

GENERAL TERMS AND CONDITIONS OF SALE AND DELIVERY OF STRAALTECHNIEK INTERNATIONAL BV

Registered with the District Court of Breda / Integrally available on www.straaltechniek.net

1. Scope of application

1.1 These general terms and conditions of sale and delivery shall apply to all legal acts, such as but not limited to agreements regarding the supply of goods (hereinafter the "Goods") and the rendering of services (hereinafter the "Services") by Straaltechniek International BV or one of its group companies (hereinafter "Straaltechniek").

1.2 Deviations from these Terms and Conditions shall only apply if Straaltechniek has confirmed the aforementioned deviations in writing. Herewith, the applicability of the general terms and conditions of the contracting party (hereinafter the "Buyer") are explicitly excluded.

1.3 In case of total or partial nullity or otherwise invalidity of one or more stipulations of these conditions, the other stipulations remain in force. Parties will draft a new provision in accordance with the spirit of these conditions

2. Offer

2.1 Offers made by Straaltechniek are without engagement. An offer accepted by the Buyer can be withdrawn by Straaltechniek within 5 (five) working days after acceptance and without costs.

2.2 All quotations and any subsequent orders and/or agreements are at all times subject to a resolutive condition of export approval (i.e. granting of a permit, a generic approval or otherwise) by the competent authorities, whether Dutch, European or otherwise.

2.3 Provided data and samples, to the extent that no specific guarantees are given, will be deemed informative from which Straaltechniek can deviate.

2.4 Straaltechniek has the right to deliver Goods which deviate from the agreed fabrication and/or trademark provided that these Goods have the same relevant features.

3. Prices, invoicing, terms of payment

3.1 Prices are based on delivery FCA, Tilburg, The Netherlands (Incoterms latest version) excluding packaging, taxes and surcharges which will be mentioned separately.

3.2 Prices are in euro. If in a specific order prices in a different currency are used this shall be done based on the exchange rate against euro applicable on order date. If at date of invoice this exchange rate deviates with 2.5 % or more, Straaltechniek is entitled to fix the contract price anew based on the then applicable exchange rate.

3.3 In the event the total production costs of the Goods and/or Services increase with more than 2.5%, Straaltechniek is entitled to raise the offered and/or agreed upon price. Aforementioned does not give Buyer any right to (partial or total) termination of the contract.

3.4 Payment will be made in accordance with the agreed upon payment schedule, within 30 days from receipt of a proper invoice. Invoicing shall take place 100% at delivery (with respect to commodities) or according to the following payment schedule (with respect to projects):

- a) 30% as advance payment at date of order;
- b) 30% at factory acceptance test;
- c) 40% at delivery.

In the event the execution of Straaltechniek's obligations is delayed due to circumstances beyond its control, Straaltechniek is entitled to deviate from the agreed upon payment schedule and invoice the activities which have already been performed.

3.5 Straaltechniek is entitled to settle its debts to the Buyer or one of its group companies against any claim it may have on the Buyer.

3.6 In the event of non payment or late payment, Buyer shall be liable to pay to Straaltechniek any and all extrajudicial (with a minimum of 15%, of the outstanding payments) and judicial costs.

4. Delivery

4.1 Delivery will be in accordance with FCA Straaltechniek, Tilburg, The Netherlands (Incoterms latest edition) unless otherwise agreed. Partial delivery is permitted.

4.2 Delivery of any goods by Buyer to Straaltechniek for treatment or processing will be DDP Straaltechniek Oosterhout, The Netherlands (Incoterms latest edition) unless otherwise agreed.

4.3 Packaging, including pallets and containers that are not included in the price shall remain the property of Straaltechniek and shall be returned to Straaltechniek at cost of the Buyer.

4.4 On delivery the Buyer shall inspect the Goods and/or Services and perform the common entrance and quality checks and controls. No claim for damage or short delivery of Goods can be entertained unless either a receipt is given to the

carrier detailing the shortage or damage at the time of delivery or alternatively notification of the shortage or damage is given to Straaltechniek within two business days from the date of delivery. In absence of the aforementioned, it is presumed the goods have been delivered in pristine conditions.

4.5 The dates or periods for the delivery of Goods and/or performance of Services take effect immediately after written confirmation by Straaltechniek and after the agreed conditions have been met by the Buyer such as but not limited to down payment.

