



## TERMS & CONDITIONS (PROCESSING)

### TECHNICAL STANDARDS

#### 1. GENERAL

- 1.1 All construction products which fall within the scope of the harmonised European Standard after the 1st July 2013 are supplied to AJN Steelstock Ltd as CE compliant.
- 1.2 According to the Construction Product Regulation (305/2011) all Fabricated Steel Products placed on the market by AJN Steelstock Ltd are CE marked after 1st July 2014.
- 1.3 The Declaration of Performance (DoP) serves to deliver the information about the essential characteristics of the product that AJN Steelstock Ltd is making available on the market.
- 1.4 All the information supplied with the DoP is obtained by strictly applying the methods and criteria provided by the relevant harmonised standard.
- 1.5 The various DoP's can be viewed and downloaded at <http://www.ainsteelstock.co.uk/downloads-resources/>
- 1.6 A CE mark indicates that a product is consistent with its Declaration of Performance (DoP).
- 1.7 Manufacturing is in accordance with BS EN1090-2, EXC2 (unless otherwise stated)

#### 2. DRAWINGS

##### 2.1 DSTV/NC Files

- 2.1.1 It is the customer's responsibility to check that files supplied are correct and are the final issue.
- 2.1.2 Components will be manufactured to the DSTV/NC file and not to any accompanying drawings.
- 2.1.3 Quantities of components produced will be the quantities specified in the DSTV/NC file unless written instructions are given to the contrary.
- 2.1.4 Where Top Flange Unpainted has been specified the unpainted flange will be the top flange contained within the DSTV/NC file.
- 2.1.5 Plates will be supplied as a 2D component. Any through thickness shaping must be advised and alternative drawings supplied.
- 2.1.6 Raised flooring patterned faces are not detailed on DSTV/NC files. Files for this material must be accompanied by PDF or other drawings that show how components are handed.

##### 2.2 StruCad Models

- 2.2.1 Models must be fully updated, marked and saved prior to enquiry to ensure NC files are final issue.

##### 2.3 Cad Files

- 2.3.1 DXF/DWG files must be full size with a scale of 1:1. Manually over written dimensions will not be accepted.
- 2.3.2 Text can be lost during import and must be sent separately.

##### 2.4 Hand Drawings

- 2.4.1 Faxes distort during sending so fully dimensioned detailing required.
- 2.4.2 Where Drawings are provided instead of DSTV/NC files parts must be manually programmed. Drawings of the programmed parts will be sent for customer approval, they are a copy of what will be manufactured and must be checked thoroughly.
- 2.4.3 Manufacture will not commence until approval is given.

#### 3. THERMAL CUTTING

- 3.1 Unless otherwise specified Profiles are cut using High Performance Plasma which produces a slight edge taper.
- 3.2 Holes in these profiles will be thermally cut using "True Hole" technology producing "bolt-hole" quality. We cannot guarantee however that a tolerance of +/- 0.5 mm can be adhered to. Should hole tolerance or taper be critical you must request drilled holes.
- 3.3 Drilled holes are only included if stated on our quotation.
- 3.4 A light coating of oil in areas around drilled holes will be present due to processing.
- 3.5 Drilled plates may have a combination of plasma and gas cut edges.
- 3.6 All plates above 55mm will be flame cut. Profiles less than 55mm thick will only be flame cut if requested.
- 3.7 Re-entrant corners and notches on cut-outs will be detailed with a standard 10 mm corner radius, regardless of execution class. Where models or DSTV/NC files are supplied, any cut-out will be supplied as specified in the file rather than the drawing.
- 3.8 The profile on thermally cut edges may occasionally fall short of the requirements of BS EN ISO 9013:2002 7.2.3 and may require light finishing by customers to meet the requirement.
- 3.9 Long narrow components are liable to distort and may not remain flat or straight. Should flame straightening be required it is the responsibility of the customer to arrange this through a qualified party.
- 3.10 Edges of profiles will be hardened by the thermal cutting process. Edge hardness testing suggests thermally cut S355 material may require up to 0.8mm removed from cut edges and S275 material may require up to 0.5mm to reduce edge hardness below 380 Hv.

#### 4. MANUAL THERMAL CUTTING/ NOTCHING

- 4.1 Notching of sections is carried out using a hand held thermal cutting process and may result in cut edge hardness exceeding 380 Hv. AJN Steelstock cannot test this process as manual cutting will not give consistently repeatable results. It is therefore not CE Certified. Notches may be dressed to remove sharp edges and cutting defects. The customer must determine how much material may need removing to reduce edge hardness before it is fit for purpose.

#### 5. MARKING

- 5.1 Parts processed on automatic lines can be hard stamped or etched with identification on request. All other parts will be marked with paint markers. Parts that are to be galvanised should be identified so a compatible marker can be used.

