

**01. Preliminary remark**

The instructions for the use of the mobile curving machine are a component part of the contract and are binding, firmly agreed upon for both parties. At the same time, the instructions also govern demarcation of the performances between the customer and BEMO Project Engineering GmbH.

**02. Weight of the mobile rollforming machine**

BEMO is using its different machines according to the special conditions and profile of the order. Information about the curving machine coming into operation at your project and its corresponding weight can be obtained in our office in Ilshofen.

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In accordance to the total weight the customer has to ensure that the access road to the building site and the sub-soil of the site are reinforced for road transport. If this is not guaranteed, it is the customer's responsibility to take appropriate measures and to accept the costs for necessary moving or similar.

**03. Dimensions and space requirements**

· Space required for curving:

**The curving machine should be located close (max. 20 m) to the storage area of the straight standing seam profiles.**

a) For the curving machine, plus lateral space for the storage and run-out of the curved panels

width: machine + camber of the curved panels

length: machine + length of panels x 2 (run-in and run-out)

+ 3,00 m working space in each case

- b) required overall breadth: machine + camber + storage space
- c) required overall length: machine + (longest profile length) x 2 + 6,00 m

- Additional space requirement for the intermediate storage of the curved sheets is to be provided in sufficient scale in accordance to the size of the building project near the panel run-in and run-out.

Additionally we want to refer to point 08 of these instructions.

### 04. Electric supply

It is **absolutely** necessary to look to it that there is an **adequate electric supply** available at site.

- Distance from the curving machine: max. 50 m
- Connection: 5 - pole Cekon - socket  
(3 x 380 V +/- max.5 % +N+PE)
- Frequency: 50 Hz +/- max. 1 %
- Connection loads: Back-up fuse (Ampere): on request  
Rated current (Ampere): on request  
Connected load (KW): on request
- Emergency power generator (if used): Connected load: on request
- If using fuse (FI) safety system an idle current of min. 300 mA from our machines is to be taken into account.
- Each curving machine is fuse protected that the engines do not work when the power is lower!

## **05. Staff requirement**

- The requisite machine-operator for operating the mobile curving machine is placed at disposal by BEMO
- The equipment may only be operated by a BEMO - machine operator.
- Unless otherwise specified in writing in the BEMO - offer, the customer has to provide assisting workers at his own expense for the removal and storage of the produced panels.
- The necessary number of support-people depends on the length of the panels to be produced (handling) and the material to be processed. The following details are guide values, the definitive quantity is to be settled with the BEMO-operator on site:
  - for aluminium profiles with a length over 8 m:  
**each 8 m / 1 helper x 2 (run-in and run-out)**
  - for steel, zinc or copper profiles with a length over 6 m:  
**each 3 m / 1 helper x 2 (run-in and run-out)**

## **06. Operating time**

- The required time depends on the demands of the production process and the extent of the contract and is determined by the BEMO - machine operator in agreement with the responsible offices.
- Normal working time:

Monday – Friday:	10 hours per day (incl. 1 hour break)
Saturday, Sunday and public holidays:	8 hours per day (incl. 1 hour break)
- Saturday working is without additional charges. If time pressure is high, the customer and the supplier can agree upon working on Sunday and public holiday for appropriate additional charges.

## **07. Services to be provided by the customer at the project site**

- Suitable offloading equipment for the curving machine for loading and unloading the curving machine off and onto the transporting vehicle.
- Providing a sufficient quantity of square-shaped timber or boards to place under the produced or curved profiles (intermediate storage).
- Suitable lifting gear (e.g. straps etc.) as well as lifting beams for the maximum profile length (maximum profile length less approx. 2,5 m left & right) for lifting the curved BEMO- profiles onto the roof.
- The customer is to ensure appropriate cordoning off of the production area, especially in the region of the panel run-out, in accordance with the general safety regulations and the instructions of the BEMO - machine operator.
- The costs for the distribution and supply of power respectively fuel for the aggregate (for curving machine production and if necessary the site containers on site) are the responsibility of the customer.
- The uncurved sheets are to be discharged at the project site by lorry by the customer and at his account and stored in accordance with the curving area.
- The disposal of the supplier's manufacturing waste or packaging material declared as such by the supplier.
- Securing the supplier's machines, coils and accessory items against theft and damage.

### **08. Intermediate storage**

- Curved profiles are to be stored temporarily on square-shaped timber or boards on clean subsoil.
- It is essential that the panels are stored with a slight downward slope in longitudinal direction.
- For the intermediate storage of uncurved profiles the client is responsible for seeing that
  - the panels are stored on a wooden base
  - the panels are stored with a slight downward slope in longitudinal direction

### **09. Passing of risk**

- The transfer of perils (from the producer to the customer) for damages to the BEMO - panels takes place after the panels leave the curving machine. For the period of temporary storage, from point of time of delivery of uncurved profiles until end of production the risk and liability is at our customer.
- Panels which get damaged during handling or during the uplifting onto the roof and have to be produced once again must be paid separately.
- The customer is obliged to check the panels' quality and dimensions immediately after handover of the curved BEMO - panels, later complaints can no longer be invoked.
- Claims after moving the panels on the building site or installation on the roof can no longer be invoked (e.g. scratches, deformations, surface damage etc.).

## **10. General remarks**

- The customer is liable for any accidents. The customer also has to prepare the building site according to the local safety regulations and to instruct the machine operator as well as support-persons in an adequate way. The customer has to pay all costs therefore.
- Delays which are not caused by the machine operator are charged to the customer and will be invoiced at 125 € / hour up to max. 8 hrs./day.
- If moving of the curving machine is necessary, due to demand of the customer or a third party, the resulting costs will be charged to our customer.

Our operating staff is not authorised to accept and carry out any changes to the contract. If required, these are to be agreed with BEMO or rather with our co-ordination office

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- Curving at an outdoor temperature less than 5 degrees Celsius is only possible if the material had been stored tempered at minimum 10 degrees Celsius for 2 days and are free of frost and ice. At radii < 10.000 mm special conditions are to be agreed with BEMO - order processing.
- Folding the panels at temperatures below 5 degrees Celsius can lead to problems (e. g. material breakage).
- An evaluation of the curving area regarding the suitability or facility for curving on site can be made by BEMO, together with the responsible authorities. A date must be fixed beforehand and original costs will be charged.
- The free use of the existing site facilities (washrooms, changing rooms and rest rooms, phone, fax and e-mail for the machine operator) is to be made available to the BEMO - working staff.

- In case of interruption of production due to bad weather the BEMO – working staff is allowed to leave the building site after a waiting-time of 3 hours and continue production on the next day or when the weather has improved.
- The BEMO - profiles curved by BEMO - operator will be specified in a production list stating the number of pieces, length and width. The responsible representative of the customer is obliged to check the produced bulk and to confirm with his signature.