4.6 Any dates, terms or periods for the delivery of goods or services are best estimates and approximate only. No such dates, terms or periods shall constitute a fatal obligation binding on Straaltechniek. In no event time shall be of the essence of the agreement.

4.7 Straaltechniek shall only be liable towards Buyer for late delivery if and when Straaltechniek is in default.

4.8 If the Client requests Straaltechniek to postpone the delivery than Straaltechniek is entitled to reimbursement of all subsequent costs (such as but not limited to storage costs and mobilisation costs of personnel). Straaltechniek shall jointly with the Client determine a new delivery date based on the internal production planning of Straaltechniek. If such new delivery date is more than 2 months later than the original one than Straaltechniek is entitled to invoice, and the Client is obliged to pay, the full contract value.

5. Execution

5.1 The obligation to deliver Goods does not include the installation and commissioning of the Goods unless specifically agreed.

5.2 If the installation and commissioning of the Goods is agreed, the following shall apply:

- a) the Goods as well as all parts and materials are for the risk of the Buyer after factual delivery to Buyer's premises;
- b) the Buyer is responsible for the accessibility of its premises to ensure that installation and commissioning can be executed without the need for any further provisions or facilities;
- c) Straaltechniek is not responsible for any foundations, civil work and/or de-installation or removal of existing equipment;
- d) the Buyer shall provide free of charge all necessary consumables such as but not limited to energy, water, air, tools, hoisting and cranes;
- e) the Buyer shall ensure that all preparatory activities such as but not limited to (civil) building and electro technical activities are finished timely;
- f) Straaltechniek is entitled to use third parties for the performance of its obligations.

5.3 The Buyer guarantees that Straaltechniek can perform all necessary activities without disturbance or interference. In case the activities are interrupted or delayed due, the Buyer is liable to Straaltechniek for all additional costs, including costs for (de)mobilisation. Any agreed completion date shall be extended.

5.4 Completion of installed and commissioned Goods shall take place if and when the Goods are mechanically complete and commissioned. The Buyer has the right to inspect the Goods at commissioning.

5.5 Completion shall be documented in a completion certificate. Any observations and/or comments shall be mentioned. The Buyer is not entitled to use the Goods before execution of the certificate of completion.

5.6 Aspects or shortcomings of minor importance which do not hinder or prevent actual operation of the Goods shall not prevent the Goods to be commissioned and completed. Any such aspects or shortcomings shall be made good by Straaltechniek within a reasonable time.

6. Passing of title and risk

6.1 Subject to 6.2, title and usage rights of the Goods shall transfer to the Buyer upon delivery.

6.2 Straaltechniek retains ownership of all goods until all amounts including but not limited to service costs owed by the Buyer to Straaltechniek are paid in full. The Buyer is not entitled to re-sell, assign, pledge or grant any other legal rights on all or any of the goods to third parties. Regardless of the aforementioned, the goods will be for the risk of the Buyer after delivery.

6.3 If Buyer does not comply with the applicable terms of payment or if Straaltechniek has reasonable doubt that the payment terms will be met, Straaltechniek may at its sole discretion repossess the delivered Goods. These Goods will be credited against their market value with deduction of costs made.

7. Guarantee

7.1 Straaltechniek warrants that full title to the Goods is delivered and the Goods are new, unused and, during the Guarantee Period, free from defects in material, workmanship and design and are in accordance with the contractual specifications. Further, Straaltechniek guarantees that all Services are performed in accordance with sound engineering practice and due diligence. This guarantee is exclusive and in lieu of any implicit and/or statutory guarantee.

7.2 The applicable guarantee period (hereinafter the "Guarantee Period") is 12 (twelve) months from commissioning, or 2200 machine hours, or 14 (eighteen) months from delivery, whichever period expires first.

7.3 In the event a default occurs within the Guarantee Period which could not have been detected with common entrance and quality checks and controls, Straaltechniek is obliged to make good any such default by either, at its own discretion, repairing or replacing the Goods and/or redoing the Services. This make good obligation is exclusive and excludes any liability for damages and/or costs sustained by Buyer as a consequence of such default in the Goods and/or Services.

