

PRODAJNA SPECIFIKACIJA RONDELE

Sales Specif. No.: R200 000 000 050
Issue: 5
Valid since: 1.4.2011
Responsible: Godicelj Tomaz
Stran: 1/6

1. SHORT DESCRIPTION OF THE PRODUCT

Discs are suitable for the manufacture of cooking - vessels' bottom.

We manufacture round discs of various diameters (up to 225 mm) and various thicknesses (from 2 to 10 mm) by punching of cold rolling Al strips.

2. APPLICABLE DOCUMENTS

Purchase Specification L 526000000000

EN 573 - 3

EN 485 - 2

EN 570

EN 851

ISO 6506

ISO 2859/1

EN 10 204 - 3.1 B

3. QUALITY CHARACTERISTICS OF THE PRODUCT

3.1. Chemical composition values:

The chemical composition value for the quality 99,7 is carried out according to recipe L 526 153 xxxxxx and for the quality 99,5 according to recipe L 526 164 xxxxxx. The figures are shown in the table 1.

Table 1: Chemical composition value for discs according to recipe TALUM and EN 573 - 3.

Elements %	Chemical composition value			
	L 526 153 xxxxxx	EN AW-1070 A	L 526 164 xxxxxx	EN AW-1050 A
Al min.	99,70	99,70	99,50	99,50
Si	0,20	0,20	0,25	0,25
Fe	0,25	0,25	0,40	0,40
Mn	0,03	0,03	0,05	0,05
Mg	0,01	0,03	0,05	0,05
Cu	0,03	0,03	0,05	0,05
Ti	0,03	0,03	0,05	0,05
Zn	0,07	0,07	0,07	0,07
individual particles	0,01	0,03	0,01	0,03
total impurities	0,30	0,30	0,50	0,50

3.2. Mechanical characteristics

Table 2: Value of hardness for individual qualities according to EN 485 - 2 (2.4)

Material	State	Thickness mm	Hardness EN 485 - 2	HBS ¹⁾ TALUM	State of material
EN AW - 1070 A (99,7)	O/HIII	0,2-12,5	18	19	soft annealing
	H 24	0,2-12,5	31	40	cold rolling
EN AW - 1050 A (Al 99,5)	O/HIII	0,2-12,5	20	20	soft annealing
	H 24	0,2-12,5	33	40	cold rolling
1) for information only					

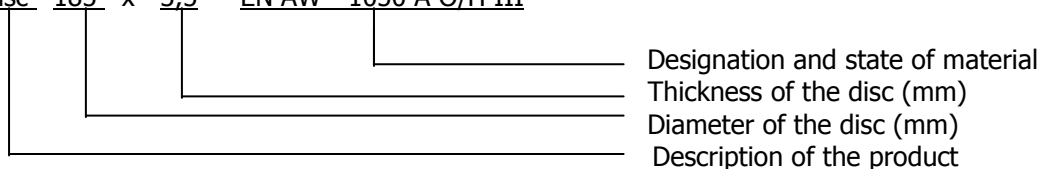
3.3 Shapes

We manufacture round discs with bosses or without, diameter up to 225 mm and thickness from 2,0 mm to 10,0 mm. Dimensions are defined individually for every type of the discs.

Discs with the bosses are produced in accordance with the drawing.

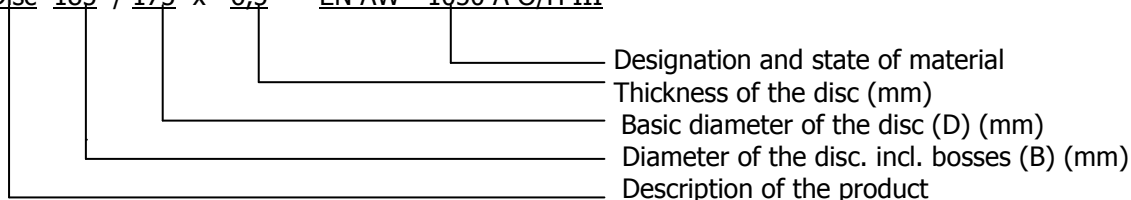
3.3.1 Standard designation in offers or orders

Disc 185 x 3,5 - EN AW - 1050 A O/H III

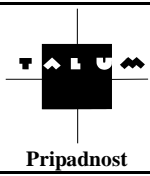


3.3.2 Designation of discs with bosses

Disc 185 / 175 x 6,5 - EN AW - 1050 A O/H III



An example of disc with bosses is shown on Figure 1. Drawing is required together with 1st order.

