GA BIDS AND AWARDS COMMITTEE

Supplemental Bulletin Nr GA-BAC-TDBA-19-01
Procurement of Tools and Dies for M855 Bullet Assembly
GA-BAC-2018C-IA-24
02 May 2019

1. This is to inform all prospective bidders for the Procurement of Tools and Dies for M855 Bullet Assembly for the amendments on the drawings.

2. Bidders are hereby instructed to use the attached Revised Technical Specifications (page 71), Revised Bid (page 76) and the transcribed drawings during the submission and opening of bids.

3. Please be guided accordingly.

MS. TERESITA L. VITUG
Chairperson, Bids & Awards Committee
## TECHNICAL SPECIFICATIONS
*(Revised)*

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Signature Over Printed Name of the Bidder

71
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ϕ15.875 +0.005 -0.000

ϕ0.50 X 45.0°

ϕ0.50 +0.025 -0.000

ϕ0.00752[A]

ϕ5.00 × 67.15 DRILL & REAM

ϕ5.95 +0.05 -0.00 BETWEEN VITUAL SHARPS

ϕ8.00 ±0.13

ϕ15.0°

DETAIL Y SCALE 7 : 1

STEEL, M2 / 58-60 HRC [UNDERHARDEN]

DRAWN
JD BALDWIN, BSIT

DATE: APR. 24, 2019

DESIGNED

CHECKED
ENGR. SKP AGUILO, ChE

DATE: APRIL 24, 2019

Recommend Approval:
ENGR. DENNIS DE CHUA, ME

DATE: 04/25/19

Approved by:
DANIEL R. CASABAR JR
DIRECTOR

GOVERNMENT ARSENAL
Republic Of The Philippines
Department of National Defense
Camp General Antonio Luna
Lamao, Limay, Bataan

Scale: 1 : 1
Dimension: mm

TITLE: BOAT TAIL PUNCH
STATION # 14
5.56mm M855 BULLET ASSEMBLY MACHINE
Dwg. No. AM855T2-14a
Sh. No. 1/1
DRILL AND TAP
1/4-20 UNC ¥ 31.75

Ø15.87 +0.005 -0.000

R1.00

R12.70

44.45

60.36

136.57

4.80 +0.051 -0.000

0.00762 [A]

Ø4.80

0.50

8

DETAIL E
SCALE 10 : 1

TRANSCRIBED FROM WBF DWG. NO. 9612-19-1510

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PUNCH

STEEL M2 / 58-60 HRC [UNDERHARDEN]

DRAWN: JD BALUYT, BSIT
DESIGNED
CHECKED: ENGR. SK. RAGUO, ChE

Republic Of The Philippines
Department of National Defense

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lammao, Limay, Bataan

Scale: 1 : 1
Dimension: mm

TITLE: 1ST SIZING PUNCH
STATION #15
5.56mm M855 BULLET ASSEMBLY MACHINE

Dwg. No. AM855T2-15a
Sht.No. Of

Recommend Approval: ENGR. DENNIS DE CHUA, ME

Approved by: DANIEL R CASABAR JR
DIRECTOR

Date: APR. 24, 2019
Date: April 24, 2019
Date: 04/25/19
Date:

REFERENCE
APPLY GEN. TOLERANCE TO UNSPECIFIED TOLERANCES

> 0 TO 4
> 6 TO 30
> 30 TO 120
> 120 TO 315
> 315 TO 1000

¥ 0.1
¥ 0.2
¥ 0.3
¥ 0.5
¥ 0.8
**DIE INSERT**

**DIE CASING**

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<td>H13 STEEL / 46 ~ 48 HRC</td>
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**DRAWN**
JD BALUYOT, B.S. IT

