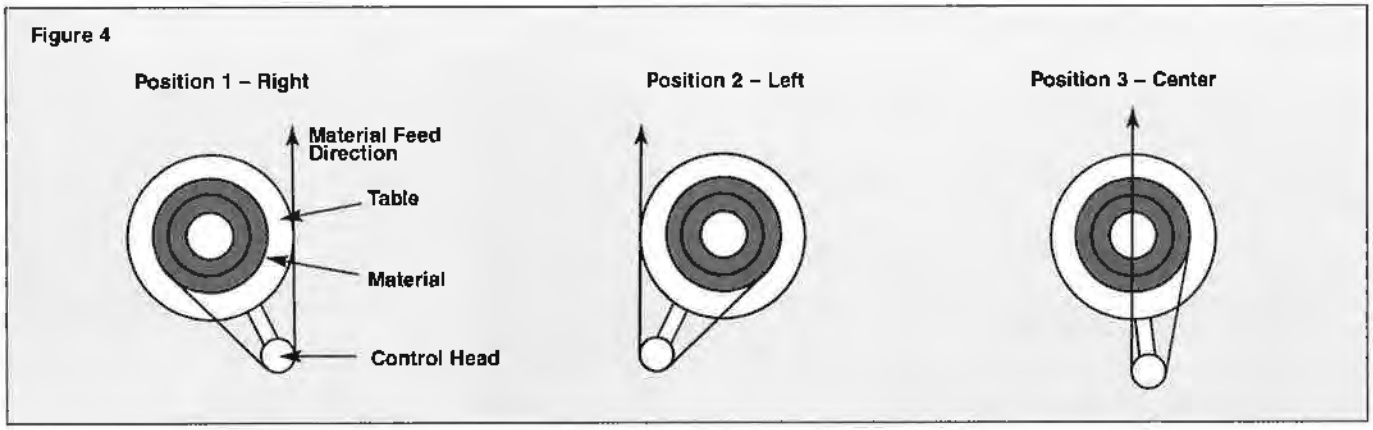
Loading

Load the pallet of coiled materials, being careful not to strike the Control Head Assembly. The top portion of the Control Head can be swiveled to the left or right to position it away from the loading side.

Center these coils on the turntable with eyesight accuracy. The Pallet Reel can tolerate a small amount of off-center loading, however too great a miss-alignment will create an oscillating rotation of the coils which will cause uneven feeding and uneven loading on the Pallet Reel frame and tabletop.

Be aware of the difference between centering the coil and centering the pallet. Coils are not always centered on the

Figure 4



pallets. When loading the Pallet Reel, it is best to look at the coils first and then the pallet for centering purposes.

The load should be checked on all sides for centering and to ensure no strapping or wrapping materials are hanging down off the turntable.

Base Arm Adjustment

As described under Unit Installation (Page 5), the Control Head Base Arm slides in and out of the leg, closer or farther away from the table top, for the purpose of clearing overhanging pallet corners.

This adjustment is made by loosening the two 3/8" nuts at the Base Arm, positioning the arm as needed, and retightening the two nuts. See BASE ARM POSITION DRAWING on page 5.

Ensure that the Control Head Mast is sufficiently away from the turntable to allow pallet corners to rotate past with generous free clearance.

Control Head Height Adjustment (Figure 5)

The height of the Control Head is manually adjusted to accommodate the decreasing height of the coil stack as coils are fed into the forming equipment.

Loosen the black knob on the Control Head Mast and slide the Control Head and Support Ring up or down as needed. When in position, tighten the black knob to secure the height position.

The Control Head should be adjusted so that the bottom of the Guide Drum is parallel or somewhat higher than the bottom edge of the top coil. This setting will allow the strip to separate from the coil cleanly without hitting the wood spacers under the coil.

As the coils are expended, the Control Head should be manually lowered with the start of each new coil. For narrower width strips, the Control Head may need to be lowered only for every second or third coil. Experience will be your best guide.

Pre-Test

Pre-Test operation of the Pallet Reel in the following manner:

1) Apply power to the control. Check "Power On" light is illuminated.

2) Place Selector Switch Man/Auto in the Man position. Depress the Jog button for table rotation.

3) Select CW/CCW switch and Motor Arm position for proper directional setting.

4) Place Selector Switch Man/Auto in the Auto position.

5) Manually slide Guide Drum on Linear Rod. Observe normal rotation of table (Figure 6)

6) Manipulate Guide Drum to different positions on Linear Rod. Observe variable rotation speed of table.

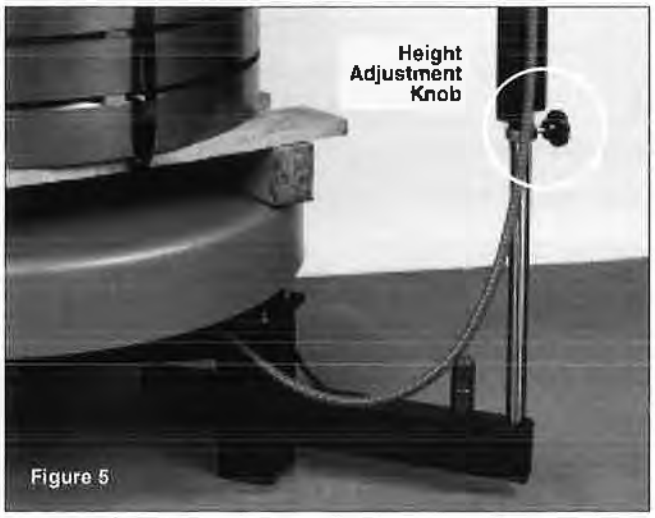


Figure 5

7) Release Guide Drum and allow it to fall back to off position. Observe stopping of table rotation.

8) Extend the Guide Drum to the end of the Linear Rod travel (Figure 7). Pull the Guide Drum further to activate the Tight Loop fault. Check that the red Reset pushbutton is illuminated indicating the Tight Loop fault. Reset the Tight Loop fault by pushing inward on end of Linear Rod then pushing the Reset pushbutton to distinguish the red Reset pushbutton light (Figure 9 on page 9).


Figure 6

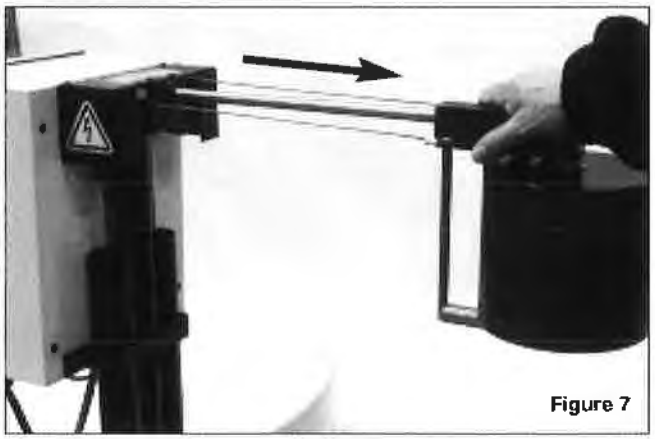


Figure 7

Counter-Weight Tension System

Begin operation with two weights on each cable. Pull cable upwards through top of Weight Channel. Weights are easily added or removed by positioning the Cable Toggle to slip weights on or off.

Extra weights are stored on the Base Arm.

The weight on the cables should be sufficient to draw the Guide Drum back to the off position when material demand stops. Weight/tension should not be so great as to cause undue stress on the stock or erratic motion of the Guide Drum.

There is no formula or specific rule regarding how much tension weight is needed. The goal is to balance the weight of the strip loop with the back tension created by the weights. Variables of strip width, thickness, loop weight, feed length and press speed in a wide range of combinations preclude a specific guiding rule.

Proper weight/tension balance is a matter of beginning with two weights on each cable, running the forming equipment, observing results at guide drum, and then adjusting weights.

Optional Coil-lock (Figure 8)

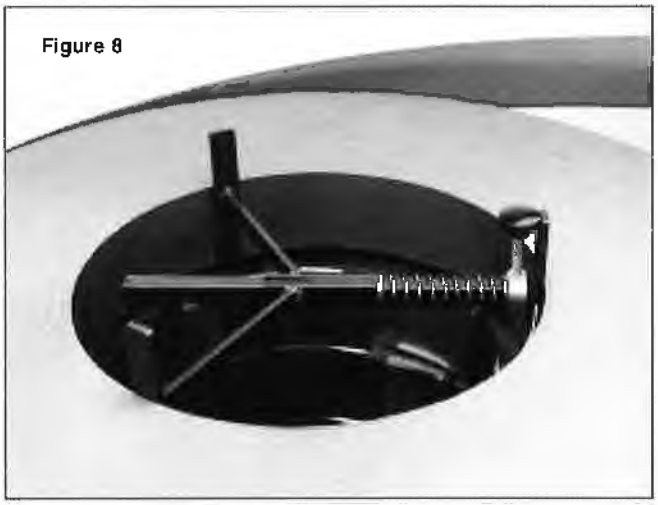
The Coil-Lock will prevent the top coil from shifting off center or pulling off the coil stack as its weight diminishes toward the inside diameter of the coil. The Coil-Lock fits inside the open space at the core of the coil stack.

Trial fit the Coil-Lock.

