

DELIVERY CONDITIONS FOR HYDRAULIC AND MECHANICAL CLAMPING DEVICES

(current status as of May 2017)

Note: In the following text the company Haff & Schneider GmbH & Co. OHG, Obere Wank 2, 87484 Nesselwang is referred to as Haff & Schneider.

1. General

For all orders of hydraulic and/or mechanical clamping devices confirmed by us, the following terms of delivery shall apply for the duration of the business relationship in addition to the general terms of business - sale. Deviating, conflicting or supplementary general terms and conditions of purchase or business shall not be valid even if we do not expressly object to them in individual cases, unless we have expressly accepted these terms and conditions in writing beforehand. The invalidity of individual provisions of this contract or its parts shall not affect the validity of the remaining provisions. The contracting parties shall be obliged in good faith and within reason to replace an invalid provision with a valid provision equivalent to its economic success, provided that this does not result in a significant change to the contents of the contract. The same will apply if a situation requiring regulation is not expressly regulated.

2. Directives and Standards / CE Marking

All requirements regulated by the German Device and Product Safety Act are met. The requirements of the Machinery Directive, the Electromagnetic Compatibility Directive and all other product-relevant European standards and directives in their latest version are complied with where applicable. In principle, the declaration of conformity, the documentation and all documents listed in the Machinery Directive or other directives are enclosed with the delivered product.

The declaration of EC conformity is always made in written form and in German and is enclosed with the delivered product.

3. Confidentiality Agreement

In general, starting from the time of submission of the tender Haff & Schneider undertakes to maintain strict confidentiality and secrecy vis-à-vis third parties with regard to all drawings, data and information that have come to their knowledge in the respective project and that have been discussed, negotiated, presented, defined and handed over by the client or its end customer, irrespective of the type and form of such drawings, data and information, or that Haff & Schneider has come into its possession. The same provision shall also apply in the event of any subsequent placing of an order by the customer; if necessary, a separate confidentiality agreement shall be concluded.

4. Construction Procedure

- a. Haff & Schneider fixtures are designed in Creo Parametric
- b. The exchange of 3D data with customers is usually in step format.
- c. Design of the fixture: As a rule, the fixtures consist of ground, bolted or pin-ended plates (modular principle). The individual parts are usually screwed together with DIN 912 x 10.9 Allen screws.
- d. The oil supply for the hydraulic elements is carried out by means of deep-hole bores. Pipelines are only installed at the customer's request or if the oil supply is not otherwise detachable for various other reasons. The deep-hole bores preferably have a bore diameter of 8 mm or 10 mm and are closed with R 1/8 or R 1/4 screw plugs.
- e. The material-conducting holes are marked internally in CAD at Haff & Schneider with the following colours:
 - Red = Clamping
 - Green = Releasing
 - Yellow / Orange = Connection of the tension cable
 - Light / dark blue = Air tube for confirmation prompt
- f. For easy loading of the device, positioning assistants are provided, which also serve to prevent incorrect positioning of the workpieces. Suitable tools such as roller levers, spring-loaded pressure pieces or similar are provided for holding the workpieces during positioning.
- g. Depending on requirements, individual components in contact with the workpiece are case-hardened or plasma-nitrided. Further surface or material treatments are only carried out in consultation with the customer or if these are required.
- h. As a rule, support and positioning pins are adjusted by means of adapter plates; they may be fixed if low demands are made on the accuracy of the workpieces. The accuracy is determined on the basis of the workpiece to be manufactured.
- i. As standard, the fixture is equipped with a reference bush and reference pins, which serve as a reference to the interface on the machine pallet.
- j. The device is marked with a Haff & Schneider nameplate, and an information plate with the coordinates of the reference bush is also attached. The signs are fixed permanently by way of grooved studs.
- k. In principle, a machine collision check is carried out during the design of the clamping device. In addition, a collision check is carried out with critical tools; the data required for this must be provided by the customer.
- l. Rotary eye bolts are used for lifting the fixture; these are usually fastened in the centre of gravity of the fixture.
- m. All holes and threads in the drawings of the base plate, mounting plate, strips, etc. are usually indicated with table coordinates.

5. Customer Acceptance

The customer's acceptance of the fixture always takes place on-site at Haff & Schneider in Nesselwang, Germany. The functional test of the fixture is carried out by way of the workpiece for the machining of which the fixture was designed; the workpiece must be provided by the customer.