7.4 Straaltechniek will not be liable for the designs and materials dictated or specified by the Buyer unless the designs and choice of materials have been explicitly approved by Straaltechniek in writing.

7.5 This guarantee does not apply to normal wear and tear, defects that could have been detected with common entrance and quality checks and controls, damage to or deterioration of the Goods as a consequence of improper storage, use or handling, repairs made by Buyer or third parties, use of spare parts, consumables or materials not supplied or certified by Straaltechniek.

7.6 If the access to the Goods is obstructed (e.g. because Goods are built in), the costs made in order to access the Goods are for account of the Buyer.

7.7 In the event the Buyer is not the end user of the supplied Goods and/or Services, the additional costs caused by the fact that the Goods and/or Services are not situated at the Buyer's location are for account of the Buyer.

8. Dissolution and suspension

8.1 If Buyer is in default with the performance of its contractual obligations, Straaltechniek may, without prejudice to its other claims and rights under the contract, suspend further performance of its obligations for such time as it shall deem fit.

8.2 In the event Straaltechniek has reasonable doubt regarding the payment capacity of the Buyer, Straaltechniek is entitled to postpone all obligations under the contract until the Buyer has provided sufficient security.

8.3 In the event the Buyer cannot meet its obligations under the aforementioned conditions within a reasonable period, Straaltechniek is entitled to terminate the contract without compensation of damages.

8.4 Straaltechniek is entitled to terminate the contract without compensation of damages or suspend its performance in the event of withdrawal of operation, judicial settlement, liquidation and/or (application for) bankruptcy of the Buyer.

9. Liabilities

9.1 Straaltechniek shall only be liable for damages, payments, losses, costs, expenses and liabilities incurred by Buyer as a result of a breach by Straaltechniek of its contractual obligations.

9.2 Any and all liability of Straaltechniek whether in contract or at law ends at all times 18 (eighteen) months from delivery.

9.3 Straaltechniek's maximum liability arising out of or in connection with this contract, whether in contract, tort or otherwise (including damages resulting from product liability) shall be limited to the total order value.

9.4 In no event shall Straaltechniek be liable for any consequential, indirect or exemplary damages, including but not limited to loss of profit or turnover, downtime costs or claims from Buyer's customers for such damages.

9.5 The above exclusions or limitations of liability apply not only in contract but also in tort or otherwise at law and shall apply notwithstanding any provisions to the contrary elsewhere in the contract.

9.6 Parties have explicitly agreed upon aforementioned exclusions and restrictions regarding Straaltechniek's liability under these terms and conditions. The compensation of risk has explicitly been applied as a basis for the price-setting in these terms and conditions.

10. Confidentiality and intellectual property

10.1 Buyer shall keep confidential, both during as well as after the performance of its obligations, all commercial and technical information and know-how, such as but not limited to information on Straaltechniek's products, prices, customers and suppliers (hereinafter "Confidential Information")

10.2 All intellectual property rights on the Goods and/or Services delivered by Straaltechniek, including without limitation all copyrights, database rights, rights in design, rights in know-how, patents and rights to inventions, information, content, materials, data or processes (in all cases whether registered or unregistered and including all rights to apply for registration thereof) belong to, shall remain and/or shall become the property of Straaltechniek. All bearers of intellectual property and/or Confidential Information shall remain or become the property of Straaltechniek and, without its explicit consent, may not be copied, shown to third parties or used in another manner, whether or not any costs were paid by Buyer for the production or provision thereof. Buyer shall return any such bearers to Straaltechniek on first written demand thereto.

11. Applicable law / jurisdiction

11.1 These terms and conditions will be governed exclusively by and construed in accordance with the laws of the Netherlands without reference to its principles of conflicts of law.

11.2 Parties hereby irrevocably submit that all disputes concerning the contractual relationship will be subject to the exclusive jurisdiction of the Dutch civil court, district of Breda.

----- specific additions, to be reviewed -----

12. Document priority

From top to bottom, the following priorities hold:

- Terms and conditions of Straaltechniek
- Order confirmation of Straaltechniek
- Quotation of Straaltechniek
- Orgalime conditions
- Purchase order from customer.