Adjust the length and tension of the Coil-Lock by positioning the Stop Collar at the appropriate location. The Stop Collar is secured with the black knob. Set the Stop Collar in a position that results in a Coil-Lock length slightly longer than the I.D. dimension.

The Coil-Lock is compressed and placed in the open I.D. space, then released to snugly press outward against the coil.

Figure 8



The vertical legs of the Coil-Lock should connect with the top coil and however many of the lower coils as strip width will allow.

MAINTENANCE

Proper care and maintenance of the Pallet Reel will ensure efficient operation and will extend service life of the machine.

We recommend that upon receipt of your Pallet Reel, arrangements be made to have your Pallet Reel added to the plant maintenance schedule to ensure regular and consistent maintenance attention.

WARNING - DO NOT PERFORM ANY MAINTENANCE FUNCTIONS WITHOUT FIRST DISCONNECTING POWER.

Cleaning

Periodically wipe clean the surface areas of the Pallet Reel including the tabletop, Control Box and Guide Drum.

Frequency of cleaning will be dictated by shop conditions of dirt, dust, oil, etc.

Lubrication

- Edge Guide Roller - At 30-day intervals apply a thin coat of light machine oil.
- Reduction Gear- Manufacturer's product information contains detail on this maintenance procedure. The following summarizes lubrication change schedules.

	Petroleum Lubricant	Synthetic Lubricant
Initial Change:	250 hours	1500 hours
Regular Change:	2500 hours or six months	5000 hours

- Linear Shaft – At thirty-day intervals wipe polished rod and spray with DTE Light Oil or other light machine oil.

Electric Motor

Manufacturer's product information contains detail on care of the motor.

TROUBLE SHOOTING

Table Does Not Rotate or Tight Loop

- Check Supply Power and Line Voltage.
- Check Circuit Breaker inside the motor control.
- Check if Reset Light on Control is illuminated. Reset by either pushing Reset Button and/or pressing Linear Shaft towards Motor Control (Figure 9).

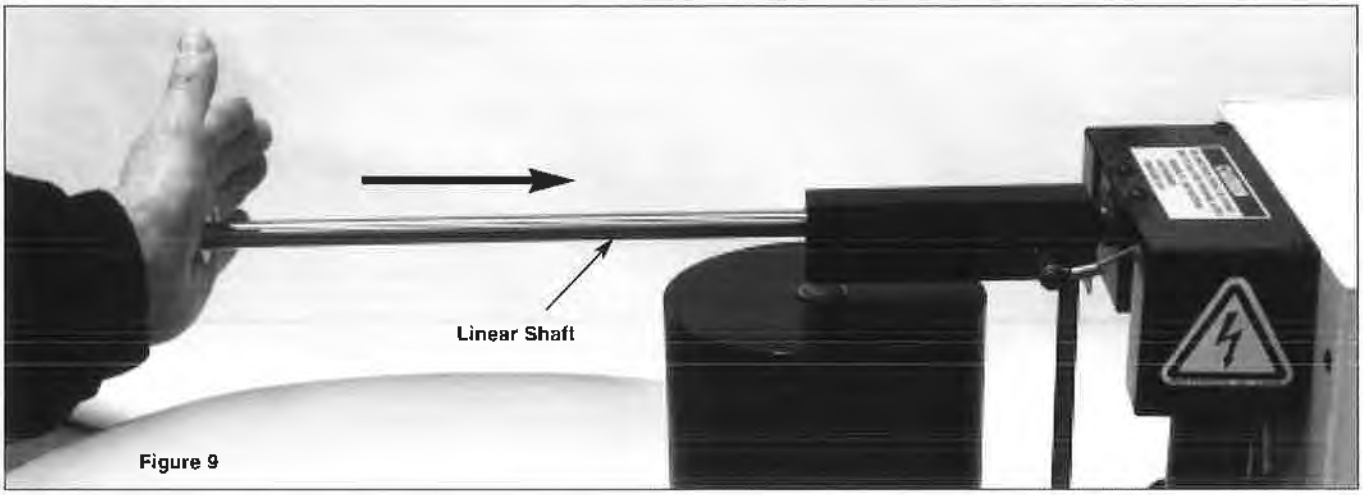


Figure 9

Table Does Not Stop

- Inspect cable windings on Pulley Cable Guide to be sure that each winding is laying flat and that full rotation is operative (Figure 10).
- Add more weight one at a time; from one side to the other until weight is sufficient to pull Drum Roller back to off position.

Table Does Not Rotate Fast Enough

- Check for stable Supply Power and correct line voltage.
- Visually check that Drive Wheel is touching inside of table rim (Figure 11).
- Inspect cable windings on Pulley Cable to be sure that each winding is laying flat and that full rotation of Pulley Cable is operative.
- **With power disconnected**, inspect and feel inside surface of tableside rim for grease or lubricant. Presence of such material will cause Drive Wheel to slip, clean both rim and Drive Wheel with a suitable cleaner. Review speed requirements of job and speed capability of the Pallet Reel to ensure compatibility.

Erratic Motion in Drum Roller

- Check that Drive Wheel is touching inside of table rim.
- Review number of Tension Weights placed on Tension Cables. If Drum Roller is moving erratically back and forth, this usually indicates too much weight. Remove weights one at a time, from one side then the other until balance in the Drum movement is achieved.
- Inspect cable windings on Pulley Cable Guide to be sure that each winding is laying flat and that full rotation of capstan is operative.

Drum Roller Hitting Tight Loop

- Machine Feed demands material faster than Pallet Reel acceleration.
- Review speed requirements of job and speed capability of the Pallet Reel to ensure compatibility.
- Review number of tension Weights placed on Tension Cables. If Drum Roller is moving erratically back and forth, this usually indicates too much weight. Remove weights one at a time, from one side then the other until balance in the Drum movement is achieved.

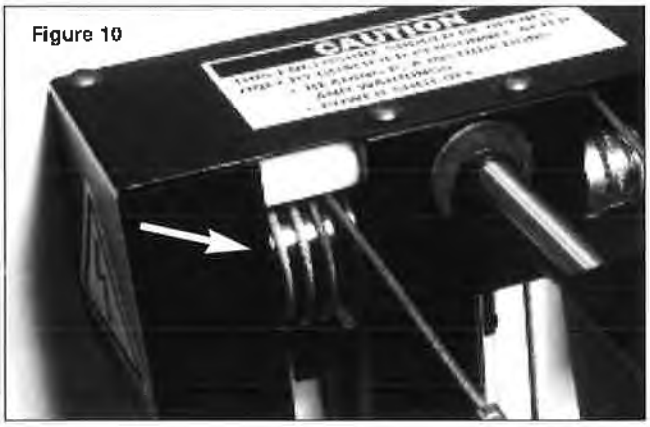
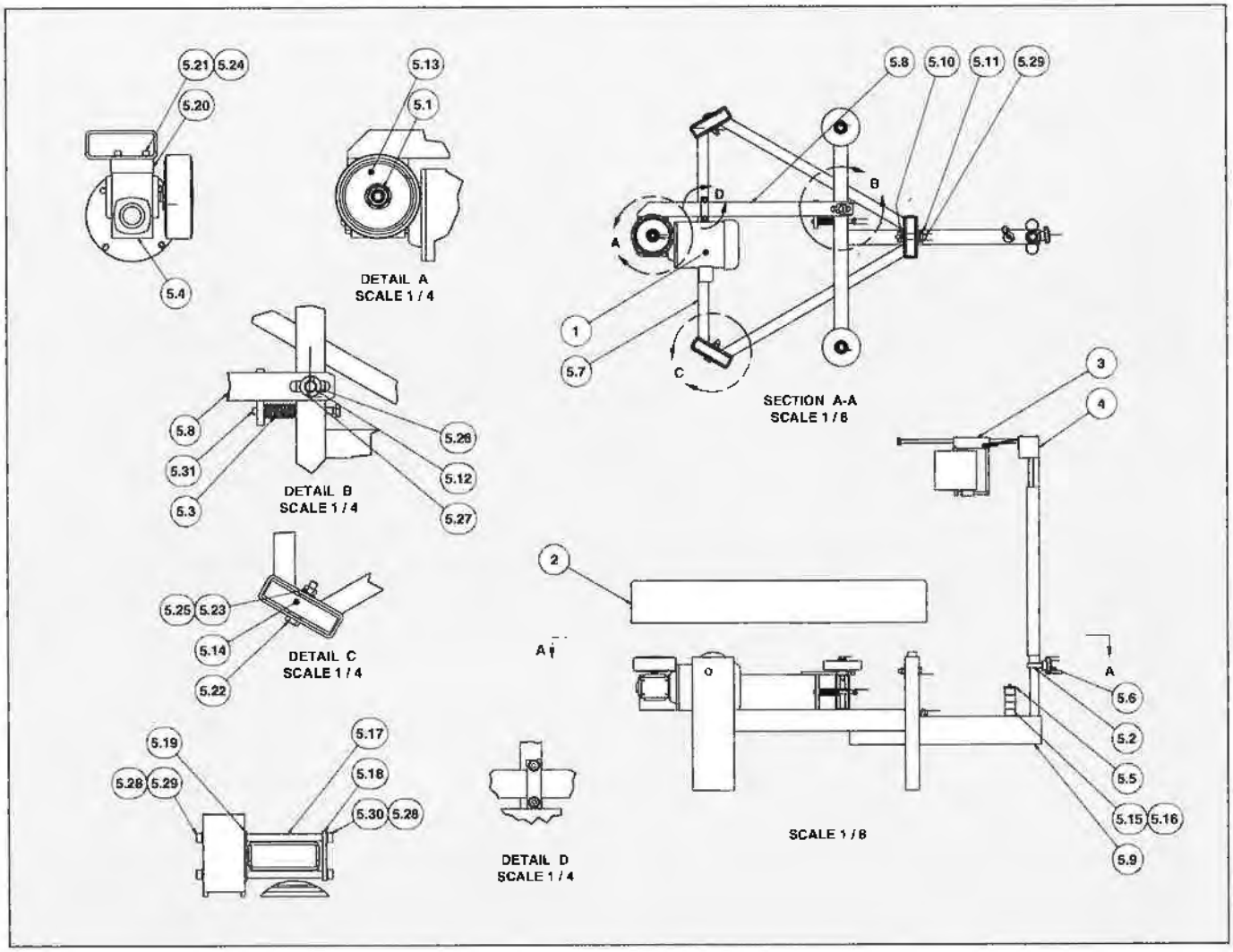


