

Manufacturing and Delivery Specifications for Design-Specific Parts

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Changes

Compared with DSE240332 Äi 00 the following changes were made:

- a) Chapter 2.3.2 Alternative made of galvanized sheet inserted
- b) Chapter 2.5 Passivation standard changed to current state of standardization

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1 General

The delivery specifications are valid for suppliers of design-specific parts unless stated otherwise in the order.

2 Delivery Specifications

2.1 Separate Packaging

All parts must be bundled and packed separately per order and order item. If a delivery contains several orders/purchase orders, they must be packed separately.

2.2 Labeling

- All parts must be labeled per order item in a clearly visible way with the corresponding Dieffenbacher bar code labels.
- The label must not be affixed directly on parts with final paint coating.

2.3 Preservation

2.3.1 Turned and milled parts

Turned and milled parts (except corrosion-resistant parts) must be preserved using oil unless specified otherwise in the respective drawing.

2.3.2 Sheet metal and welded parts (except corrosion-resistant parts)

- which are **larger** than a Euro pallet are to be preserved with zinc dust paint, or have to be supplied alternatively in galvanized steel sheet.
The alternative made of galvanized steel sheet is subject to the following conditions:
Specified basic material:
EN 10025-2 1.0038 (S235JR), EN 10111 1.0332 (DD01), EN 10130 1.0330 (DC01)
Supplied basic material:
EN 10152 1.0330+ZE (DC01+ZE)
Sheet strength: $\leq 3\text{mm}$
- which are **smaller** than a Euro pallet are to be preserved using oil unless specified otherwise in the respective drawing.

2.4 Priming and Lacquering of Units with Inside Thread

The threads of units with inside threads (e.g. welding brackets) must be coated with oil prior to priming and lacquering and sealed with a flangeless plug unless stated otherwise in the respective order.

(Example: Essentra Components, SR 1034, flangeless plugs)



2.5 Passivation

All parts to be passivated must generally be passivated in accordance with ISO 2081-Fe/Zn 8 B, unless stated otherwise in the respective order/drawing

2.6 Associated Documents to be Included (drawings, test reports, certificates of compliance, etc.) Delivery to Dieffenbacher Sites

Associated documents to be included in the delivery must be included with the delivery note and must **not** be included with the parts! The documents must be attached on the outside (but in such a way that they cannot be read).

2.6.1 Delivery to sites other than Dieffenbacher sites (e.g. clients, transshipment terminals, construction sites, other third-parties)

Associated documents must be sent to the respective buyer and must **not** be included with the delivery/goods!

2.7 Test Reports

Check dimensions and other dimensions subject to documentation (obligation) indicated in the drawing must be documented in the test report and included with the respective delivery note. Additional dimensions to be documented are indicated in the text of the respective order.

2.8 Check of the Revision Index of drawings by the supplier

With regard to orders from Dieffenbacher, the supplier is obligated to responsibly check before planning and production start that the revision index indicated in the purchase order corresponds to the one indicated on the drawing. This also applies to recurrent parts if the supplier already has the drawings and Dieffenbacher did not send a new one. The supplier is liable to manufacture the parts according to the revision index indicated on the purchase order.

In case of deviations the responsible buyer at Dieffenbacher must be contacted **prior to manufacture of the parts** and if necessary the drawings with the correct revision index have to be requested.

3 Other Applicable Documents

WN 11-08-32	Design dimensions, threads, counterbores etc. have to be designed according to company standard
DSE110831	Center holes form R + D have to be designed according to company standard
WN 92-75-17	Corrosion protection by means of Extrium zinc dust paint grey matt EPE and similar RAL 7001; technical details have to be taken from the company standard
DG927529	Preservation specifications; unless otherwise stated in the order, the company standard must be observed.

The supplier is obliged to obtain knowledge of the applicable documents.