

# Data sheet finishing

Above all, your satisfaction is the focus of our daily work.

In our offer relevant aspects were taken into account and if necessary deviations from your request pointed. In addition we ask for compliance with the following delivery instructions:

## 1. General information

- ✓ Packaging: Unless otherwise agreed the delivery packaging is also for the return shipment used. Exceptions may be small packages.
- ✓ Delivered packaging units must be flawless with details of the purchaser, product name, weight and delivery note number.
- ✓ Euro pallets in exchange; for lattice boxes, racks and pallets, a blank box / empty pallet is to be supplied.
- ✓ Pallet weight: max. 1000kg
- ✓ The provided goods must be largely metallic. Residual oils / residual impurities must be removable with common aqueous alkaline degreasers. Silicone-containing, alkaline / alkaline earth-containing oils and high-pressure additives are to be avoided at all costs.
- ✓ Layer thickness tolerances listed in offers are exclusively defined measuring points adhered to and checked. Outside the measuring points these may differ. If no measurement points have been agreed at offer creation these will be determined by Metoba.
- ✓ Due to the process it is possible that several delivery lots are combined into one batch.
- ✓ Measurement protocols are not created coil or measurement point related, but usually one test report per packaging lot (pallet, grid box, etc.) is made.
- ✓ Layer thicknesses are applied without statistical security.
- ✓ Galvanically applied surfaces always reflect the texture of the base material. Information on roughness can therefore not be guaranteed or tested.
- ✓ Silver passivations contain thiol compounds and are always applied over the entire surface.
- ✓ Residual soil analyzes are not carried out by Metoba.
- ✓ Uncoated areas or e.g. bare copper surfaces tend to form oxides. With selective coating traces of the deposited metal in other / uncoated areas may be possible.
- ✓ Index changes of the drawings are to be reported separately to Metoba in writing and are only accepted after confirmation by Metoba.

## 2. Strip coating

### 2.1. Delivery status

- ✓ Maximum ring / coil weight: 500kg
- ✓ Pallet size: max. 800x1200mm or 1000x1000mm, stack height: max. 1300mm
- ✓ Round palettes: diameter max. 1200mm
- ✓ Minimum delivery quantity: 500m, the delivery quantities for brush, spot or strip coatings are to be agreed individually.
- ✓ Delivered liner paper is reused in an environmentally friendly way. If new paper is used differently please inform us before placing the order.
- ✓ At delivery at least one empty reel and two rolls of intermediate paper shall be provided.
- ✓ Reels are not permitted to be twisted when delivered.

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## 2.2. Punching grid / coils

- ✓ Core holes of the coils; 20mm, all remaining core bore diameters must be reported in writing before order placement.
- ✓ Minimum inner diameter: 200mm
- ✓ Maximum outer diameter: 1200mm
- ✓ Maximum coil width: 125mm
- ✓ Unwinding of pallet possible, winding only vertical and same position.
- ✓ We ask you to supply coil lists containing coil number and quantity / coil.
- ✓ Strip interruptions must be indicated at delivery time. Standard: loose, not connected.
- ✓ Delivery only on stable spools (no cardboard or constrictions)
- ✓ The winding direction does not correspond to the delivery condition. It is wound in the tape principle. Special requirements for the winding direction must be agreed before order placement.
- ✓ On winding drawings the burr and round side must be specified for delivery and return delivery status.
- ✓ Before order placement we ask you to coordinate the run-off zones. These can be up to 4mm.
- ✓ Brushing operations are always performed over the entire surface.

## 2.3. Flat strip

- ✓ Ring inside diameter: 300-500mm
- ✓ Winding only vertical and coincident
- ✓ Maximum outer diameter: 1200mm
- ✓ If necessary sufficient cardboard inner rings are to be provided otherwise the winding takes place without a core.

## 3. Barrel coating

- ✓ Bulk material processing can result damage, bending, growth or deformation. The extent and type of damage can only be determined by close-to-series-production sample processing.
- ✓ Because of the fact components can interlock with one another due to their geometry it is always recommended to use sample processing close to series production.
- ✓ Please note that surface finishing usually increases the delivered volume.
- ✓ Sockets and components must have a flushing bore of min. 0.2mm.
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## 4. Frame coating

- ✓ Please take into account that contact points and consequently uncoated areas are unavoidable.
- ✓ If no contact point was specified at offer creation it will be defined by Metoba.

