

Anocote Ltd CR o.s. parts processing notes

The surface coating FIZn applied in Anocote limited CR are corresponding with CSN EN ISO 10683 and CSN EN 13858. Fastener parts larger than or equal to M6 are recommended for FIZn finishes. Smaller parts are not suitable for this type of coating and sample processing is recommended here to agree on production possibilities.

Please note the number of our price offer on your order!

All prices are without VAT.

An integral part of this offer are the terms and conditions (Conditions of sale) attached to this offer. By accepting this offer, as well as the customer accept these terms and conditions.

Delivery conditions are FCA Incoterms 2010 Hradec Kralové. Term of payment - Nett Monthly. Minimum order charge for coatings is 70 EUR per PO position (Dip Spin even Spray technology) and 115 EUR per PO position for thread locking and sealing patch.

Prices are valid for the material delivered in large quantities in the boxes which allow for passage through the entire production process by forklift. Upon delivery of goods in small paper cartons boxes or unsuitable metal or plastic boxes packing will be charged, which is not included in the standard Price offer or Price list. Parts processed by Spray technology are standardly interlaced on the floors with paper liners. The free space between the parts is not filled and no other protective material than paper horizontal spacers is used. This package is included in the price of the surface treatment. According to the packing instructions and mutual agreement, it is possible to pack the parts individually. Work or costs for the material associated with this may be charged to the customer. The customer is obliged to specify the packaging prescription together with the order for parts running on Spray technology. If the packaging prescription is not delivered, the parts will be packed with the basic variant - a paper liner, which will not fully prevent damage to the parts and the surface finish. If Anocote Ltd. proposes a method of packaging that does not subsequently prevent damage, it is not Anocote Ltd. responsibility - the overall assessment of the packaging regulation (even in the context of next transport provided by the customer) is the customer's responsibility.

Additional costs will be charged even for overweight shipments or other specific cases. The price is subject to a trial batch and sampling of parts from that batch. We can then decide the plant capability and basket loading of the parts. The geometry of the parts will determine the basket loading and plant capability.

Trade allowance for wastage Quotations are give subject to the customary trade allowance for wastage maximum 5%. The percentage of such waste to vary according to the nature of the article. Contractor performs final inspection of the applied coating at random, and in accordance with the recommendations and according to paint producers manual.

Original finish time for surface coatings by Dip Spin method is 5 to 20 (according used colour of the paint and other requests) and for Spray method it is 5 to 20 working days (unless agreed otherwise). Until the time of processing, the day of delivery and shipment is not counted. Production deadlines may, in exceptional cases, be extended. Receiving and collection of goods is possible every working day since 6am to 3:30pm.

The delivery time for Thread Locking and Sealing is up to an individual agreement (common term is 10 - 15 working days).

In the case of a contract execution in urgent time, we may charge an express surcharge upon mutual agreement to the current price for the coating. The amount of the surcharge will reflect the real costs associated with the change of the production plan and possible extra costs.

Any Production Parts Approval Process (PPAP) documents required should be requested on your order. We reserve the right to remove five or more pieces for testing.

Prices are valid for fasteners that are supplied in the raw state without previous galvanic or other surface treatments. In the event that the parts supplied will already have a pre-applied finish, we will charge the price for its removal and at the same time such parts will be made without our warranty as Anocote Limited CR does not take responsibility for the products that have been pre-exposed to hydrogen brittleness (strength screws) or other inappropriate processes, or products with high contamination by mechanical impurities in the customer's containers and the parts exhibiting initial surface corrosion upon acceptance.

All coating processes we recommend make an initial sample testing procedure before mass production. In case of a request to produce parts with spraying there is always necessary to make samples before production. When sampling parts, it is necessary to take into account the removal of about 10 pieces for appropriate tests and archiving (only for manual spray technology, individual agreement is possible).

Before applying surface coating parts are shotblasted. Please note that the technology Dip Spin may cause fine thread damage and recess fill at ca 2,5% of parts (or even steel balls used during blasting) which may occur based upon part geometry. Dip Spin technology as well could cause bending of parts or their edgings. All flat parts (washers etc.) may stick together during the processing which may cause typical touch marks.

When using the spray method, the paint may not be applied to all the holes and internal threads. In the holes and internal threads could be steel balls used during blasting and also initial fills (e.g. oily substance). The thickness of the layer when using Spray technology can range from about 10-40 micrometers, depending on the characteristics of the part. So after surface treatment, it may be appropriate to re-thread the threads and holes. Therefore the required corrosion resistance is not guaranteed at the welding sites, holes and internal threads.

Anocote Ltd CR is also not responsible for parts sent for processing in unsuitable packaging (eg fragile paper boxes) or in packaging that does not take into account the increase in the volume of parts after packaging (eg after spray technology).

Corrosion resistance is guaranteed according to ČSN EN ISO 9227.

Some parts may be also lost or may be contaminated with other parts during process inside of the process line. It is difficult to avoid mentioned effects. For small orders around cca.100pcs may be a production loss of around 10% (up to 20% for extremely small and light parts). Here we recommend sending at least 5kg of parts for processing. For larger orders over 100 kg is a common manufacturing sacrificing cca.2, 5%.

We also recommend manufacturing the thread tolerance to 6e to get 6h after coating and maximum length of parts for processing by Dip Spin method is up to 240mm.

Screws with pre-applied adhesives are necessary to protect from humidity and store in dry indoor space. In other case there is no guarantee in preserving their right function and needed characteristic.

Storage conditions parts on which is applied:

precote

- air permeable containers
- max. storage temperature 30°C, max. relative air humidity 65%
- protection against rain and condensation

Scotchgrip

- range of temperature from 4°C to 38°C
- Fasteners which are more than one year from the date of adhesive application should be checked for performance prior to use.

Nylon Patches may not fully adhere to lubricated parts (surface finishing with lubricant). With such an order, the customer is obliged to notify the treatment containing the lubricant. If they fail to do so, Anocote Ltd will not be liable for any poor adhesion of Nylon Patches. It is always necessary to determine in order how the pre-applied adhesive should be applied. When applying thread locking on a non-metric thread, it is necessary to supply, together with the parts, corresponding counterparts for measuring the control torques, in the number according to the pieces supplied for processing - 20 (min.) - 50 pcs. For the sake of identification, the supplied counterparts must also be included in the order. If the counterparts are not delivered to Anocote Ltd does not guarantee the torques in the output certificate. If not agreed otherwise, the application of threaded locking systems, including the measurement of control torques, takes place in accordance with DIN 267. The control torques when applying the Nylon Patch in the 360° design may be higher compared to the specified standard (DIN 267-28). By placing an order for the Nylon Patch 360° application, the customer agrees to this. Control torques are always measured without preload. Anocote Ltd. CR o.s. does not measure torques with preload.

Follow the recommended guideline for installation speeds (RPM) apply only for reactive or non-reactive products (precote, Scotchgrip). M20 max. 100 RPM M12 max. 200 RPM M10 max. 300 RPM M3 - M8 max. 400 RPM The tightening torque should be at a maximum speed of 30U/min. and the feed rate in the axial direction should be as low as possible, recommended are 0 N.

Any tests at accredited laboratories are not included in this offer. We are not offering 100% inspection of parts. This is the reason why we can deliver some percentage of NOK parts.