
Technical conditions of work execution (TCWE): pickling stainless steel – at the pickling plant 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, 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
- identification of the part(s) or order
- required surface treatment
- the numerical designation of the material grade according to ČSN, DIN, or AISI (if there are multiple designations, list them all)
- any special requirements for packaging, 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.
- 1.3. The pickling plant is primarily equipped for pickling and passivation of alloy stainless AUSTENITIC STEEL. In the event of a request for pickling other than austenitic material, it is necessary to state this prominently in the order so that there is no confusion, and at the same time to inform the technician of the pickling shop or the foreman of the pickling shop by phone or in person.
- 1.4. If a stainless steel part to be pickled also includes a carbon steel part, this must be noted in the order. Carbon steel parts must be primed, even where they come into contact with a stainless steel surface. This coating may be damaged by pickling. If aluminium flanges are part of the piece, they must be delivered thoroughly wrapped in PE foil. Combined parts with carbon steel or aluminium can only be pickled by spraying.
- 1.5. Parts to be pickled must be delivered dry, without grease, without any paint or marker markings, etc. and without mechanical impurities, incl. stickers, burnt foil, etc. Delivery of parts failing to meet this requirement may result in poorer visual quality of the pickled surface.
- 1.6. After prior agreement with the technician, parts can be delivered, e.g. greasy for degreasing, with scales after annealing for removing scale, with protective foil, if necessary, etc.
- 1.7. During the period of chemical treatment of roads (salting), it is necessary to transport parts only on a tarpaulin cargo area, both parts for pickling and parts that have already been pickled.

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Salt acts very aggressively on the stainless steel surface, and even packaging in PE foil will not sufficiently protect the parts. We recommend transporting parts after pickling by tarpaulin vehicles all year round. Only a random check is performed on receipt. Any damage can only be detected after work on the parts has started. The number of pieces is not checked. On request, it is possible to order 100% acceptance of parts.

- 1.8. If parts are not delivered in accordance with these TCWE or general and normative requirements for material readiness for surface treatment, additional work will automatically be done to prepare the parts for the required surface treatment. This additional work will be invoiced as extra costs according to the actual complexity of the work and the valid price list.

2. Quality standards

- 2.1. Pickling and passivation are technical operations ensuring corrosion resistance of the material. They cannot achieve a uniform or repeatable surface appearance.
- 2.2. The surface after pickling will be metallically clean without corrosion, colour fading and scale after welding, coating and abrasion of carbon material and residues of pickling and passivating agents.
- 2.3. Pickling cannot remove slag, burnt grease in welds, deep inclusions of carbon material, dirt ground into the surface, burnt remains of protective foils, labels, etc.
- 2.4. Pickling often dulls the surface and increases surface roughness.
- 2.5. Defects cannot be claimed on poorly accessible or completely inaccessible surfaces.
- 2.6. In the pickling process, small touches of individual parts with the pickling equipment and with each other may occur. The occurrence of possible small abrasions, scratches and shadows is not considered a defect. The formation of deep scratches, dents and mechanical damage to parts is unacceptable during the pickling process.
- 2.7. The processing of visible parts and surfaces, for which there is a requirement to minimize mechanical traces and marks after rinsing, can be ordered in special modes for an additional fee. The request for Special Mode must be clearly stated in the order. If there is a requirement in the order for careful handling, not to scratch parts, visible parts, etc., the order will be automatically executed in Special mode at the appropriate price. Section 2.1 of these TCWE also applies to work in special regimes.
- 2.8. On request, we provide a report on the work performed according to the technical standard ČSN EN 10204 – 2.1, or an inspection certificate in accordance with ČSN EN 10204 – 3.1 after the customer has defined the tests. The issuing of both reports is subject to a fee in accordance with the valid price list.

3. Problem areas in terms of pickling

- 3.1. Dip-pickled parts must not have closed spaces (square tubes, pipes, etc.) that are not watertight and into which pickling agents could seep without the possibility of rinsing. The possibility of flushing is ensured, for example, by drilling a square tube at both ends with a hole with a diameter of min. 6 mm, chamfering of the walls of the tube at its ends, etc. However, always in such a way as to ensure that the bath flows out of its entire volume. Suitable places for drilling can be consulted with our technicians. Otherwise, these parts will be pickled by spraying at an additional charge as per the price list. Only accessible surfaces can be pickled by spraying.

- 3.2. If there are joints (stitch welds, sheet metal on sheet metal, screw joints, etc.), porosity (e.g. in castings), or other surface inhomogeneity, residues of pickling agent or rinsing water may remain in the parts. These may subsequently flow out or ooze out and form maps on the surface. Any defects arising from construction details mentioned in sections 1.3, 1.4, 3.1 and 3.2 or others, non-compliance with delivery conditions 1.5 and 1.7 or others are not considered to be pickling defects and we do not recognize them as a claim.

4. Packaging

- 4.1. After pickling, parts are shipped packaged in the same way they were delivered. In the event of a request for a different packaging method, this must be agreed with the technician and included in the order. Packaging other than the basic type (section 4.3) is subject to a charge.
- 4.2. The basic method of packaging is included in the price of the work.
- 4.3. Basic packaging includes clean packaging material as a base on a pallet, in a box, etc. It also includes placing the parts on a pallet or in a box, strapping them to the pallet and possibly covering the entire pallet or box with clean PE foil.
- 4.4. EXTRA packaging can be ordered for an additional fee. EXTRA packaging means that each part is packed separately, or individual layers of parts are horizontally separated from each other by cardboard, and also the parts in each layer are separated from each other by cardboard or foil.
- 4.5. The packaging is not intended for open trucks and is not intended for storage in outdoor, unsheltered places.

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. We offer express order processing under the following conditions:
- Work completed within 48 hours. For example, parts delivered on Monday morning and the finished order picked up on Wednesday morning.
 - Processing of orders over the weekend. For example, delivery of parts on Thursday or Friday morning and collection of the finished order on Monday morning.
- 6.3. 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.