13. Highly specialized machinery

STRAALTECHNIEK sells, engineers, manufactures and commissions professional pressureblast machines, wheelblast machines, dedusting installations and industrial fans. This equipment is highly specialized machinery with a value of up to millions of euro's. Improper use can and will result in big repairing costs and/or safety risks. Therefore, the customer is expected to study intensively the sales contract, the terms & conditions and the equipment.

14. Orgalime conditions

Orgalime conditions are applicable. A copy of the terms and conditions is attached. (for Naaykens only?)

15. Warranty, guarantee (additions to article 7)

- Refer to section 20 (Asset Care) for the requirements on inspection during Warranty.

- Wear and tear items are excluded from warranty. Also items broken due to improper use are not covered by warranty. **Warning!** In some of our machines, consumables even last less than 4 weeks at high utilization. See Article 44 (Consumables).

- Warranty is valid only, if service, startup, maintenance has been performed or witnessed by STRAALTECHNIEK.

- Warranty is valid only when spare parts of STRAALTECHNIEK are used.

- This warranty applies if all financial obligations towards STRAALTECHNIEK are fulfilled.

16. Validity of quotations

The prices quoted are open for acceptance within a period of 30 days from our quotation date and if accepted within this period, will remain fixed for the delivery period quoted. If not accepted within this period, they may be subject to revision or extension at our discretion.

18. Service contract / Service Level Agreement

STRAALTECHNIEK has a professional maintenance department to provide the customer with after sales maintenance.

Even in Warranty period, our machines require service. To be able to qualify for the Warranty, this machine requires inspection and service by STRAALTECHNIEK. Unless otherwise specified, the interval is 6 months.

19. Asset Care: checks and inspections

Blasting equipment is highly specialized equipment, prone to many mechanical and abrasive loads.

Warning! In some of our machines, consumables last less than 4 weeks at high utilization. See Article 38: Industry Conventions. Daily, weekly and monthly checks and inspections are required to keep the machine in good condition. These involve:

- Check wear on specific parts, like nozzles, hoses, rubber or steel wearplates.
- Check for leakage visually and listening for abnormal noises.
- Check for abnormal vibrations.
- Regularly check and clean perforated plates on scrapers and cleaners.
- Check waste and dust disposal containers

The customer is responsible for this. An instruction will be provided by S.I. during training. Failure to comply with the asset care instructions leaves the warranty void.

20. Asset Care: Proper access of replacement parts

Parts susceptible to replacement or greasing during the lifetime of the equipment, should be kept properly accessible at all times. Hoisting possibilities should be also be facilitated. Examples requiring proper access, include:

- Inspection hatches
- After filters
- Fans
- Elevator motors
- Cleaners
- Bearings
- Space beneath filter hopper required to replace bigbag, drum etc.

21. Spare parts

The supply of spare parts is not included in the delivery of the machine. Spare parts can be quoted as an option.

22. Taxes, Fees and Duties

Our prices are based on calculations as mentioned on our pricing schedule of this proposal. Costs related to local premiums, duties, taxes, value added or excise taxes, custom charges, legalization fees, etc., are not included on our proposal and must be added separately. These costs are for the account of the client / purchaser.

23. Permits, certificates and other consents

STRAALTECHNIEK equipment is operating worldwide. Costs related to homologation, fees, permits, certificates and other like documents for the local authorities are excluded from our offer and for the account of client.

24. Quality control and inspection

All STRAALTECHNIEK equipment will be produced according to ISO 9001 quality system. During production and assembling all components are checked. All products are manufactured with CE- mark.

25. Manuals

STRAALTECHNIEK will deliver the following documentation digitally. Everything will be sent in PDF format:

- Maintenance manual with spare parts and an operating manual.
- Language: 1 pcs in Language of Country of Installation or English language

26. Included

Unless otherwise specified, the following is within the scope of supply:

- Project design, engineering and realization.
- SAT testing of all core components at the Clients manufacturing site. See section SAT.
- System design and construction.
- Manuals and CE conformity
- Mechanical and electrical Layout Drawings.
- Mechanical and electrical assembly

27. Excluded / Out-of-scope

Unless otherwise specified, the following is out-of-scope:

- Any spares and consumables, including abrasive media
- System integration of all components, delivered and installed by customer;
- Integration of items that were not specifically mentioned in quotation or order confirmation.
- Costs for renting of local contractors or contracted services.