6. Documentation

- a. The documentation how to use the fixture is carried out in accordance with Directive 2006/42/EC, one copy of which is supplied in a paper version. The documentation contains the operating instructions. In addition, the attachment contains the Declaration of Conformity (for hydraulic clamping devices), the release protocol, the final inspection protocol, the measuring protocol and the assembly drawings with parts lists.
- b. The documentation plus the component drawings and 3D models in step format on CD are offered as a separate item.
- c. The fixture drawing of the main assembly for hydraulic clamping fixtures usually consists of:
 - Sheet 1: Information sheet with balloons
 - Sheet 2: Dimension and set-up sheet
 - Sheet 3: Hydraulic plan
 - Sheet 4: Customer sheet with customer-specific information
- d. The dimension and set-up sheet is the basis for measuring the fixture on the measuring device. This results in the measuring protocol with the dimensions for position and support points (P1, P2, ff. for position points and A1, A2, ff. for support points) and the reference bushing and reference point.
- e. In the hydraulic plan, all clamping devices, valves, support elements, etc. used are listed with their designations on sheet 3. In addition, the hydraulic plan contains the general layout drawing with designation of the individual valves.
- f. Assembly drawings contain on the one hand the clamping point as an individual assembly, as well as all wear and spare parts.

7. Terms of Delivery

In principle, the delivery specification "EXW" ("ex works") according to Incoterms 2010 applies. However, other delivery conditions may be agreed for individual projects; these must then be set out in writing in the offer.

8. Terms of Payment

In general, the terms of payment of the General Terms and Conditions - Sale shall apply in the currently valid version unless it has been agreed otherwise in an individual contract.

9. Attrition and Spare Parts Lists / Availability of Spare Parts

The attrition and spare parts lists shall be made available by Haff & Schneider at the latest upon delivery of the device to the customer. In the case of a warranted guarantee, attrition and spare parts are only the items listed in the respective list.

The attrition and spare parts lists are compiled by Haff & Schneider in such a way that the following components are listed for the respective assemblies:

- the designation of the individual parts and assemblies
- the article number of Haff & Schneider
- the number of pieces of the respective individual part and assembly group
- the valid unit price per part / assembly
- the delivery time of the respective individual parts and assemblies

Furthermore, Haff & Schneider guarantees and takes into account the availability of spare parts for parts and / or assemblies to be purchased of the devices to be supplied over a period of 10 years, calculated in each case from the date of the offer, when preparing the offer and placing the order.

10. Warranty / Guarantee

Haff & Schneider provides a guarantee, i.e. a material and limited support personnel guarantee (i.e. free installation by mechanics within the D-A-CH region in the event of a warranty claim) for a period of 24 months, irrespective of whether the clamping device is used in single-shift or multi-shift operation. The warranty period begins with the successful final acceptance by the end customer, and ends no later than 30 months after delivery of the fixture, provided that the delays are not the fault of Haff & Schneider. Excluded from the guarantee are parts subject to attrition which Haff & Schneider has specified in advance in a list of parts subject to attrition.

11. Services provided by Haff & Schneider

If the customer requires technical assistance, Haff & Schneider guarantees a continuous availability and commitment by technically experienced employees and a proficient support team (for customer service and spare parts) during the usual business hours from Monday to Thursday from 7:00 a.m. to 4:00 p.m. and on Fridays from 7:00 a.m. to 12:00 noon CET.

If the telephone support does not lead to a solution of the problem at short notice, Haff & Schneider guarantees that within the European Economic Area (EEA), including Switzerland, an experienced technician will be sent to the location of the device within 48 hours of receipt of the fault / malfunction report at the latest, and will immediately initiate the defect to be remedied and try to find a solution. If the repair cannot be carried out on site, the device must be sent to Haff & Schneider so that a thorough analysis of the defect and a repair can then be carried out in the Haff & Schneider factory.

Haff & Schneider also guarantees that services and deliveries of all spare and attrition parts will be carried out within the above-mentioned response and operating time.

If a project is handled by a machine manufacturer, the central service of the machine manufacturer is the contact for the end customer in the event of a defect or damage. The central service department initiates and coordinates all necessary troubleshooting measures. In the first step, the central service department of the machine manufacturer clarifies the problem with an on-site technician and try to find a solution. Should this not lead to a solution, Haff & Schneider guarantees telephone assistance during the business hours stated above. If the problem cannot be solved, Haff & Schneider guarantees that an experienced technician will be at the end customer's site at short notice to solve the problem. If the repair cannot be carried out on site, the device must be sent to Haff & Schneider so that a thorough analysis of the defect and a repair can be carried out in the Haff & Schneider factory.

Haff & Schneider does not assume any costs for service calls by its employees and any necessary shipments of materials and equipment outside the granted guarantee period.