Figure 10

Figure 11

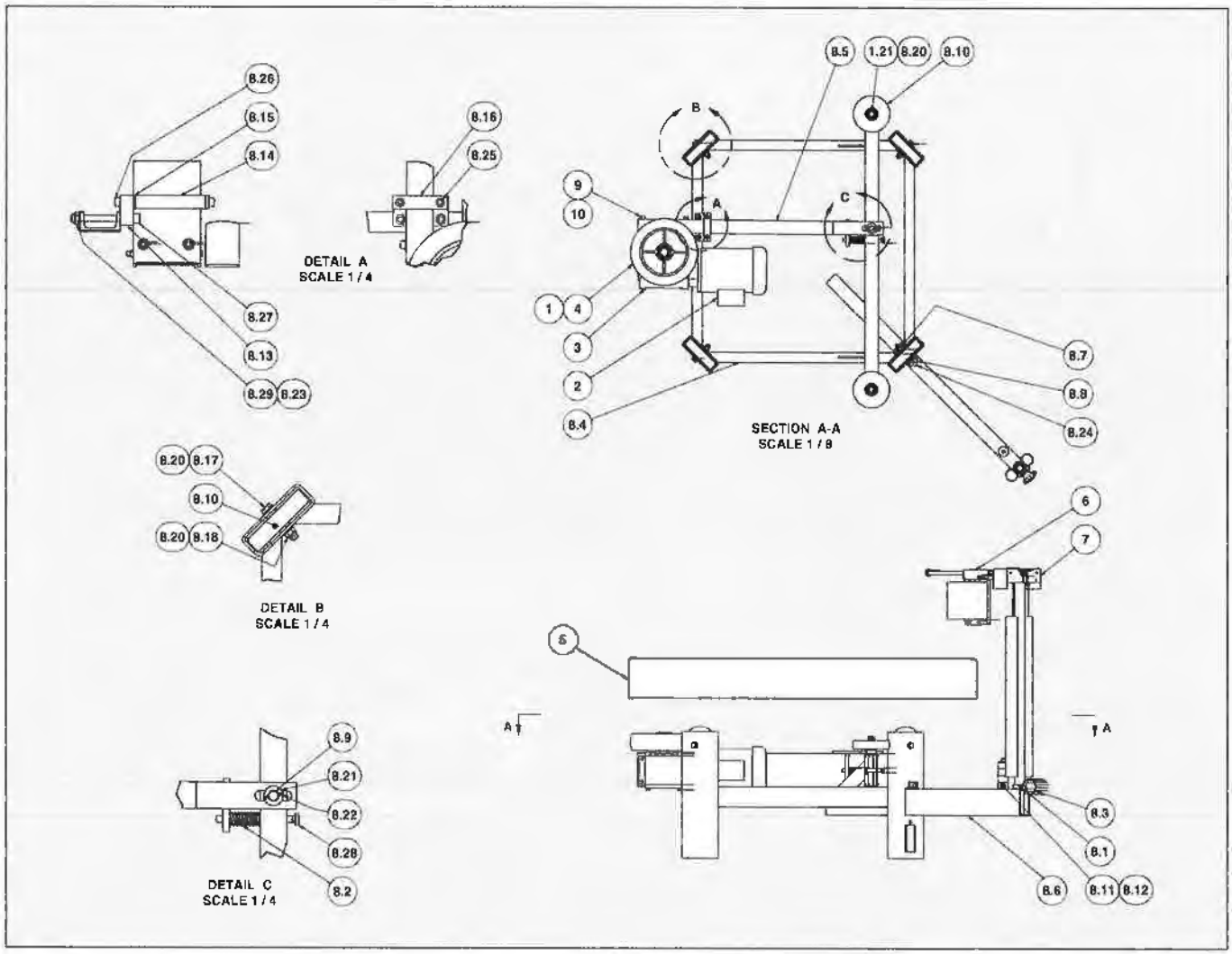
PALLETIZER PR-4 and PR-5



Item	Qty	Description	Part Number
1	1	PR-4 Motor, 230/460 VAC	12125-111
	1	PR-5 Motor, 230/460 VAC	12125-126
2	1	PR-4 Table, 42 in.	17934-01
	1	PR-5 Table, 42 in.	17934-03
3	1	Guide Drum Assembly, PR	Refer to pg.14
4	1	Tension/LC Arm Assy, PR, 12 in. Travel	17962-20
5.1	1	Trantorque, 1.5 OD x .625 ID	12028-55
5.2	1	Set Collar, 1.25 ID x 2.0 OD x 11/16	12441-108
5.3	1	Spring, Compression, 1 OD x .5 ID x 3	12442-77
5.4	1	Reducer, Worm Gear, 15:1, 133, 56C	12445-143
5.5	1	Hairpin Cotter Pin, 1/8 Dia x 2.30 Long	12466-69
5.6	1	Knob, 2.38 Dia x 3/8-16 Thd x .50 Long	14977-02
5.7	1	Base Weldment, Fixed Arm PR, 42 in.	17920-03-04
5.8	1	Motor Arm, Fixed, PR, 42 in. (25.16)	17921-07
5.9	1	Arm Weldment, Outrigger, PR, 42 in.	17923-01
5.10	1	Clamp, Outrigger, Threaded, Metric	17925-02
5.11	1	Clamp, Outrigger, Thru Hole	17926
5.12	1	Pin, Motor Arm	17927
5.13	1	Wheel, Drive, 6 in. Dia x 2 in.	17930-01

Item	Qty	Description	Part Number
5.14	5	Wheel Assembly, Idler, 5.415 Dia	17931-01
5.15	4	Collar, Counter Weight	17955-01
5.16	1	Rod, Counter Weight Storage	17964
5.17	2	Spacer, 1.0 OD x .56 ID x 5.24 Long	18233-04
5.18	1	Strap, Hold Down, 3.5 x 1.0 x .25 Thick	18234-03
5.19	1	Wear Strip, 3.5 x 1.0 x .125	18234-04
5.20	1	Spacer, Reducer, 1 in. Tigear 13Q Series	18783-01
5.21	4	5/16-18x2" Lg, SHCS Black	900031-16
5.22	5	1/2-13x3.0 Lg, Hex Hd, Cap Screw	908050-24
5.23	3	1/2-13, Hex Nut, Nylon Insert Locknut, Stain	942050SS
5.24	4	5/16, Flat Washer, SAE	958031
5.25	5	1/2, Flat Washer, SAE	958050
5.26	1	3/4, Flat Washer, SAE, ZP	959075
5.27	2	.187 Diax1 1/2 Lg, Roll Pin	972P18-12
5.28	4	M10, Washer, Flat, Reg, Zinc Plated Steel	Din-125-M10
5.29	3	M10x110mm Lg, SHCS, Black	Din-912-M10x100
5.30	2	M10x25mm Lg, SHCS, Black	Din-912-M10x25
5.31	1	M12x150mm Lg, Hex Hd SCR, Black	Din-933-M12x150

