



## **AB KOMPONENTY s.r.o.'s TECHNICAL DELIVERY TERMS**

### **Art. I INTRODUCTION:**

These Technical Delivery Terms (hereinafter referred to as TDT) are a supplement to the trade terms provided in General contracts, Purchase contracts or References to Orders of the company AB Komponenty s.r.o. (hereinafter referred to as ABK). The TDT specify the requirements for the quality of supplied products.

### **Art. II AREA OF APPLICATION:**

These TDT apply to all products made by ABK. They include, in particular, products made using machining, forming, cutting, die-cutting and soldering technologies without surface treatment or with surface treatment by powder paint varnishing.

ABK declares that it manufactures its products in compliance with the following national and international standards:

- ČSN EN 1090-2 +A1 (Execution of steel structures and aluminium structures – Part 2: Technical requirements for steel structures)
- ČSN ISO 2768-1 (General tolerances. Tolerances for linear and angular dimensions without individual tolerance indications)
- ČSN ISO 2768-2 (General tolerances. Geometrical tolerances without individual tolerance indications)
- ČSN EN ISO 13920 (Welding – General tolerances of welded structures – Linear and angular dimensions – Shape and position)
- ČSN EN ISO 9013 (Thermal cutting – Classification of thermal cuts – Geometric product specification and quality tolerances)
- ČSN EN 10163-2 (Delivery requirements for surface condition of hot-rolled steel plates, wide flats and sections. Part 2: Plates and wide flats)
- ČSN EN ISO 10130 (Cold rolled low carbon steel flat products for cold forming – Technical delivery conditions)
- ČSN EN ISO 1302 (Geometrical Product Specification (GPS) – Indication of surface texture in technical product documentation)
- ČSN EN ISO 12944 (Paints and varnishes – Corrosion protection of steel structures by protective paint systems)

The quality requirements are based on the buyer's (customer's) drawing and technical documentation. If the information in drawing and technical documentation is incomplete or if it is not set by the buyer, ABK will supply products in the quality stated in the article below.

If the buyer requires a higher quality of products, i.e. higher than set in the article below, he is obliged to give ABK these non-standard conditions in writing or to mention them in the order.

In non-machined parts, the surface condition is derived from the technical delivery terms of the supplier of metallurgical semi-products (ČSN EN 10163-2, ČSN EN 10130)

### **Art. III CHARACTERISTIC OF STANDARD TECHNICAL REQUIREMENTS FOR QUALITY IN TERMS OF TECHNOLOGY:**

#### **LASER CUT PRODUCTS**

Perpendicularity deviation – tolerance field “**2**” acc. to ČSN EN ISO 9013

Mean height of elements of section Rz5 – tolerance field “**2**” acc. to ČSN EN ISO 9013

Dimensional deviations – tolerance class “**1**” acc. to ČSN EN ISO 9013

Surface quality – TDT of metallurgical semi-product supplier

#### **CHIPLESS CUT PRODUCTS**

Linear dimensions – accuracy class “**m**” acc. to ISO 2768-1

Angular dimensions – accuracy class “**m**” acc. to ISO 2768-1

General geometrical tolerances – accuracy class “**K**” acc. to ISO 2768-2

Surface quality – TDT of metallurgical semi-product supplier

#### **CHIP CUT PRODUCTS**

Linear dimensions – accuracy class “**m**” acc. to ISO 2768-1

Angular dimensions – accuracy class “**m**” acc. to ISO 2768-1

General geometrical tolerances – accuracy class “**K**” acc. to ISO 2768-2

Surface texture – max. Ra 25

#### **WELDED PRODUCTS**

Quality requirements for fusion welding acc. to ČSN EN ISO 3834-2

Linear dimensions – tolerance class “**A**” acc. to EN ISO 13920

Angular dimensions – for rated dimension up to 100 mm – tolerance class “**B**” acc. to EN ISO 13920

– for rated dimension over 100 mm – tolerance class “**A**” acc. to EN ISO 13920

Straightness, planarity and parallelism tolerances – tolerance class “**F**” acc. to EN ISO 13920

#### *Inspection and testing:*

- Visual inspection acc. to ČSN EN ISO 17637 – **standard**
- Capillary (penetration) test acc. to ČSN EN ISO 3452-2 – **at request**
- Magnetic powder test (ČSN EN ISO 17638), ultrasound test (ČSN EN ISO 17640), radiographic test (ČSN EN 1435) – **at request externally**

#### **FORMED PRODUCTS**

Linear dimensions – accuracy class “**c**” acc. to ISO 2768-1

Angular dimensions – accuracy class “**c**” acc. to ISO 2768-1

General geometrical tolerances – accuracy class “**K**” acc. to ISO 2768-2

#### **PRODUCTS WITH SURFACE TREATMENT BY POWDER PAINT VARNISHING**

Film thickness – 50 ÷ more µm as a standard

Color type, appearance and shade, surface texture – acc. to customer's requirement