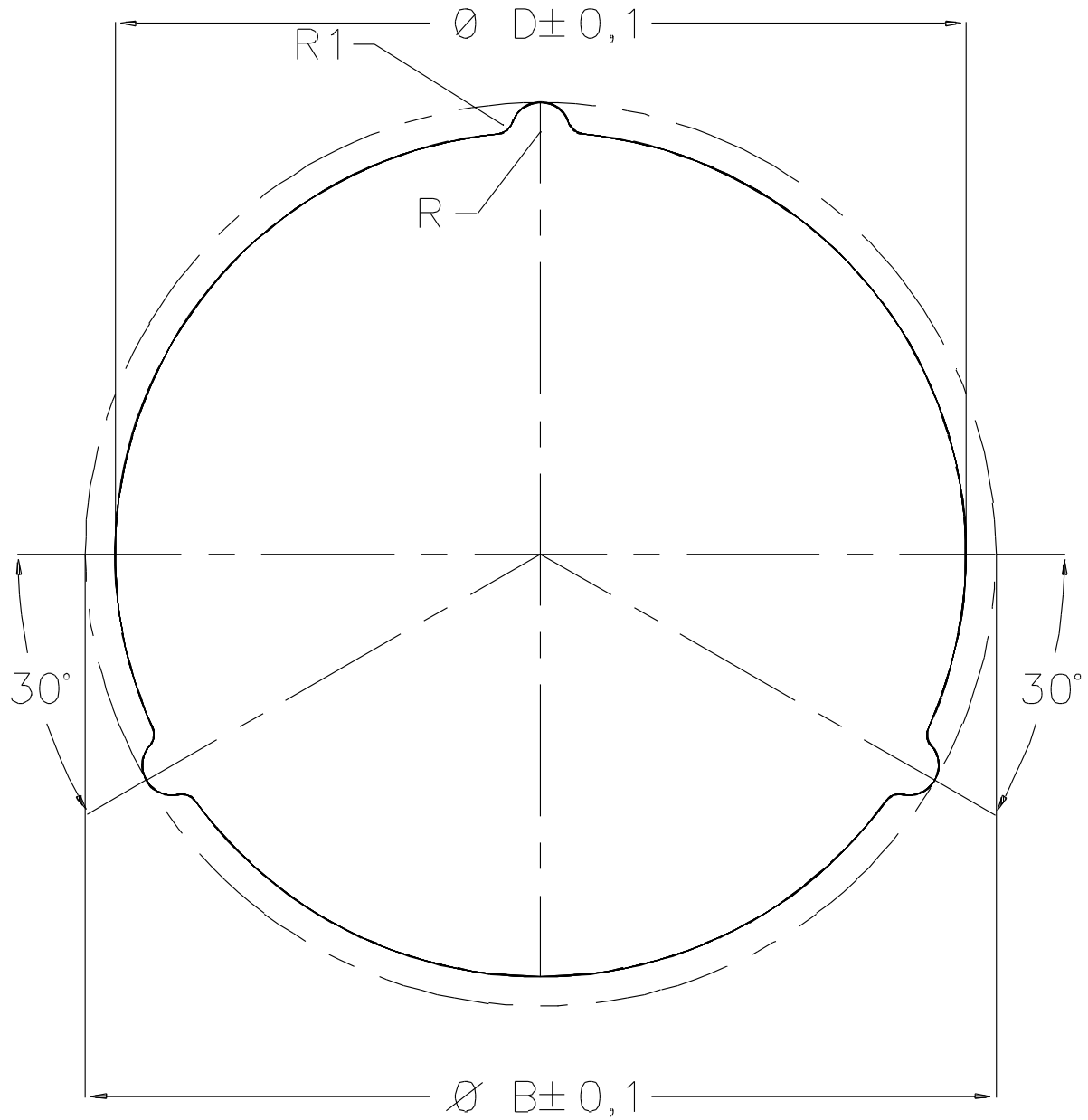


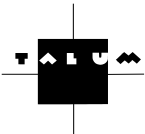
Pripadnost

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Picture 1



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3.3.3. Dimension tolerances

are defined in tables 3 - 5:

