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Planning

## Supply of Escalator Steps (Fabricated and Die-Cast)

Transport for London

UK2: Preliminary market engagement notice - Procurement Act 2023 - [view information about notice types](#)

Notice identifier: 2025/S 000-041586

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Published 21 July 2025, 12:00pm

### Scope

### Description

In the last decades the vast majority of the world of escalator steps production has been migrating to die casting. TfL's present die-cast step fleet is at 43%. The introduction of die-cast steps has been primarily through our main escalator contractors during escalator replacement or refurbishment works. TfL are looking to accelerate the percentage of the step fleet which is die-cast by proactively replacing fabricated steps on our internally maintained legacy fleet with interchangeable die-cast steps.

The MH-B step is deemed to be the most appropriate candidate to begin the conversion: today more than 18,000 MH-B steps are installed in MH-B, MY-A, and MH-A Otis escalators. Their replacement is intended to contribute by 21% to the whole fleet conversion.

The scope of the contract is summarised below:

1. Desktop study
  - a. Design of Escalator Steps to meet specification
  - b. Finite Element Analysis (FEA) of step to meet load cases in specs

c. Feasibility of mould design to verify that the step geometry be achieved within constraints of moulding technology available

## 2. Die Cast Moulding

a. Mould Design

b. Manufacture of mould

c. Prototype testing and quality assurance against BS EN 115 and SPC-LAE-421479903

## 3. Manufacturing of Escalator Steps

a. Ability to die-cast steps

b. Minimum production runs per order

c. Number of shots for life of mould

## 4. Delivery and Storage of Escalator Step

a. Typical lead time

b. UK storage

A first study for the new die cast design has been performed (drawing 564-12031 Rev.A) and the set of requirements for the step supply has been collected in the SPC-LAE-421479903.

The Contractor will be asked to follow the SPC document as a technical reference.

### **Contract dates (estimated)**

- 1 January 2027 to 1 January 2037
- 10 years, 1 day

### **Main procurement category**

Goods

## **CPV classifications**

- 44000000 - Construction structures and materials; auxiliary products to construction (except electric apparatus)

## **Contract locations**

- UKI - London

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## **Engagement**

### **Engagement deadline**

15 August 2025

### **Engagement process description**

As part of this market sounding exercise, TfL wishes to seek your views on the extent of your capabilities and appetite for TfL MH-B Die-Cast Step Supply Contract.

TfL would appreciate your feedback in the form of a response to a questionnaire, with the specific questions to be answered in the blank tables/boxes provided. Should you consider a particular question is not applicable to your organisation, please state "not applicable" in the tables/boxes provided. There is no limit to the amount of feedback that can be provided.

Please email [RfLProcurement@tfl.gov.uk](mailto:RfLProcurement@tfl.gov.uk) if you are interested in completing this questionnaire.

Structure:

The questionnaire covers the Design Desktop Study, the Quality Assurance, and the Mould Manufacturing for an Escalator Die Cast Step. Whilst it is understood that some suppliers operate their business providing all the services, some may not, and we may adopt different strategies for the different services. If you provide services relating only to one of these types, please advise in your response to this MSQ.

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## **Participation**

### **Particular suitability**

Small and medium-sized enterprises (SME)

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## **Procedure**

### **Special regime**

Utilities

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## **Contracting authority**

### **Transport for London**

- Public Procurement Organisation Number: PHMT-6197-NWNZ

5 Endeavour Square

London

E20 1JN

United Kingdom

Email: [RfLProcurement@tfl.gov.uk](mailto:RfLProcurement@tfl.gov.uk)

Region: UKI41 - Hackney and Newham

Organisation type: Public authority - central government