28. Installation: Handling, hacking, breaking, supplies (additions to article 5)

Unless otherwise specified, the following is **out-of-scope**:

- Hoisting materials and services, like cranes, lifting platforms and forklifts, required during the installation period:
- Forklifts for unloading the trucks.
- Forklifts to be used during the entire assembly period
- Platforms and/or scissor lifts for the assembly of the installation
- Forklifts, work platforms and scissor lifts must be in full working order and have
- have sufficient lifting capacity and reach height.
- If these are not available, STRAALTECHNIEK reserves the right to rent them at the at the customer's expense.
- Additional man-power, tools, scaffolding, cranes, forklifts and transport of the equipment within the customers company need to be provided by the customer.
- Building constructional work, such as hacking, breaking, digging, demolition etc.
- Waste disposal from delivery and/or local installation works.
- Waterproof pit as a foundation (if required) for the abrasive transport system and submersible pump pit and accessories.
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- Unloading, storing and moving STRAALTECHNIEK equipment on site.
- Transporting goods towards a different level in premises of client.
- For all terms out of scope regarding electrical, see Article 48: Electrical.
- Inspection costs and/or other requirements of the local energy company, fire brigade,
- etc.
- Unless otherwise specified, no installation hours are included in the price.

The following is **necessary** for a proper installation of the equipment:

- Approval of set-up drawing, see Article 36: Delays by customer.
- Present a clean, dry and plane levelled building site.
- Managing the goods as a good custodian from delivery to the site , possibly repairing any damage caused by weather conditions, theft, damage by third parties or force majeure.
- Assembly can continue at normal working hours and without interruption. Proper access to machine site and suitable storing area is provided. Client ensures uninterrupted progress during installation and testing of the equipment according to the contract overall planning.
- The work area is free and easily accessible for supply of materials up to the work area. Unless otherwise specified, passage to the site 4m wide and 4.5m high)
- All preparations (foundation works etc) in accordance with the prepared STRAALTECHNIEK order confirmation and drawings.
- Flat horizontal floor under the installation according to DIN 18202 group 3, NEN 2747, class 2 for a new concrete floor: See foundation drawings.
- The client's premises should be equipped with the necessary openings in the walls and roof and provide watertight sealing of the openings around the various pipes. If pipes against facade or S-bends with more than 1.5m gradient: Such works require in some cases separate lifting equipment to work safely and minimize human safety hazards. STRAALTECHNIEK investigates during detailed engineering how such assemblies of ducting can be carried out safely and informs the client which additional measures (paved ground, accessibility, type of crane,) required for this purpose.
- Air currents on the outside around the cabin(s) at the height of doors and openings in the cabin shall not exceed 0.1m/s.
- Packaging and/or waste materials can be deposited free of charge on site in a designated
- container.
- Assembly activity might consist of work at height with various risks towards occupational safety. The provision of the appropriate lifting/height equipment is not included in this quotation and is at the customer's expense.
- Sanitary and canteen facilities
- Costs caused by not correctly following instructions will be charged
- The customer specifies the height of the blow-off channeling.
- The installation may only be commissioned by the customer after delivery and after all financial obligations have been fulfilled.
- For electrical necessities, see Article 45
- If, before delivery, client puts the installation into operation, warranty is void and this moment is considered to be the moment of delivery.

29. Supplies

Out-of-scope: The assembly of the machine doesn't include delivery of gas, oxygen, compressed air or electrical energy. Client is responsible for:

- Plumbing of air to the specified drops for the components.

- Connecting of electrical power supply into main control panel.
- Supplying dry compressed air at the required pressures, flows and quality.
- Delivering electrical power to the specified drops for the components.
- Provide the external power supply cables on the power distribution cabinet of the equipment with the AC electricity, as well as all other electrical installation materials.

30. FAT

- 2 weeks before the FAT, a protocol will be provided by STRAALTECHNIEK for information.

- The customer is expected to get acquainted with this protocol. No extra specifications are allowed to be tested, unless explicitly agreed so and for a proportional financial compensation.

31. SAT

- 2 weeks before the SAT, a protocol will be provided by STRAALTECHNIEK for information.

- The customer is expected to get acquainted with this protocol. No extra specifications are allowed to be tested, unless explicitly agreed so and when a proportional financial compensation.