**DESIGNED**

**CHECKED**
ENGR. SK. PABUJO, CH.E

**Recommend Approval:**
ENGR. DENNIS DE ELA, ME

**Approved by:**
DANIEL R CASABAN JR
DIRECTOR

---

**GOVERNMENT ARSENAL**
Camp General Antonio Luna
Lamao, Limay, Bataan

**Scale:** 4:1

**Dimension:** mm

**Dwg. No.:** AM655T2-15c

**Sht. No.:** 1

**Title:**
1ST SIZING LOWER DIE
STATION # 15
5.56mm M855 BULLET ASSEMBLY MACHINE

**TRANSCRIBED FROM WBF DWG. NO. 9612-19-1551**
DRILL AND TAP
1/4-20 UNC ¥ 31.75

Ø15.87 +0.005 -0.000

R1.00

R1.00

Ø4.80 +0.051 -0.000

Ø4.80 -0.000

Ø0.00762A

DETAIL F
SCALE 8:1

PUNCH
STEEL M2 / 58-60 HRC [UNDERHARDEN]

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DRAWN
JD BADINGST, BSIT
Date: APR. 24, 2019

DESIGNED

CHECKED
ENGR. SK. PAGUIO, ChE
Date: Apr. 24, 2019

Recommend Approval:
ENGR. DENNIS DS CHUA, ME
Date: 04/25/19

Approved by:
DANIEL R CASABAR JR

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamao, Limay, Bataan

Republic Of The Philippines
Department of National Defense

Scale: 1:1
Dimension: mm
Dwg. No. AM855T2-17a
Sht. No.

TITLE:
2ND SIZING PUNCH
STATION #17
5.56mm M855 BULLET ASSEMBLY MACHINE
DIE INSERT

1

DIE CASING

1

QUANTITY DESCRIPTION PART NO. MATERIAL HARDNESS

DIE INSERT 2 GC209 / 90.5 - 92 HRA

DIE CASING 1 H-13 STEEL / 46 - 48 HRC

DRAWN

JD BALLO, PT. BSIT

DESIGNED

CHECKED

ENGR. SK. PABUIO, Ch.E

RECOMMEND APPROVAL:

ENGR. DENNIS DE CHUA, ME

APPROVED BY:

DANIEL R. CASABAR JR.

Date: APR. 24, 2018

Date: APR. 24, 2019

Date: 04/25/19

GOVERNMENT ARSENAL

Republic Of The Philippines
Department of National Defense

Camp General Antonio Luna
Lamao, Limay, Bataan

SCALE: 3 : 1

DIMENSION:

Dwg. No.

AM805T2-17b

Sh. No.

1

Of

G2ND SIZING DIE GUIDE

STATION # 17

5.56mm M855 BULLET ASSEMBLY MACHINE
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| t0.1 | t0.2 | t0.3 | t0.5 | t0.8 |

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**Diagram:**

- Ø44.42 +0.01 -0.00
- Ø19.05
- Ø5.56 +0.01 -0.00
- R1.00
- SMOOTH THE ANGLE

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**TRANSCRIBED FROM WBF DWG. NO. 9612-19-1751**

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**Drawn by:**

JD BAJUYOT, BSIT

Date: APR. 24, 2019

**Designed by:**

ENGR. DENNIS DS CHUA, ME

Date: April 24, 2019

**Checked by:**

ENGR. SK PASQUIO, CHe

Date: April 24, 2019

**Recommended by:**

ENGR. RVEST C. CASTELLANOS, ME

Date: 04/23/19

**Approved by:**

DANIEL R. CASASBAR JR

Date: 

**Republic of the Philippines**

Department of National Defense

**GOVERNMENT ARSENAL**

Camp General Antonio Luna
Lamao, Limay, Bataan

**Scale:**

3 : 1

**Dimension:**

mm

**Dwg. No.:** AM855T2-17c

**Sh. No.:** 1

**PROJECT:**

2ND SIZING LOWER DIE
STATION # 17

**TITLE:**

5.56mm M855 BULLET ASSEMBLY MACHINE