Table 3: Tolerance on diameter of round disc Table 4: Tolerance on diameter of disc with bosses after punching

Disc diameter (mm)		Tolerance (mm)
from	to	
D > 50	⊕ 225	±0,1

Diameter (mm)		Tolerance (mm)
from	to	
B > 55	⊕ 230	± 0,1
D > 50	⊕ 225	± 0,1

Table 5: Thickness tolerance of disc after punching

Thickness (mm)		Tolerance (mm)
from	to	
> 2,0	⊕ 6,5	± 0,05
> 6,5	⊕ 8,5	± 0,07
> 8,5	⊕ 10,5	± 0,10

3.4. Surface finish

The surface of the disc is clean, without oil spots and large scratches. Burr on the cut edge shall not exceed 0,3 mm.

Packing and despatch of aluminium discs is carried out as follows.

4.1. Packing

The packing of discs is implemented on standard pallets (drawing no. Ae 202691) with dimensions 1.200 x 800 x 134 (mm) and each is limited to approximately 900 kg net of packed discs.

The packing procedure is as follows:

- after being sorted the discs are placed in piles on the pallet.
- the piles in height of about 165 mm are spread over the total surface of the pallet. On the top of first layer we place second layer of piles and such method is repeated until the height of about 500 mm is reached. The last pallet from the order could be lower or higher.
- depending on the diameter of the disc the number of piles is limited to the dimension of the pallet.
- individual piles are separate and covered with cardboard including the bottom, top and outside walls of the packing.
- the pallet is wrapped up and protected with shrink foil.

Table 6: Packing material used for standard packing of discs

Packing material	standard packing
Pallet (mm)	1200 x 800 x 134
Cardboard	yes
Pallet height (mm)	≈ 650
Net weight (kg)	≈ 850
Pallet is wrapped up with shrink foil	yes
Pallet covered with PVC foil	yes

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4.2. Marking

The packed pallet is marked and labelled on the front side. The table includes data visible in the table 7.

Table 7: The data on the label

	standard marking
name of manufacturer	Yes
Packing date	Yes
name of buyer	Yes
article number(from buyer)	No
order number(from buyer)	Yes
Talum order number (number of work order)	Yes
Quality	Yes
cast number	Yes
dimension	Yes
pallet number	Yes
net weight(kg)	Yes
number of pieces	Yes
gross weight(kg)	No
In the case that the buyer does not submit certain data, the area is left empty.	

4.3 Quality documents

The manufacturer guarantees that every consignment is made in accordance with the demands of the buyer. Other than the usual transport documents every shipment leaving the factory is accompanied by a "Quality certificate".

5. QUALITY CRITERIA

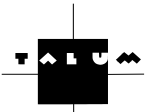
- a) the quality of the discs is guaranteeing in accordance with the quality system of ISO 9001
- b) control of the discs during manufacture is based on a control plan

6. COMPLAINTS

Complaints are reconsidered in order to find solution. In principle Complaints should be provided not later than 6 months after delivery.

The buyer is liable to forward the following data to the supplier:

- a) order number
- b) pallet number
- c) Talum order number (work order)
- d) slugs dimensions
- e) identification data of defected units
- f) number of faulty pieces

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The complaints are carried out on basis of samples of defected material, delivered by the buyer.

After the complaint is adjusted by the supplier, the complained quantity is subject to an agreement between the supplier and buyer, and can be:

- sending back the material to the supplier and an agreement for a credit note
- sending back the material and supplying new, suitable material
- repaying the damage to the customer which occurred because of proven inferior quality of slugs.

7. MISCELLANEOUS

The quality of the turned discs, as set in this specification, is valid for all deliveries unless otherwise stated.

Remarks:	Approved by:
	Date: Signature: The responsible for specification