



सीएसआईआर-केंद्रीय खाद्य प्रौद्योगिक अनुसंधान संस्थान
CSIR- CENTRAL FOOD TECHNOLOGICAL RESEARCH INSTITUTE
मैसूरु / MYSURU-570 020, भारत / INDIA

(Constituent Laboratory of CSIR, New Delhi (Ministry of Science & Technology)
An ISO 9001:2008, ISO 14001:2004 & ISO 17025:2005, NABL Accredited Laboratory

Corrigendum: Tender for Biscuit Line

Corrigendum Title: Revised Technical Specification

Tender Ref: CFTRI/74190/20-21 Date: 29-05- 2020

Tender ID: 2020_CSIR_49284_1

The revised final specification based on the discussion in Pre Bid Conference held on 10-06-2020 @ 11.30A.M. at Purchase Committee Room, CSIR-CFTRI Mysuru through Video Conference enabling equal opportunity to all OEMs has been incorporated and given below as revised specification to the original tender specification. All bidders are requested to take cognizance of the revised specification and submit their bids accordingly on or before 02.00 p.m. on 01/July/2020.

The Firms who has already submitted their offer may resubmit their offer as per our revised final technical specification.

All other tender terms and conditions remain unaltered except delivery schedule date i.e. 10-12 weeks from the date of issue of P.O (instead of 6-8 weeks as mentioned in our initial tender terms & conditions).

Revised Technical Specifications for Biscuit Making Line Based on PBC

Plant consisting of

- 1) Dough mixer
- 2) Travelling baking oven
- 3) Rotary moulding machine

Production capacity: 10-15 Kg biscuits/ hour

1. Dough Mixer- double arm horizontal sigma mixer

Capacity Max	: 10-15 Kg Dough basis
Mixing Arm speed	: 10- 60 RPM (3 variable speeds)
Bowl Tilting	: Powered tilting arrangement with Geared Motor of suitable capacity
Door	: Counter Balanced Safety Switch
Drive	: Geared Motor (matching capacities) Coupled to Mixing Arm
Arm Rotation	: Mixing arms rotation in opposite directions for better mixing.
Operating Panel	: Reverse, Forward, Emergency Switch, Digital Timer and all other controls fitted in the Front side of the panel

M.O.C.: All contact parts AISI304.

Main frames - MS & powder coated

2. Electric Biscuit Baking Traveling Oven (3 Chambers) with suitable cooling conveyor

Oven Band Size	: Width 200-240 mm, Length 4500-5000mm
No of Lines on Baking Band	: 3-4 Lines
Cooling Conveyor	: 3000-4000mm length with PU Endless Belt
Heating Control	: Separate Heaters for 3 chambers with independent Digital temperature control.
Maximum Temperature	: 350°C.
Drive	: Geared Motor with variable speed.

Exhaust Blower : Suitable exhaust blower with Open/Close Dampners

Conveyor cleaning : Brush with Pressure Adjustment

Type of Conveyor : Wire Band with Tensioner

M.O.C

1. All Outer contact area of AISI 304 Grade
2. Main frames Fabricated of M S Angles & Channels & Spray Painted with high temperature resistance Paint.
3. Wire Band - Spring steel/ High Carbon steel

Others:

1. Hoods at both the Ends of the oven for max Heat Suction.
2. Insulation: All the Four Sides of the OVEN (top, bottom, 2 Sides) with ceramic blanket / mineral wool reinforced to eliminate Heat loss
3. Chimneys for all 3 Zones (Charging, Middle, and Discharging End) with Shutters for (Half Open /open / Close) and suitable ducting (5-8 metres) to vent out all the exhaust fumes.
4. OVEN should have separate control panel consisting of Drives MCBs, Contactors, Relays Cable Connectors, Digital Temp Control, Off Push Buttons, Speed regulators etc.

3. Rotary Moulding Machine

Forcing Roller : Dia 164-200mm Width Fluted Roller with Rev- Fwd Movement adjustments

Die Roller (3 nos;

2 rectangle, 1 circular) : Dia 200- 240mm, M.O.C: Gun-metal, customized design engraved as per CFTRI specification

Rubber Roller : Suitable size made of natural rubber lagged to the roller surface with up & Down Pressure Adjustments

Cover : Made out of Stainless Steel 304 grade with doors, for quick access and easy maintenance

Adjustable Scrapper Knife : To be Provided for Uniform Scraping of the Dough

Web Tightner : All the Webs with suitable Manual Tensioner & Web Tracking facility attached.

Hopper : AISI 304 Grade

Drive : Geared Motor with V.F.D

Easy Transfer of biscuit from Mould to Oven Band

M.O.C

1. All the Dough Contact Area will be of AISI 304 Grade Steel Fabricated
2. All Outer contact area will be of SS-304 Grade
3. Main frames Fabricated of M S Angles & Channels Powder Coated

Others:

1. Web Drive Roller: Knurled Rollers with full End to End Shafts.
2. All the Conveyor Webs with Manual Web Tensioner & web Tracking Units
3. All transfer Knives should have nose head for easy transfer.
4. Service panel fitted with all electric & electronic accessories -V.F.Drives, MCB, Relays etc

NOTE: Equipment to be fabricated with GMP guidelines. Easy-to-assemble system for easy access, repair and maintenance. Footprint of the entire line including utility requirements such as power supply, civil work & site requirements to be provided