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## **Technical conditions of work execution (TCWE):**

### **Paint shop**

### **FK system – povrchové úpravy, s.r.o.**

*These TCWE do not replace the General Terms and Conditions of FK system – povrchové úpravy, s.r.o.*

#### **1. Acceptance of a part for surface treatment**

- 1.1. Please submit your order at least 1 day in advance in Czech, Slovak, or English to the email address [fkssystem@fkssystem.cz](mailto:fkssystem@fkssystem.cz), which is the only address to receive and process orders. Orders are confirmed only electronically by a confirmation sent from the system. Without an order, goods will not be released for treatment.

Among other things, an order must state:

- customer identification
- ref. No. of our offer, if any has been made, or the agreed price
- identification of the part(s) or order
- required surface treatment
- material (carbon steel, stainless steel, aluminum alloy, etc.)
- coating system specifications (types of coating materials, layer thicknesses, surface pretreatment before coating)
- weight of the part, if greater than 1,000 kg
- any special requirements for packaging, masking, handling, etc.

All information required by the contractor for the correct performance of the work must be stated directly in the body of the order (not on a drawing or in an attachment, and not merely by reference to the offer). All information must be provided in a single document (i.e., it is not possible to provide part of the information in the body of the order and part in the body of an email message).

- 1.2. Parts must be delivered with a delivery note referring to the order number under which treatment was ordered. Parts for painting must be delivered dry, free of grease without markings with paint, marker, etc. and free of mechanical dirt including stickers, baked foils, etc. Delivery of parts contrary to the above may result in poorer quality of the painted surface, or additional work required to prepare the surface for quality compliance will be charged.
- 1.3. Parts must be delivered with a suitable pre-treatment of surface for the coating, preferably abrasively blasted. In the case of a differently prepared surface, the suitability of the pretreatment will be assessed by the technician prior to painting. The surface can be additionally pre-treated in our company by blasting or other suitable means according to the technician's assessment. There will be an additional charge for this pre-treatment. If the surface cannot be sufficiently pre-treated for painting, we do not guarantee the adhesion of the coating to the surface of the part.
- 1.4. If there are places and surfaces on the parts that must not be painted (e.g. machined surfaces, sealing surfaces, seating surfaces, inner surfaces of tanks and vessels, threads, etc.), the Client must explicitly point this out in the work order and at the same time the Client must provide a drawing with the part where these places are marked clearly and unmistakably (e.g. with a colour marker).

- 1.5. During the winter chemical treatment of the roads (salting), we recommend that the parts are transported only on the load area covered with a tarpaulin. Salt has a very aggressive effect on the metal surface and even wrapping the parts in PE foil will not protect them sufficiently. It is recommended to transport the parts after painting by vehicles with tarpaulin cover all year round.
- 1.6. Only a random check is carried out upon receipt. Any damage can only be detected after work on the parts has begun. The number of pieces is not checked. 100% parts acceptance is available on request.
- 1.7. The date of execution and completion of the work will be decided by the paint shop foreman.

## **2. Quality standards**

- 2.1. The specification of the coating system (type of coating material, layer thickness, colour shade, etc.) is based on the Client's specification and is elaborated in the offer for the execution of works. According to the offer, which must be approved by the Client, the work is subsequently carried out. The standard specification is based on ČSN EN ISO 12944, which also specifies recommended coating systems according to the material to be painted and the required corrosion resistance.
- 2.2. When evaluating the completed coating system, a visual inspection of the surface and measurement of the coating thickness according to ČSN EN ISO 12944 is carried out.
- 2.3. Painted parts are packed and shipped at the earliest drying or curing stage suitable for handling. However, the final mechanical and chemical resistance of the coating system is obtained only at a time that is precisely determined by the technical data sheet of the paint.
- 2.4. Wrapping parts in PE film and then storing them outside can lead to colour changes or defects. These defects will not be accepted in the event of a claim.
- 2.5. Upon request, we will draw up a report on the work carried out.

## **3. Problem areas in terms of pickling**

- 3.1. If there are closed or otherwise inaccessible places on the product, these places will not be coated.
- 3.2. If there are hard-to-reach places on the product, i.e. places where it is not possible to apply the coating layer by spraying, these places will be painted by hand.
- 3.3. Visual defects visible before painting (deep grooves, large unevenness, etc.) are even more apparent after painting. This is not considered a painting defect. If the Client requests, such defects can be sealed, provided that the coating system contains at least two layers of paint. The sealing must be approved by the paint shop technician and will be charged as additional work.

## **4. Packaging**

- 4.1. To avoid damage to the painted surface and degradation of the work, each part is packed and dispatched no earlier than the day after the painting operations are completed.
- 4.2. Individual parts on pallets are interlaced with suitable packaging material. In addition, small parts are packed in PE stretch film. The parts are stacked on pallets preferably in the same way as they were delivered. If the parts no longer fit on the original number of pallets after



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packing, they will be placed on additional pallets. The price of these pallets will be added to the invoice.

- 4.3. In case of request for a different packing method or if you wish not to pack at all, this must be agreed with the technician and specified in the order.
- 4.4. The package is not intended for transport on open cars and is not intended for storage in outdoor, unroofed areas.

## **5. Shipment of parts after surface treatment**

- 5.1. If parts are picked up by an external carrier, it is necessary for the driver to report the name of the company that ordered the surface treatment and the order number for which the treatment was ordered. Without this, it is not possible to identify the order and carry out the loading.
- 5.2. Our company does not arrange transport, nor does it assume any responsibility for proper and careful securing of goods for the purpose of transport on a vehicle. The driver/carrier assumes responsibility for the subject of the order on loading the goods and signing the delivery note

## **6. Order completion times**

- 6.1. Orders are normally processed within 5 working days, if technologically possible.
- 6.2. Prices and conditions are listed in the attached Price Clause. The possibility of express processing and technical and deadline specifications must be agreed in advance.