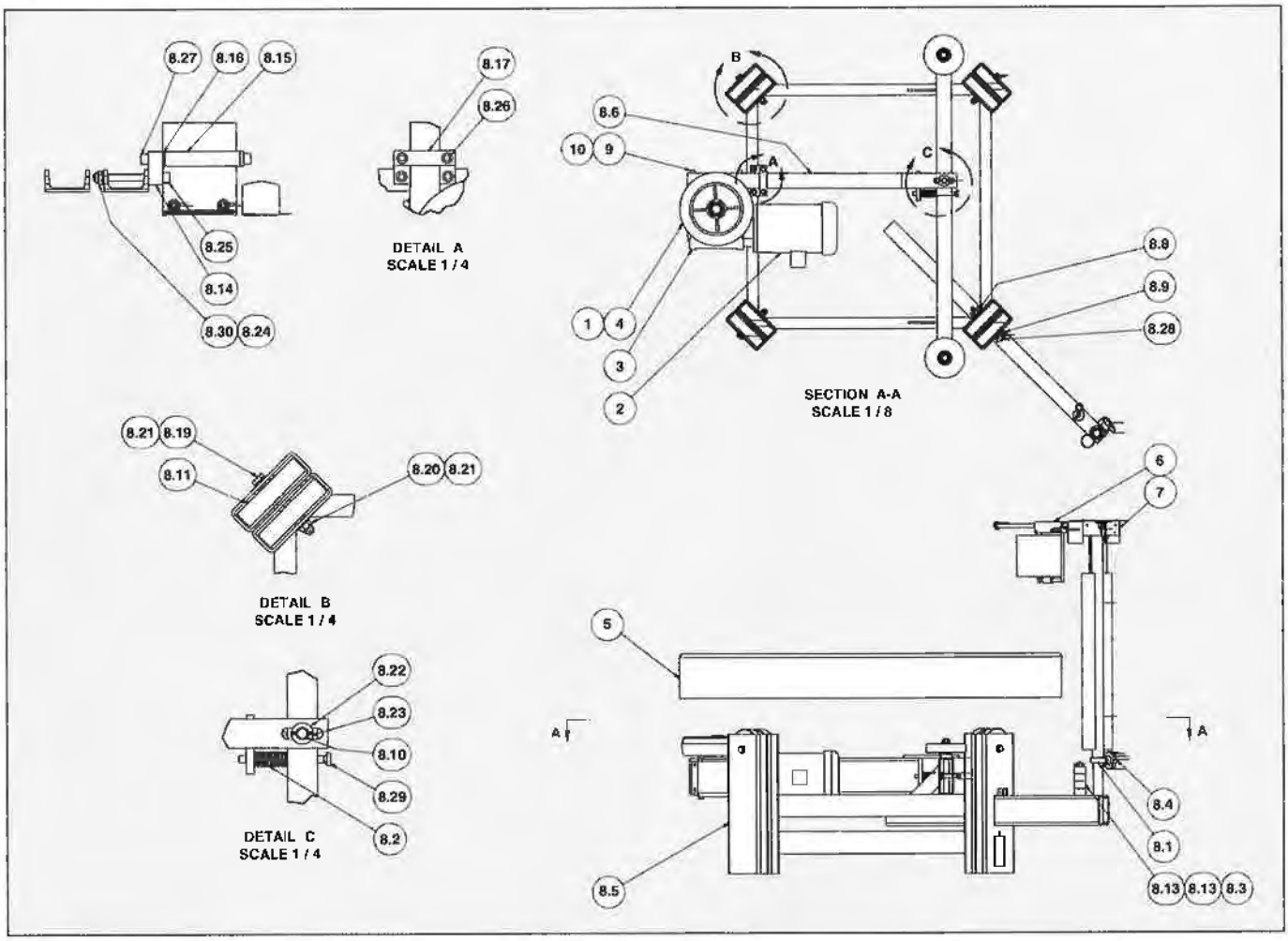
PALLETIZER PR-6



Item	Qty	Description	Part Number
1	1	Trantorque, 2.0 OD x 1.125 ID	12028-72
2	1	PR-6 Motor, 230/460 VAC	12125-125
	1	PR-6HS Motor, 230/460 VAC	12125-128
3	1	PR-6 Reducer, Worm Gear	12445-76
	1	PR-6HS Reducer, Worm Gear	12445-154
4	1	Wheel, Drive, 10 Dia x 2.5 W x 2 in. Bore	17930-06
5	1	Table, 52 in.	17934-02
6	1	Guide Drum Assembly, PR	Refer to pg.14
7	1	Tension/LC Arm Assy, PR 12 in. Travel	17962-20
8.1	1	Set Collar, 1.25 ID x 2.0 OD x 11/16	12441-108
8.2	1	Spring, Compression, 1 OD x .5 ID x 3	12442-77
8.3	1	Knob, 2.38 Dia x 3/8-16 Thd x .50 Long	14977-02
8.4	1	Base Weldment, Fixed Arm, 52 in. Table	17920-02
8.5	1	Motor Arm, 42 in, Stationary	17921-09
8.6	1	Arm Weldment, Outrigger, PR 52 in.	17923-02
8.7	1	Clamp, Outrigger, Threaded, Metric	17925-02
8.8	1	Clamp, Outrigger, Thru Hole	17926
8.9	1	Pin, Motor Arm	17927
8.10	6	Wheel Assembly, Idler, 5.415 Dia	17931-01
8.11	4	Collar, Counter Weight	17955-01

Item	Qty	Description	Part Number
8.12	1	Rod, Counter Weight Storage	17964
8.13	1	Spacer, 1 in. Square x 4.25	18233-06
8.14	2	Spacer, 1.0 OD x .56 ID x 5.25 Long, mm	18233-07
8.15	1	Wear Strip, 4.25 x 1.0 x .125	18234-05
8.16	1	Spacer, 1.0 OD x .56 ID x 5.24 Long	18234-06
1.21	2	1/2-13x2 1/2 Lg, Hex Hd. Cap Screw	908050-20
8.17	4	1/2-13x3 Lg, Hex Hd, Cap Screw	908050-24
8.18	4	1/2-13, Hex Nut, Nylon Insert Locknut, ZP	942050ZP
8.20	10	1/2, Flat Washer, SAE	958050
8.21	1	3/4, Flat Washer, SAE, ZP	959075
8.22	2	.187 Dia x 1 1/2 Lg, Roll Pin	972P18-12
8.23	2	M12, Washer, Flat, Reg, Zinc Plated Steel	Din-125-M12
8.24	1	M10x110mm Lg, SHCS, Black	Din-912-M10x100
8.25	2	M10x20mm Lg, SHCS, Black	Din-912-M10x20
8.26	2	M10x40mm Lg, SHCS, Black	Din-912-M10x40
8.27	2	M12x120mm Lg, SHCS, Black	Din-912-M12x120
8.28	1	M12x150mm Lg, Hex Hd Scr, Black	Din-933-M12x150
8.29	2	M12, Hex Nut, Nylon Insert Lock Nut, ZP	Din-985-M12
9	4	3/8-16 x 2 1/2 Lg, SHCS, Black	900038-20
10	4	3/8, Flat Washer	958038