32. Training

During start-up the entire installation and operation is explained. Duration $\pm$ 4 hours, unless otherwise specified. At the end of the training day, the personnel receiving the training, will receive a certificate, as proof of attendance of training. At all times, at least one certified operator, should be present at or near the installation. In case of complaints, claims or damage, this personnel will be contacted to explain the course of events leading up to the damage, to rule out improper use.

33. Transport

Unless otherwise specified,

- Seaworthy packing of the cargo is out of scope.
- Incoterms apply.
- Waiting time for unloading truck at location of client is limited to 1,5h.

34. Payment & Prices

Unless otherwise specified, the following payment terms apply:

- 1/3 with order, within 8 days of invoice date
- 1/3 when ready, before shipment, within 8 days of invoice date
- 1/3 after delivery, within 30 days of invoice date
- Subject to agreement credit insurance company.
- Credit insurance company will be informed with delays in payment.
- Prices are Nett, excl. V.A.T.

35. Approval of Layout / production drawings.

STRAALTECHNIEK is an expert in custom engineered projects. Experience from the past has taught us that revisions and changes in the layout /concept phase are a major cause of delays and leads to losses for both sides if left unchecked. These delays are often caused by unclarity from the side of customer. In the interest of everybody involved, to ensure that the project is handled smoothly, the following guidelines are set:

- The customer is expected to proactively engage and provide all inputs before the to-be accepted layout drawings.
- After receiving the to-be-approved layout drawing from STRAALTECHNIEK, the purchaser is to provide a reply within 2 working days.
- Small changes in design/drawing which will take less than 2-3 hours of effort will be updated for one time only. For larger change requests, or required changes due to new input, an additional rate will be invoiced separately. The rate is € 85,- per hour.

36. Delays by the customer (additions to article 4.8)

- The product delivery date is re-calculated from the date of layout approval by the customer. Even if an overarching delivery time is agreed upon initially. Approval of layout drawings outside of agreed time (usually 2 working days from receiving the layout drawing) or any delays due to change requests to the original layout drawing might result in re-assessment of the end delivery time and might overrule agreed delivery time penalties.
- Delays by the customer leading to more than 1 month delay from the originally agreed lead time (delivery time of the goods, service, or other agreements) might be rejected and/or could result in price increases. Reasons include re-start costs, standstill related defects and storage problems.
- Rejection of delays: STRAALTECHNIEK reserves the right to reject delay if production & install is already planned or ongoing.
- STRAALTECHNIEK reserves the right to cancel the contract if the delay is longer than 3 months. Cancellation costs apply, see section 33.

37. Rental of storage area in case of delays by customer

- If hardware is already present and waiting in the premises of STRAALTECHNIEK, 1.25% of the total order-amount is charged per month of delay. Even if delay is caused by Force Majeure.
- Storage costs of delivered components at the customer of our equipment are for the customer. **Warning!** All moving parts need regular movement to avoid damage due to idle-standing. Frequency invertors need to be connected to electricity.

38. Industry conventions & audits by external parties

Unless otherwise specified, the following holds:

- STRAALTECHNIEK operates in an industry, where it is not conventional to include certified weldings and documented welding definitions. These are known by e.g. "welding method qualification" (WPS, WPQ). Materials, used in our machines, are not traceable by so called 3.1 certificates. Therefore, this should be specified up-front in the request for quotation.
- Audits by notified body's generally result in extremely time consuming processes. Audits are not quoted and if customer announces such an audit after awarding the contract, the audit will be rejected until delivery times and prices are re-calculated.
- Any extra work as a direct or indirect consequence of audits by external parties (customer, DNV, Dekra or equivalent) is charged with a price of € 120,- per hour. If the size of the order is higher than € 100.000,-, then 1 ("FAT") visit of 5 hours incl. lunch is free of charge.
- Laws are always applicable, however, norms & guidelines should be agreed upon.

39. Surcharge for commodity inflation spikes

STRAALTECHNIEK reserves the right to apply a surcharge, after a price is agreed upon in the purchase order & order confirmation. (STRAALTECHNIEK will provide a proper substantiation). A surcharge will be charged, if the impact of price spikes is larger than € 2000,-. The commodity/energy prices are compared to the commodity/energy prices at the week of the order date.

