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This special quality agreement applies as a supplement to the general quality agreement.

1. Markings for identification purposes

The following markings must be cast into the casting so that they are readily legible:

- Pattern No. acc. to drawing regulations
 - Casting date
 - Supplier's code
- } - unless otherwise specified,
 } in the area of the pattern No.

In the case of heat-cured aluminium castings the marking "T6" (formerly "wa") must be cast after the pattern No.

The markings are to be provided on a surface of the casting which will not be machined.

2. Requirements placed on the condition of the castings:

- Cast cleanly.
- Gates and feeders must be removed.
- Well cleaned and deburred.
- Sandblasted.
- Absolutely oil-tight.
- There must be no blowholes, cavities or cracks.
- External surfaces which are no longer machined must be cleaned in line with the contours.
- The inside of the castings must be free from sand spots and material deposits, e.g. scab, finning or vitrification.
- There must be no sand spots, material deposits or residue of blasting grit under the primer.
- Repair welding is prohibited. A request for special release is permitted in individual cases.

3. Primer regulations

If the castings have been ordered as "primed", they must have a complete prime coat on the inside and outside.

Unless a specific primer is required, it must meet the following requirements:

Recoatibility

With conventional rust-inhibiting, industrial and consumer paints. After final drying with nitrocellulose, 2-pack epoxy and 2-pack polyurethane paints.

Resistance

Against mineral gear oil (e.g. CLP 220, DN 51517) at approx. 120°C.

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4. Initial sample

Sample castings are to be supplied unprimed, when specifically agreed otherwise.

Korrosion protection: packed in VCI foil or sprayed with Hakudren (Kluthe).

Identification of sample delivery, by notation on the delivery note and marking the goods with a label or tag plate "initial sample" is mandatory.

Test certificates

Initial samples must be supplied along with following test reports:

- Test record (dimensional check)
- Inspection certificate 3.1 (material)

The Stiebel Order No. must be listed on each document.

Pattern transfer

When the pattern was provided by Stiebel, the supplier bears the responsibility for the quality of the castings in accordance with specifications. The supplier first assess the suitability of the pattern for the production, assessed internal samples and provides the initial sample together with the test reports to Stiebel.

5. Machinability

To improve machinability, the following are stipulated for the Brinell hardness in the area of surfaces to be machined:

for	grey cast iron GG – 20	200 HB +/- 20 HB 30
	grey cast iron GG – 25	220 HB +/- 20 HB 30

6. General casting tolerances

Unless there are details on the general casting tolerance in the technical documents, the accuracy degree GTB 16 to DIN 1680 shall apply.

7. Pattern equipment

Lettering

Unless otherwise agreed, the characters, letters and numbers necessary to identify the castings shall be provided on the pattern or in the core box on a surface of the casting which will not be machined.

Storage and obligation to keep safe

Proper storage must be guaranteed as this and the service life have a major influence on the re-usability of the pattern equipment.

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Patterns including core boxes, additional equipment and negative moulds are the property of Stiebel. They are subject to the obligation to keep them safe and are to be protected in particular against destruction by moisture and fire.

Patterns to be scrapped always require our written approval.

Maintenance

The pattern equipment is to be examined during and after every use for its condition of wear so that maintenance work can be performed in good time or, if necessary, new equipment provided.

Any costs which the purchaser may incur shall be reported prior to the start of the maintenance work by means of a cost estimate.

Delivery notes and invoices for pattern equipment

The pattern, every relevant loose part and every relevant core box as well as negative moulds are to be indicated in full on the delivery note and the invoice.

.....
 (Place, date)

.....
 STIEBEL-GETRIEBEBAU GmbH&CoKG

.....
 (Supplier)