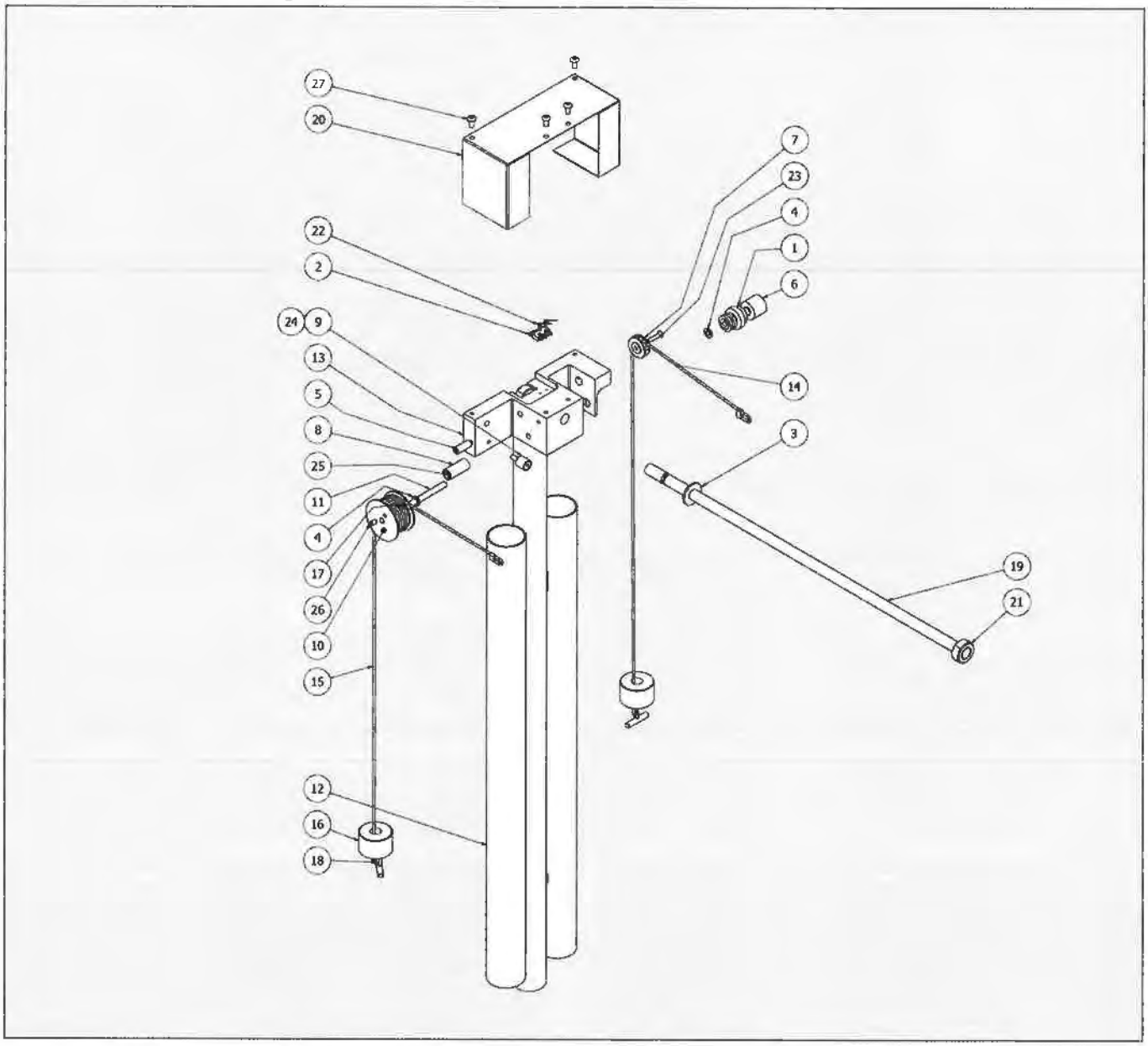
PALLETIZER PR-8 and PR-10



Item	Qty	Description	Part Number
1	1	Trantorque, 2.0 OD x 1.125 ID	12028-72
2	1	PR-8 Motor	12125-128
	1	PR-8HS Motor	12125-128
	1	PR-10 Motor	12125-106
	1	PR-10HS Motor	12125-106
3	1	PR-8 Reducer	12445-76
	1	PR-8HS Reducer	12445-154
	1	PR-10 Reducer	12445-85
	1	PR-10HS Reducer	12445-156
4	1	Wheel, Drive, 10 Dia x 2.5 W x 2 in. Bore	17930-06
5	1	Table, 52 in.	17934-02
6	1	Guide Drum Assembly, PR	Refer to pg.14
7	1	Tension/LC Arm Assy, PR 12 in. Travel	17962-20
8.1	1	Set Collar, 1.25 ID x 2.0 OD x 11/16	12441-108
8.2	1	Spring, Compression, 1 OD x .5 ID x 3	12442-77
8.3	1	Hairpin Cotter Pin, 1/8 Dia x 2.30 Long	12466-69
8.4	1	Knob, 2.38 Dia x 3/8-16 Thd x .50 Long	14977-02
8.5	1	Base Weldment, PR-8/10	17920-04
8.6	1	Motor Arm, 42 in, Stationary	17921-09
8.7	1	Arm Weldment, Outrigger, PR 52 in.	17923-02
8.8	1	Clamp, Outrigger, Threaded, Metric	17925-02
8.9	1	Clamp, Outrigger, Thru Hole	17926
8.10	1	Pin, Motor Arm	17927

Item	Qty	Description	Part Number
8.11	10	Wheel Assembly, Idler, 5.415 Dia	17931-01
8.12	4	Collar, Counter Weight	17955-01
8.13	1	Rod, Counter Weight Storage	17964
8.14	1	Spacer, 1 in. Square x 4.25	18233-06
8.15	2	Spacer, 1.0 OD x .56 ID x 5.25 Long, mm	18233-07
8.16	1	Wear Strip, 4.25 x 1.0 x .125	18234-05
8.17	1	Spacer, 1.0 OD x .56 ID x 5.25 Long	18234-06
8.18	2	1/2-13x2 1/2 Lg, Hex Hd, Cap Screw	908050-20
8.19	4	1/2-13x5.0 Lg, Hex Hd, Cap Screw, GR5, ZP	908050-40GR5ZP
8.20	4	1/2-13, Hex Nut, Nylon Insert Locknut, ZP	942050ZP
8.21	14	1/2, Flat Washer, SAE	958050
8.22	1	3/4, Flat Washer, SAE, ZP	959075
8.23	2	.187 Diax1 1/2 Lg, Roll Pin	972P18-12
8.24	2	M12, Washer, Flat, Reg, Zinc Plated Steel	Din-125-M12
8.25	2	M12x120mm Lg, SHCS, Black	Din-912-M12x120
8.26	2	M12x20mm Lg, SHCS, Black	Din-912-M12x20
8.27	2	M12x40mm Lg, SHCS, Black	Din-912-M12x40
8.28	1	M10x150mm Lg, Hex Hd SHCS, Black	Din-933-M10x150
8.29	1	M12x150mm Lg, Hex Hd Scr, Black	Din-933-M12x150
8.30	2	M12, Hex Nut, Nylon Insert Lock Nut, ZP	Din-985-M12
9	4	3/8-16 x 2 1/2 Lg, SHCS, Black	900038-20
10	4	3/8, Flat Washer	958038

CONTROL ARM ASSEMBLY

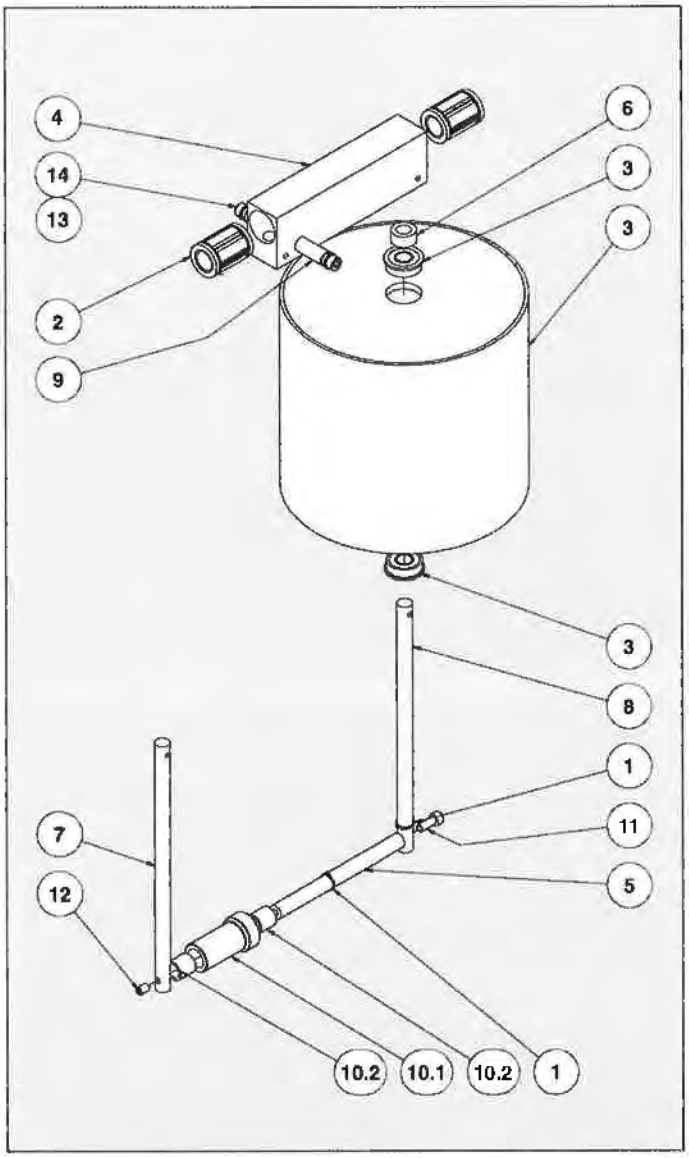


Item	Qty	Description	Part Number
1	1	Coupling, .25 Bore, Adj Slip	12028-77
2	1	Limit Switch, Micro, 10A @ 240 VAC	12031-23
3	1	Washer, Rubber, .5 ID x 1.062 OD x .093	12434-59
4	2	Washer, Thrust, .255 ID x .437 OD x 1/16	12434-60
5	1	Plunger, Ball, M8 x 22mm Long	13379-70
6	1	Potentiometer, 3-Turn, 10K	14946-16
7	1	Sheave, 1.0 Dia x 1/8 Rope Dia	14963-60
8	1	Wire Rope Guide	17945
9	1	Wire Rope Guide	17945-03
10	1	Pulley, Cable Guide, Metric	17946-03
11	1	Shaft, Pulley, Cable Guide	17947-01
12	1	Mast, Tubular Weldment	17948-02
13	1	Mounting Block, Upper, Control Mast, Metric	17950-05
14	1	Cable, 30 in Long, w/Loop Ends	17954-01

Item	Qty	Description	Part Number
15	1	Cable, 42 in Long, w/Loop Ends	17954-02
16	2	Collar, Counter Weight, 1 in	17955-01
17	1	Pin, Cable Pulley Guide	17957
18	2	Pin, Cable Counter Weight	17959
19	1	Linear Shaft, 1/2 OD x 20 in	17961-01
20	1	Cover, Tension/Loop Control Arm	17963-04
21	2	Collar, Modified, .501 ID	18305-03
22	2	M2x8mm Lg, Cheesehdscr, Raised, Steel-Plat	Din-7985-M2x8
23	1	M4x20mm Lg, FHSCS, Black	Din-7991-10-M4x20
24	1	M5x25mm Lg, FHSCS, Zinc Plated	Din-7991-M5x25
25	1	M5x30mm Lg, FHSCS	Din-7991-M5x30
26	1	M5x10mm Lg, Sock Set Scr, Cup Pt, Black	Din-916-M5x8
27	4	M5x10mm Lg, BHCS, Black	Din-9427-M5x10