40. Liquidated damages

Liquidated damages claims by the customer are never accepted.

41. Late delivery penalties

Unless otherwise specified, late delivery penalties claims by the customer are not accepted.

42. Cancellation costs

Unless otherwise specified, the following holds:

- Order < € 50 000: all costs already incurred + 20% of the order value;
- Order < € 100 000: all costs already incurred + 15% of the order value;
- Order > € 100 000: all costs already incurred + 10% of the order value.
- Order > € 300 000: all costs already incurred + 5% of the order value.
- Order > € 500 000: all costs already incurred + 4% of the order value.
- Order > € 800 000: all costs already incurred + 3% of the order value.

43. Questionnaire

STRAALTECHNIEK provides the customer with a questionnaire, which will define, amongst others, the scope of the contract. Customer and STRAALTECHNIEK complete this questionnaire together.

44. Consumables

Unless otherwise specified, spares and consumables are not included in the price and are not replaced under warranty. All our machines are prone to wear and tear. **Warning!** In some of our machines, consumables even last less than 4 weeks at high utilization. Especially masking tools (to blast exact spots or shapes) should be made out of Tungsten Carbide or Boron Carbide with intensive utilization. Normally, only tool steel demonstrators are included in the price of the machine.

45. Replacement of spare parts and consumables

Replacement of certain parts can be performed without special knowledge by skilled mechanics employed by the customers. See Orgalime article 30.

- Spare parts like low power motors (< 5kW), nozzles, bolts, wear plates, blast hoses, filter cartridges, 'deadmans handles'.

Replacement or repairs where STRAALTECHNIEK mechanics are required at all times:

- Impellers, blast wheels, cleaners, blast pots, pressure vessel, motors > 5 kW, frequency invertors and other specialized equipment.
Always consult STRAALTECHNIEK when replacing components.

46. Paint thickness

STRAALTECHNIEK follows ISO 19840 with regards to paint criteria. To check whether criteria are met, the following holds: (paragraph 5.4 of "NEN-EN-ISO 12944-5-2007")

- The arithmetic mean of all the individual dry film thicknesses shall be equal to or greater than the nominal dry film thickness (NDFT);
- All individual dry film thicknesses shall be equal to or above 80 % of the NDFT;
- Individual dry film thicknesses between 80 % of the NDFT and the NDFT are acceptable provided that the number of these measurements is less than 20 % of the total number of individual measurements taken;

Unless otherwise specified, the following holds:

- Coating is meant for "inside execution": the installation is placed inside premises.
- Dry Film Thickness (DFT) is 50 μm .
- After installation, STRAALTECHNIEK reserves the right to use minor repairs (Touch-up paint).
- The paint should be considered industrial grade. Inspection distance: 2 meters.

47. Work pieces, products to-be-blasted (blasting machines)

- The to-be-blasted products should be available to STRAALTECHNIEK in actual hardware at blast tests before release for production of the blast machine. A STP file, a dimensional sketch should be available. Tests are performed, before release for production. If none of the above is available, STRAALTECHNIEK reserves the right to test on a dummy product and share those results. Any product presented after signature of the contract is out-of-scope for STRAALTECHNIEK.
- Unless otherwise specified, the work pieces should have a temperature between 10°C and 60°C and should be clear of oil, grease and humidity. Cleaning products with high pressure water and drying in the blast machine equals improper use. Not conforming will result in big risk of clogging of blast media!
- Unless otherwise specified, work pieces have not been already painted before or have mm's thick rust scale. **Warning!** if work pieces do have paint or big rust scale, a special type of cleaner is required. Normal cleaners sieves will clog very quickly, causing blast media overflow and hours of cleaning and thus downtime.
- Aluminium and magnesium products are forbidden and need extra protections in the machine body and filter (Atex regulations). Not complying with this, introduces a big safety risk.
- In case of a stainless steel product: should it not become contaminated: Perform a mutual test in one of our test facilities. Unless otherwise specified, STRAALTECHNIEK doesn't guarantee a cleanliness specification from carbon steel.
- Ample work pieces should be provided by the customer for conducting tests during installation of the machine. Costs of work pieces are excluded for STRAALTECHNIEK.
- Unless otherwise specified, automated removal of blast media from the products is not included.

