

1. Preliminary remark

The instructions for the use of the mobile conical machines 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 Zambelli RIB-ROOF GmbH & Co. KG.

2. Weight of the mobile rollformer

Mobile conical machine RIB-ROOF Speed 500	approx. 11.500 kg
Mobile cutting machine	approx. 6.000 kg

In accordance to the 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.

3. Dimensions and space requirements

Mobile conical machine is 40ft shipper's own container with measurements of

Length : 12,19m
Width: 2,43 m
Height: 2,59 m

Mobile cutting machine is 20ft shipper's own container with measurements of

Length : 6,06m
Width: 2,43 m
Height: 2,59 m

required space for conical and cutting machine :

- 1a) for the conical machine:
^ Width: 5,00 m
 Length: 15,00 m
- 1b) required space:
 15,00 m plus longest length of profile
- 2a) for the cutting machine:
^ Width: 5,00 m
 Length: 8,00 m
- 2b) required space:
 8,00 m plus longest length of profile

- additional space requirement for intermediate stock of coil material and produced material:

- coil material:
Such a place is needed in a satisfactory largeness, according to the size of the project, not more than 100 m from the conical machine.
The road between the stock and the conical machine must be passable for a suitable lifter (fork lifter or wheel loader) to put the coils into the conical machine.
- b) produced material:
Such a place is needed in a satisfactory largeness, according to the size of the project, not more than 20 m from the profile run-out.
Additionally we want to refer to point 8 of these instructions.

4. Electric supply

It is absolutely necessary to look to it that there is an adequate electric supply available at site. The customer is responsible that the necessary power feed cable will be brought directly to the conical machine. Consumption costs are to be borne by the customer. Distance from the machine/s max. 50 m.

Mobile conical machine RIB-ROOF Speed 500:

- power supply with 400 V / 11 kVA
- connection 5-pole
- an AC/DC sensitive protective switch called "FI-Fehlerstromschutzschalter" FI F804" with 30 mA is available

Mobile cutting machine

- power supply with 400 V / 11kVA
- connection 5-pole
- an AC/DC sensitive protective switch called "FI Fehlerstromschutzschalter" FI F804" with 30 mA is available

5. Staff requirement

- The requisite machine-operator/s for handle the mobile conical and cutting machines ls/are placed at disposal by Zambelli RIB-ROOF GmbH & Co. KG.
- The equipment may only be operated by a Zambelli RIB-ROOF GmbH & Co. KG - machine operator.
- Unless otherwise specified in writing in the Zambelli RIB-ROOF GmbH & Co. KG - 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 Zambelli RIB-ROOF GmbH & Co. KG - operator on site:
 - for aluminium profiles with a length over 6 m:
each 6 m / 1 helper
 - for steel, zinc or copper profiles with a length over 6 m:
each 3 m / 1 helper

6. Operating time

- The required time depends on the demands of the production process and the extent of the contract and is determined by the 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.

7. Services to be provided by the customer at the project site

- Unloading and safe storage of the raw material (maximum weight of a double coil incl. pallet approx. 2,0 - 4,0 to) must be organized and paid by the customer
- Suitable offloading equipment for the rollforming machines (40ft container, and 20ft container weight see no: 2) for loading and unloading the machines off and onto the transporting vehicle
- Providing a stacker truck suitable for ground on site (2,0 -4,0 to) or another suitable hoist to unload and transport the coils to the hydraulic lifting gear of the conical machine
- Providing a sufficient quantity of square-shaped timber or boards to place under the produced profiles (intermediate storage)
- Suitable lifting gear (e.g. spreader beam etc.) as well as lifting beams for the maximum profile length (maximum profile length less approx. 2,5 m left & right) for lifting the Zambelli RIB-ROOF GmbH & Co. KG - profiles onto the roof
- The customer is to ensure appropriate cordoning off of the production area, especially in the region of the panels run-out, in accordance with the general safety regulations and the instructions of the machine operator

- The costs for the distribution and supply of power respectively fuel for the aggregate (for conical machine and cutting machine production and if necessary the site containers on site) are the responsibility of the customer
- 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

8. Intermediate storage

For the intermediate storage of raw material (coils) the client is responsible for seeing that

- the stockyard is clean and has a level surface
- the coils are stored on a wooden base
- not more than 2 coils are stacked on top of each other
- the coils are protected against rain and moisture

Produced 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.

9. Passing of risk

- The transfer of perils (from the producer to the customer) for damages to the RIB-ROOF - panels takes place after the panels leave the conical machine. For the period of temporary storage of coil material, from point of time of delivery until end of production respectively collection of remaining coil material, 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 RIB-ROOF - 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

Instructions for the use of the mobile conical and cutting machine at site

- Delays which are not caused by the machine operator are charged to the customer and will be invoiced with 250 €/day
- If moving of the rollforming machine is necessary, due to demand of the customer or a third party, the resulting costs will be charged to 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 Zambelli RIB-ROOF GmbH & Co. KG or rather with our co-ordination office

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- Profiling at an outdoor temperature less than 5 degrees Celsius is only possible if the coils had been stored tempered at minimum 10 degrees Celsius and are free of frost and ice
- Folding the sheet panels at temperatures below 5 degrees Celsius can lead to problems (e. g. material breakage)
- An evaluation of the production area regarding the suitability or facility for rollforming at site can be made by Zambelli RIB-ROOF GmbH & Co. KG, 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 Zambelli RIB-ROOF GmbH & Co. KG - working staff
- In case of interruption of production due to bad weather the Zambelli RIB-ROOF GmbH & Co. KG - 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 RIB-ROOF profiles produced by Zambelli RIB-ROOF GmbH & Co. KG - 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