GUIDE DRUM ASSEMBLY

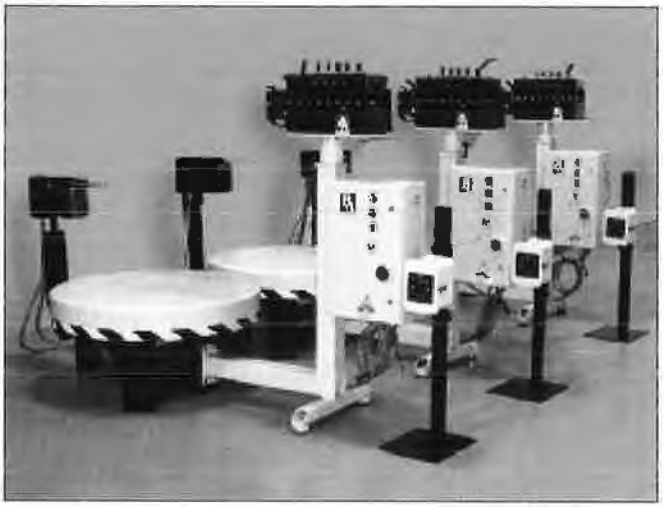
Item	Qty	Description	Part Number
1	2	Retaining Ring, External, 3/8 Shaft	12013-61
2	2	Linear Ball Bearing, .500 Dia	15433-24
3	1	Drum, Roller Guide Assy, 6 in. Drum	17935-01
	1	Drum, Roller Guide Assy, 9 in. Drum	17935-02
	1	Drum, Roller Guide Assy, 12 in. Drum	17935-03
	1	Drum, Roller Guide Assy, 15 in. Drum	17935-06
	1	Drum, Roller Guide Assy, 18 in. Drum	17935-04
	1	Drum, Roller Guide Assy, 24 in. Drum	17935-05
	1	Drum, Roller Guide Assy, 6 in. Drum, Urethane	17935-11
	1	Drum, Roller Guide Assy, 9 in. Drum, Urethane	17935-12
	1	Drum, Roller Guide Assy, 12 in. Drum, Urethane	17935-13
	1	Drum, Roller Guide Assy, 15 in. Drum, Urethane	17935-16
	1	Drum, Roller Guide Assy, 18 in. Drum, Urethane	17935-14
	1	Drum, Roller Guide Assy, 24 in. Drum, Urethane	17935-15
4	1	Bearing Block, Linear Guide	17938
5	1	Axle, Roller, Edge Guide	17939-01
6	1	Spacer, Roller	17940-01
7	1	Support Bar, Axle, 6 in Drum	17941-01
	1	Support Bar, Axle, 9 in Drum	17941-02
	1	Support Bar, Axle, 12 in Drum	17941-03
	1	Support Bar, Axle, 15 in Drum	17941-06
	1	Support Bar, Axle, 18 in Drum	17941-04
	1	Support Bar, Axle, 24 in Drum	17941-05
	1	Support Bar, Axle, 6 in Drum Urethane	17941-01
	1	Support Bar, Axle, 9 in Drum Urethane	17941-02
	1	Support Bar, Axle, 12 in Drum Urethane	17941-03
	1	Support Bar, Axle, 15 in Drum Urethane	17941-06
	1	Support Bar, Axle, 18 in Drum Urethane	17941-04
	1	Support Bar, Axle, 24 in Drum Urethane	17941-05
8	1	Axle, Drum Roller, 6 in Drum	17942-01
	1	Axle, Drum Roller, 9 in Drum	17942-02
	1	Axle, Drum Roller, 12 in Drum	17942-03
	1	Axle, Drum Roller, 15 in Drum	17942-06
	1	Axle, Drum Roller, 18 in Drum	17942-04
	1	Axle, Drum Roller, 24 in Drum	17942-05
	1	Axle, Drum Roller, 6 in Drum, Urethane	17942-01
	1	Axle, Drum Roller, 9 in Drum, Urethane	17942-02
	1	Axle, Drum Roller, 12 in Drum, Urethane	17942-03
	1	Axle, Drum Roller, 15 in Drum, Urethane	17942-06
	1	Axle, Drum Roller, 18 in Drum, Urethane	17942-04
	1	Axle, Drum Roller, 24 in Drum, Urethane	17942-05
9	1	Pin, Cable Anchor	17944-03
10	1	Roller Assembly, Edge Guide	17960-02
10.1	1	Roller, Edge Guide	17943-02
10.2	2	Bearing Sleeve, .3765 IDx.503 ODx.500 Long	12128-87
11	1	10-32x1/2 Lg, SHCS, Black	901010-04
12	1	10-24x3/8 Lg, Sock Set Scr, Cup Pt, Blk	931010-03
13	2	M5, Washer, Flat, Reg, Zinc Plated Yellow	Din-125-ZY-M5
14	2	M5x10mm Lg, SHCS, Black	Din-912-M5x10

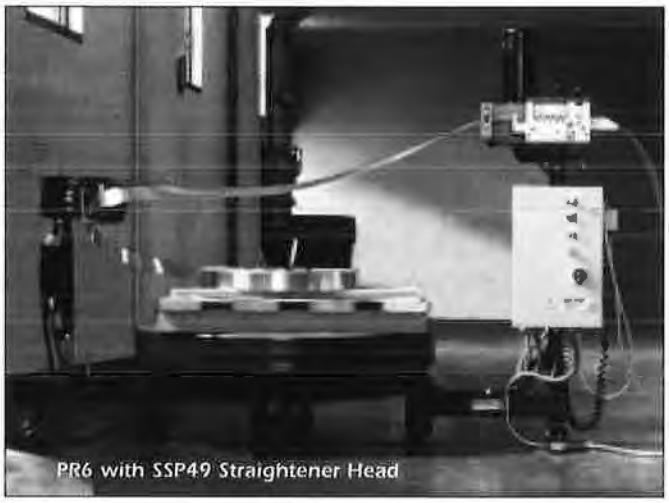


Guide Drum Assembly	
Description	**Part Number**
Linear Drum Assembly, PR, 6 in.	20029-01
Linear Drum Assembly, PR, 9 in.	20029-02
Linear Drum Assembly, PR, 12 in.	20029-03
Linear Drum Assembly, PR, 15 in.	20029-04
Linear Drum Assembly, PR, 18 in.	20029-05
Linear Drum Assembly, PR, 24 in.	20029-06
Linear Drum Assembly, Wire Guide	20029-21
Linear Drum Assembly, Break Away Wire Guide	20029-22
Linear Drum Assembly, PR 8 Dia x 2.12 with Pulley	20029-23
Linear Drum Assembly, PR, 6 in, Urethane	20029-31
Linear Drum Assembly, PR, 9 in, Urethane	20029-32
Linear Drum Assembly, PR, 12 in, Urethane	20029-33
Linear Drum Assembly, PR, 15 in, Urethane	20029-34
Linear Drum Assembly, PR, 18 in, Urethane	20029-35
Linear Drum Assembly, PR, 24 in, Urethane	20029-36

PALLET REEL STRAIGHTENER

The Pallet Reel Straightener incorporates all the features of the Palletizer and provides the additional function of straightening the material in a reduced floor space footprint. Separate Drive Motors and Loop Controls provide pallet reel rotation and material speed. This assembly provides larger material stock loop and no back tension.





PR6 with SSP49 Straightener Head

Model	Max. Pallet Weight (Lbs.)	Max. Stock Width (In.)	Stock Thickness Range (In.)	Max. Table Stacking Height (In.)	Table Speed Range (RPM)	Table Dia. (In.)	Drive Motor (HP)	Input Power VAC/Phase/Hz
PR4/SS49LC3	4000	4	.015 – .065	36	0 – 12 or 0 – 24	42	1/2	220 / 1 / 60
PR4/SS89LC3		6	.018 – .065			42	1/2	
PR4/SSP29LC3		2	.005 – .040			42	1	
PR4/SSP49LC3		4	.005 – .040			42	1	
PR4/SSP69LC3		6	.005 – .030			52	1	
PR6/SS49LC3	6000	4	.015 – .065			52	1.5	
PR6/SS89LC3		8	.018 – .065			52	1.5	
PR6/SSP29LC3		4	.005 – .040			52	2	
PR6/SSP49LC3		2	.005 – .040			52	2	
PR6/SSP69LC3		6	.003 – .030			52	2	

Guide Drum Assemblies up to 22" are available. Wire Guides available. Coil weights up to 10,000 lbs. are available.

WARRANTY AND SAFETY PROGRAM

Warning

This equipment offers various means of operating or controlling machines. The operator must not be in or near the point-of-operation of the machine, or the operating parts of any equipment installed on the machine, or bodily injury could result. The EMPLOYER must post adequate warning signs onto the machine with proper warnings for his machine and the specific application to which the machine and equipment are being applied.

Occupational Safety and Health Act (OSHA) Sections 1910.211, 1910.212, and 1910.217 contain installation information on the distance between danger points and point-of-operation guards and devices. No specific references have been made to which paragraph of OSHA 1910.211, 1910.212, 1910.217 or any other applicable sections because the paragraphs may change with each edition of the publication of OSHA provisions.

All equipment manufactured by us is designed to meet the construction standards of OSHA in effect at the time of sale, but the EMPLOYER installs the equipment so the EMPLOYER is responsible for installation, use, application, training, and maintenance, as well as adequate signs on the machine onto which this equipment will be installed.

Remember, OSHA says that the EMPLOYER must use operating methods designed to control or eliminate hazards to operating personnel.