48. Electrical

Unless otherwise specified, the following is supplied by the customer:

- Electricity 3 phase 400 V-50 Hz, connection TN-S system (PE+N).
- Brands of PLC software, PLC hardware, Communication protocol, Frequency inverter hardware are defined by STRAALTECHNIEK.
- Only one recipe is provided within the PLC soft- and hardware
- Client supplies an electrical power supply cable to the switch box of the installation.
- The cable must be suitable for 50 Hz, 400V, 3 phases, 0 and PE and is free of "electrical waste" like influences of other machines.
- Client supplies earthing & short cut of fuses 10kVA and fuses with curve C.
- A "loss current switch" and a conductor for equipotential connection should be present.
- When using frequency controls, the differential switch should be of type B. (not sensitive to DC component, according to standard EN 50178).

49. Equipment monitoring through Internet

A working internet connection is essential to be able to monitor the STRAALTECHNIEK equipment. Monitoring the delivered equipment enables

timely support, minimizing or reducing repair or maintenance costs. And minimizing or reducing downtime. Consequences of the lack of an active internet connection could involve unnecessary extra downtime in case of breakdowns and extra repair costs. Disconnection of the equipment from a working Internet connection might leave the Warranty void.

50. Compressed air

To operate pneumatic cylinders, which are necessary for fully automatic control, the customer must provide a compressed air connection with an operating pressure of 6 bar. The compressed air should be clean and free of oil and water.

Compressed air consumption:

- Nozzle	110-1100	Nm ³ /hour
- Scrapertrack	10	Nm ³ /hour per track
- Dust collector	6-46	Nm ³ /hour
- Helmet air	30	Nm ³ /hour

Clean, dry air is required, max contents of oil: 3 mg/m³

51. Abrasives: types (blasting machines)

Unless otherwise specified, the following holds: only one agreed abrasive(s) is allowed. Whether Steel, Stainless steel, Corundum or Glassbeads, all blast media behaves differently and requires special treatment and design choices.

52. Abrasives: first filling (blasting machines)

Unless otherwise specified, the customer should purchase media with STRAALTECHNIEK:

- Wheelblast machines:	1 000	kg
- Pressure blast machines S	1 000	kg
- Pressure blast machines M	2 000	kg
- Pressure blast machines L	3 000	kg
- Pressure blast machines XL	> 10 000	kg

53. Dust (dust collectors, cyclones)

If dust to be extracted is not created by the STRAALTECHNIEK equipment, the following holds: Unless otherwise specified, the dust meets the following properties:

- Density of the dust $\geq 4000 \text{ kg / m}^3$.
- Max particle size: 100% is $\leq 2 \text{ mm}$.
- Min particle size: 95% is $\geq 30 \mu\text{m}$.

Malfunctioning of the filter due to different dust properties, leaves the warranty void.

54. Balancing & vibrations (Rotating equipment machines)

- All wheels are balanced on our electronic balancing-machine, make SCHENCK, type H 40 U, in line with the directives for unacceptable unbalance as pointed out by DIN ISO 1940 Part 1, class G 6,3.
- All fans meet with VDI Standard 2056 or ISO10816-3 for a vibration free run. When mounted fixed up to a max. of 4,5 mm/s; when mounted on vibration-dampers up to a max. of 7 mm/s.

55. Sound level (Rotating equipment machines)

- The acoustic capacities (Lw) and sound levels (Lp) as mentioned, apply each fan and are measured in the working-point according to DIN 45635 (Part 1) under free field conditions. This is applicable to the fan-sound. Flow-noises or resonances in the supplying and exhausting pipes as well as the sound-emission of such pipes are not included.
- Delivery tolerances : Delivery-tolerances according to DIN 24166, class 2.
- Capacity guarantee : According to DIN 24166. Measured according to NEN 1048-II (VDI-Standard 2044)
- Fans to be delivered with a IIB-declaration, which is necessary to obtain full CE-mark of the complete installation.

56. Test run (Rotating equipment machines)

Before each fan leaves our plant, a mechanical test-run is being performed, in which the following values will be measured:

- Amperage consumption of the electromotor;
- Vibration-level of the bearings;
- The fan's revolutions per minute (rpm).