It shall be the responsibility of the EMPLOYER to establish and follow a program of periodic and regular inspections of his machine to insure that all their parts, auxiliary equipment, and safeguards are in a safe operating condition and adjustment. Each machine should be inspected and tested no less than weekly to determine the condition of the machine. Necessary maintenance or repair of both shall be performed and completed before the machine is operated. The EMPLOYER shall maintain records of these inspections and the maintenance work performed.

Our Company is not responsible to notify the user of this equipment of future changes in State or Federal laws, or construction standards.

Safety Program

Accident free operation will result from a well developed management sponsored and enforced safety program.

Of vital importance to any successful program is the proper selection of guards and devices. However, there is no safety device that will bring "automatic" safety to your operation.

Of equal importance to this proper selection of the guard and the device is the training of your personnel. Each person must be trained as to the operation of the guard or safety device, highlighting why they have been provided on the equipment. Rules for safe operating should be written and enforced at all times. A final major concern of an effective safety program is regularly scheduled inspection and maintenance of all of the equipment.

To ensure continued safety at all times, top management, line supervision, safety engineers and all employees must assume their proper share of the responsibility in the program. Only as a group, one that knows your own operation and its problems, can you carry out an effective safety program.

To assist you in the development of and continued use of safety programs, many safety minded groups have made guidelines available to you. However, you must know when and how to apply these guidelines. The manufacturer provides information to assist you in properly adjusting and maintaining your equipment. There is no short cut to proper safety; therefore, it is recommended that you comply with their recommendations at all times.

Warranty

We warrant our new parts against defects under normal use and service for a period of 12 months after date of shipment. Our obligation under this warranty is limited to replacing or repairing (at our option) the defective part without charge, F.O.B. our plant in Bloomfield, Connecticut. The defective part must be forwarded or repair. EXCEPT AS EXPRESSLY PROVIDED HEREIN, THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING A WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Furthermore, the seller does not warrant or represent that the equipment complies with the provisions of any law, particularly including the Occupational Safety and Health Act of 1970, and regulations promulgated thereunder. In no event shall we be liable for special, indirect incidental or consequential damages, however rising.

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C Frame Crank Press (SN Series)

This is generally applicable for blanking, punching, bending and forming process on small single work of thin steel plate and progressive die parts, which can connect with single press, progressive die, mechanical arm or added with transfer system.

- High torque, low noise wet clutch and brake.Rigid frame with less deflection.
- High accuracy transmission gears and high rigidity crank ensure press long life and accuracy.
- Forced Lubrication system with default monitor ensures the operation reliability.
- User-friendly design and all-function electric control system provide high automation compatibility.

SN1 SERIES

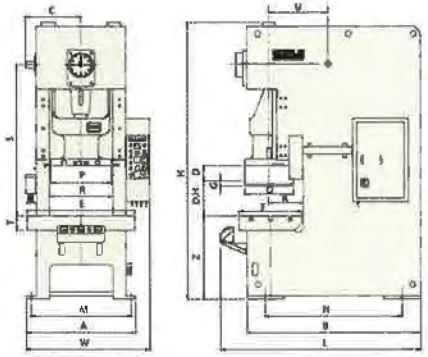
Blanking Press option: SN1-66

Model		SN1-28			SN1-39			SN1-50			SN1-66			SN1-88			SN1-121			SN1-176			SN1-220			SN1-275		
Type		S	H	P	S	H	P	S	H	P	S	H	P	S	H	P	S	H	P	S	H	P	S	H	P	S	H	P
Tonnage Capacity	U.S. Ton	28			39			50			66			88			121			176			220			275		
Stroke Length (I)	in	3.15	1.97	1.38	3.54	2.36	1.57	4.33	2.76	1.77	5.12	3.15	1.97	5.91	3.94	2.36	7.09	4.33	2.76	7.87	5.12	3.15	8.66	5.91	3.54	9.84	7.09	3.94
Stroke per Minute Fixed speed	S.P.M.	90	110	140	80	100	130	70	90	120	60	80	100	60	80	100	50	70	90	40	60	80	35	50	65	30	45	55
Variable speed		70~110	80~140	80~180	60~105	70~140	80~160	50~85	60~120	60~160	40~85	55~110	70~150	40~85	50~110	65~150	35~75	45~100	60~135	30~50	35~70	50~100	25~55	30~70	40~95	22~50	30~60	30~80
Tonnage Rating Point	in	0.13		0.09	0.13		0.09	0.13		0.09	0.16		0.09	0.20		0.13	0.20		0.13	0.24		0.16	0.24		0.16	0.24		0.16
Die Height (D.H)	in	9.06	7.87		9.84	8.66		10.63	9.45		11.81	10.63		12.99	11.81		13.78	12.60		15.75	14.17		17.72	15.75		17.72	15.75	
Slide Adjustment (R)	in	1.97			1.97			2.36			2.76			3.15			3.54			3.94			4.33			4.72		
Slide Area (PxQ)	in x in	12.99x9.84			14.96x11.81			16.93x13.78			18.90x15.75			22.05x18.11			25.59x20.47			28.35x22.83			33.86x25.59			37.80x28.35		
Diameter of Shank Hole	in	Φ1.50			Φ2			Φ2			Φ2			Φ2			Φ2			Φ2.56			Φ2.56			Φ2.56		
Bolster Area (ExF)	in x in	27.56x13.60			30.71x15.75			33.07x17.32			35.43x20.47			41.34x23.62			45.28x26.77			49.21x29.92			55.12x33.07			59.06x35.43		
Bolster Thickness (T)	in	3.35			3.94			4.53			5.12			5.51			6.10			6.50			7.09			7.09		
Bolster Height (Z)	in	31.50			31.50			31.50			35.43			35.43			35.43			35.43			39.37			39.37		
Frame - Inside Distance (R)	in	15.28			19.13			20.31			21.42			24.17			26.38			28.74			35.43			38.19		
Frame - Gap Distance (K)	in	6.69			8.27			9.06			10.63			12.20			13.78			15.35			16.93			18.11		
P.T.O. Shaft Position (CxSxU)	in x in x in	13.82x18.70x15.08			15.87x42.05x15.94			16.85x45.59x17.20			17.72x50.59x18.82			19.56x56.89x20.16			23.46x64.17x24.17			25.43x71.22x27.01			29.76x81.38x28.58			31.34x89.06x33.23		
Main Motor Fixed speed	HPxP	5x4			5x4			5x4			7.5x4			7.5x4			10x4			15x4			20x4			25x4		
Variable speed		5x4			5x4			5x4			7.5x4			10x4			10x4	15x4		15x4	20x4		20x4			25x4		
Slide Adjustment Motor	HPxP	—			—			—			0.5x4			0.5x4			0.5x4			1x4			1x4			1x4		
Foot Print (AxB)	in x in	28.35x41.65			32.68x44.29			35.04x47.64			37.01x51.77			41.34x58.27			45.67x66.14			51.18x78.15			58.27x83.19			61.42x94.49		
Position of Anchor Bolts(MxN)	in x in	24.41x34.57			28.74x36.42			31.10x39.76			33.07x43.90			37.40x48.43			41.73x54.33			46.46x65.16			53.54x69.02			56.69x78.74		
Required Floor Space(WxLxH)	in x in x in	34.45x52.36x81.10			38.78x55.12x86.02			40.75x58.46x90.16			42.72x63.78x100			47.05x70.28x108.46			51.57x78.15x117.72			59.45x90.16x128.74			66.54x95.08x146.65			69.69x106.50x157.68		
Required Air Pressure	PSI	71			71			71			71			71			71			71			71			71		
Die Cushion (Option)																												
Capacity	U.S. Ton	2.42			2.42			3.85			3.85			6.60			8.80			11.00			15.40			15.40		
Stroke Length	in	1.97			1.97			2.76			2.76			3.15			3.54			3.94			4.33			4.72		
Die Cushion Area(L.R.xF.B.)	in x in	11.61x8.27			11.61x8.27			13.39x9.21			13.39x9.21			16.14x10.24			18.90x11.81			21.26x13.39			25.20x17.32			29.13x21.26		

Blanking Press option: SN1-66

Machine Dimension

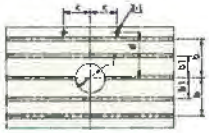
SN1-176, 220, 275 are without shank holder



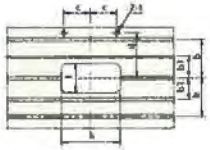
Dimension of Bolster Plate and Ram

The cushion pin holes of SN1-28,39,50,66, 220 are center located on bolster

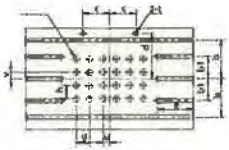
Surface of Bolster - Round Type (Shadow)



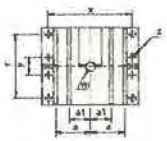
Surface of Bolster - Rectangular Type



Surface of Bolster - Die Cushion

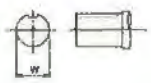


Surface of Ram



Size of T-Slot

Power Take-off Shaft Option



P.S.: The T-Slot on slide only for SN1-160 above

Blanking Press option: SN1-66

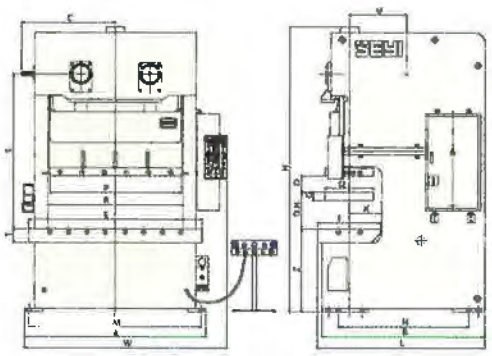
Model	SN1-28	SN1-39	SN1-50	SN1-66	SN1-88	SN1-121	SN1-176	SN1-220	SN1-275
a	4.13	5.12	5.51	5.91	6.30	7.09	10.24	11.81	13.78
a1	—	—	—	—	—	—	6.30	6.69	7.87
b	3.94	4.92	5.51	5.91	7.09	8.27	11.42	12.60	13.78
b1	—	—	—	—	—	—	6.50	7.09	7.87
c	5.12	5.12	5.91	5.91	5.91	5.91	7.87	7.87	9.84
d	5.31	6.69	7.28	7.87	9.84	11.81	13.39	14.96	16.14
e	—	8.27	8.66	9.45	10.63	11.02	11.42	12.60	12.60
f	Φ3.94	Φ4.33	Φ5.12	Φ5.91	Φ7.09	Φ7.87	Φ8.66	Φ9.84	Φ10.63
g	2.56	2.56	2.95	2.95	2.95	3.54	3.94	3.94	3.94
h	2.36	3.54	3.94	3.94	2.95	3.54	3.94	3.94	3.94
i(L.R.xF.B.)	5x3	5x3	5x3	5x3	6x4	6x4	6x4	7x5	8x6
j	Φ1.02	Φ1.02	Φ1.02	Φ1.02	Φ1.02	Φ1.26	Φ1.26	Φ1.26	Φ1.26
k	7.87	8.66	10.24	11.81	14.57	15.75	17.32	19.69	21.26
l	3.94	4.33	5.12	5.91	7.09	7.87	8.66	9.84	10.63
m	Φ1.50	Φ2	Φ2	Φ2	Φ2	Φ2	Φ2.56	Φ2.56	Φ2.56
n	0.87	0.87	0.87	0.87	1.10	1.10	1.10	1.10	1.10
p	0.91	0.91	0.91	0.91	1.18	1.18	1.18	1.18	1.18
q	0.63	0.63	0.63	0.63	0.79	0.79	0.79	0.79	0.79
r	—	—	—	—	—	—	18.90	21.65	24.41
s	1.50	1.50	1.50	1.50	1.89	1.89	1.89	1.89	1.89
t	Φ0.87	Φ1.02	Φ1.02	Φ1.18	Φ1.18	Φ1.18	Φ1.18	Φ1.18	Φ1.18
u	0	0	0	0	1.48	1.77	1.97	0	0
w	Φ1.38 -0 -0.001	Φ1.38 -0 -0.001	Φ1.57 -0 -0.001	Φ1.57 -0 -0.001	Φ1.57 -0 -0.001	Φ2.76 -0 -0.001	Φ2.76 -0 -0.001	Φ2.76 -0 -0.001	Φ2.76 -0 -0.001
x	11.42	13.39	14.57	15.75	18.90	22.05	24.80	29.53	33.46
y	2.76	2.76	3.15	3.54	3.54	3.94	5.12	5.51	6.30
z	4-Φ0.71	4-Φ0.71	4-Φ0.71	4-Φ0.71	4-Φ0.71	4-Φ0.91	4-Φ0.91	4-Φ0.91	4-Φ0.91

※ This specification is subject to change without notice.

SN2 SERIES

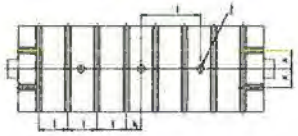
Model		SN2-121		SN2-176		SN2-220		SN2-275		SN2-330	
Type		S	H	S	H	S	H	S	H	S	H
Tonnage Capacity	U.S. Ton	121		176		220		275		330	
Stroke Length (St)	in	7.09	4.33	7.87	5.12	9.06	5.91	9.84	7.09	11.02	7.09
Stroke per Minute (Fixed speed)	S.P.M.	50	70	40	60	35	50	30	45	30	45
Stroke per Minute (Variable speed)	S.P.M.	35~65	45~90	30~60	35~75	25~50	30~60	22~45	30~50	20~35	30~50
Tonnage Rating Point	in	0.20		0.24		0.28		0.28		0.28	
Die Height (D,H)	in	15.75	13.78	17.72	15.75	19.69	17.72	21.65	17.72	21.65	17.72
Slide Adjustment (G)	in	3.54		3.94		4.33		4.72		4.72	
Slide Area (PxQ)	in x in	56.30x20.47		61.42x22.83		72.83x25.59		82.68x27.56		82.68x31.50	
Diameter of Shank Hole	in	Φ2.01		Φ2.01		Φ2.01		Φ2.01		Φ2.01	
Bolster Area (ExF)	in x in	74.02x26.77		80.31x29.92		95.28x33.07		106.30x36.22		106.30x37.01	
Bolster Thickness (T)	in	5.91		6.30		6.69		7.09		7.87	
Bolster Height (Z)	in	35.43		37.40		39.37		43.31		43.31	
Frame - Inside Distance (R)	in	57.87		62.60		75.98		86.22		85.83	
Frame - Gap Distance (Q)	in	13.78		15.35		16.93		18.50		18.90	
PTO. Shaft Position (CxSxU)	in x in x in	39.57x66.34x24.21	39.57x62.99x24.21	42.72x73.03x25.98	42.72x69.60x25.98	49.61x82.95x27.95	49.61x79.41x27.95	55.31x90.75x30.31	55.31x85.43x30.31	55.91x95.87x31.50	55.91x89.96x31.50
Main Motor	HPxP	10x4	15x4	20x4	20x4	20x4		30x4		30x4	
Motor of Slide Adjustment	HPxP	1x4		2x4		2x4		3x4		3x4	
Foot Print (AxB)	in	77.17x69.29	77.17x67.13	85.43x79.92	85.43x77.56	99.21x85.24	99.21x83.27	110.63x97.24	110.63x94.29	111.81x101.18	111.81x97.24
Position of Anchor Bolt(MxN)	in x in	73.23x55.51	73.23x53.35	80.71x67.60	80.71x60.24	94.49x67.91	94.49x65.94	105.91x77.56	105.91x74.61	107.09x80.12	107.09x76.18
Required Floor Space(WxLxH)	in x in x in	86.22x71.26	86.22x71.26	93.50x82.09	93.50x82.09	107.28x87.80	107.28x87.80	118.70x99.61	118.70x99.61	119.88x102.36	119.88x102.36
Press Height(w/o Mount)(H)	in	122.44	119.09	133.07	129.72	148.03	144.49	163.39	158.07	172.44	166.54
Required Air Pressure	PSI	71		71		71		71		71	
Die Cushion (Option)											
Capacity (at 5kg/cm²)	U.S. Ton	6.6x2		8.8x2		11x2		15.4x2		15.4x2	
Stroke Length	in	3.74		4.33		5.12		5.51		5.51	
Die Cushion Area(LRxFB)	in x in	18.90x13.39x2		22.05x14.57x2		27.56x17.72x2		27.56x17.72x2		27.56x17.72x2	

Machine Dimension

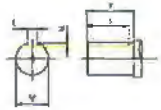


Dimension of Bolster and Slide

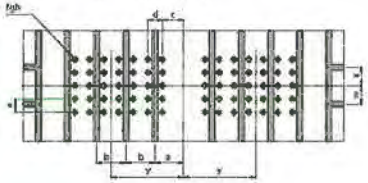
Surface of Slide



Power Take-off Shaft



Surface of Bolster



Size of T Slot

Model	SN2-121	SN2-176	SN2-220	SN2-275	SN2-330
a	4.33	7.87	8.46	9.25	9.25
b	7.87	7.87	8.66	8.66	8.66
c	6.30	5.91	6.30	7.09	7.09
d	3.94	3.94	4.33	4.33	4.33
e	3.94	3.94	3.94	3.94	3.94
f(L,R,F,B)	5x4x2	6x4x2	7x5x2	7x5x2	7x5x2
g	Φ1.26	Φ1.26	Φ1.26	Φ1.26	Φ1.26
h	Φ1.57	Φ1.57	Φ1.57	Φ1.57	Φ1.57
i	13.78	15.75	17.72	17.72	17.72
j	Φ2.01	Φ2.01	Φ2.01	Φ2.01	Φ2.01
k	4.72	0	4.33	4.72	4.72
l	9.45	7.87	8.66	9.45	9.45
m	1.10	1.10	1.10	1.10	1.10
n	1.18	1.18	1.18	1.18	1.18
p	0.79	0.79	0.79	0.79	0.79
q	1.89	1.89	1.89	1.89	1.89
r	3.94	3.94	3.94	3.94	3.94
s	3.54	3.54	3.54	3.54	3.54
t	0.79	0.79	0.79	0.79	0.79
u	0.30	0.30	0.30	0.30	0.30
v	Φ2.76 -0 / -0.001	Φ2.76 -0 / -0.001	Φ2.76 -0 / -0.001	Φ2.76 -0 / -0.001	Φ2.76 -0 / -0.001
x	4.53	4.92	5.51	5.91	5.91
y	14.17	15.75	19.29	20.08	20.08

※ This specifications is subject to change without notice.