#### 6. MATERIAL

- 6.1 Unless otherwise specified material is supplied as self-colour. Beams and columns may be stored externally and may be subject to surface oxidation. Hollow and bright sections may be covered in a preservative oil. With the exception of some sheet materials, products cannot be guaranteed to be rust free at the point of delivery.
- 6.2 If no 'EN' specification is requested on Hollow Sections at the enquiry stage then we reserve the right to quote this product "Cold Formed" (BS EN 10219) or "Hot finished" (BS EN 10210). This will be advised on the quotation.
- 6.3 Grade; where the word 'Minimum' or 'Min' appears on the grade we reserve the right to supply material of a superior Charpy designation at our discretion. i.e. EN10025 S355 JR Min, could be supplied as EN10025 S355 JO.



**7. PACKAGING**

7.1 Any special packaging requirements must be agreed prior to order being placed

**8. SHOTBLASTING & PAINTING**

8.1.1 Most sections and profiled parts can be shotblasted and painted upon request.

8.1.2 The SHOTBLASTING process generates heat which may cause the straightness tolerances to be challenged. The most common affected sections are Channels and Tubes.

8.1.3 Material that is <=5mm thick may distort when Shotblasted. AJN Steelstock Ltd will not accept responsibility if this process is requested on these products.

**8.2 SHOTBLASTING ONLY**

8.2.1 Parts and sections are blasted to minimum SA2½, the surface finish of blast only material can only be guaranteed at the time of blasting as it quickly deteriorates during the distribution process. This material can be wrapped on request to postpone deterioration.

8.2.2 We are unable to guarantee that shotblast only material will not have paint residue on the material

8.2.3 It is impossible to avoid small deposits of shot getting into tubes.

**8.3 PAINTING**

8.3.1 Painted material is shotblasted to minimum SA2½ then coated with a minimum 30 microns of pre-fabrication primer. This shop primer only affords temporary protection. Sections are painted prior to further processing, and this coating may be damaged during handling and processing

8.3.2 Cold formed hollow sections may be oiled and this can reduce the adhesion of the primer coating. Primer adhesion on these products cannot be guaranteed.

8.3.3 Full specification of the primer paint can be provided upon request or it is available on our website <http://www.ajnsteelstock.co.uk/downloads-resources/>

**9. SAWS**

9.1 We are unable to deburr material after sawing and Customers are advised to take the necessary Health & Safety precautions to prevent the possibility of accidents

9.2 All lengths shown on mitre cutting are to be advised as long to long/overall measurements.

**10. HANDLING**

10.1 Mechanical handling can cause surface scratches, Customers are requested to advice if a scratch free surface is required prior to order.

10.2 Although we cannot guarantee a scratch free product, we will endeavour to keep the scratching down to a minimum.

**11. DELIVERY**

11.1 Once our driver has checked and unchained his load, it becomes the responsibility of the Customer to ensure that the delivery is made in a safe manner. The driver is not allowed to operate any lifting equipment and will only assist if, in his opinion, the delivery can be made safely and without risk. Our drivers have the full support of the company to abandon any delivery that they feel is unsafe.

11.2 Delivery dates are given as a guidance only and are not guaranteed.

**12. CREDIT CONTROL**

12.1 Stock will not be reserved until credit clearance has been achieved. Delays may subsequently mean that stock has been sold elsewhere

12.2 Delays due to credit issues may adversely affect ultimate delivery dates

**PROCESSING TOLERANCE TABLE**

Process	Tolerance	Notes
Saw	+/- 2mm	up to 10m length
	+/- 3mm	above 10m
Mitre cut	+/- 1 degree	
Holes	+/- 2mm	
Thermal cut	+/- 3mm	1) Edges will have a bevel to the cut 2) Flatness cannot be guaranteed but we will endeavour to keep the material as flat as possible

Measurement and checks of cut and processed products are performed using calibrated class 2 tape measures. The achievable tolerance and overall accuracy of the measurement process may be limited by this.

**CE MARKING CLASSIFICATION TABLE**

<b>Execution Class</b>	<b>Quality Level</b>	<b>Example Usage</b>	<b>Test Cert</b>	<b>Traceability</b>
<b>EXC1</b>	Elementary	Buildings of minor importance for public safety, e.g. agricultural, farm buildings etc.	N/A	Not required
<b>EXC2</b>	Standard	Normal buildings (Ordinary buildings, not belonging in the other categories)	2.2/3.1	Partial
<b>EXC3</b>	Comprehensive	Buildings whose seismic resistance is of importance in view of the consequences associated with a collapse, e.g. schools, assembly halls, cultural institutions, bridges etc.	3.1	Full
<b>EXC4</b>	Comprehensive	Special structures (i.e. buildings whose integrity during earthquakes is of vital importance for civil protection, e.g. hospitals, fire stations, power plants, etc.)	3.1/3.2	Full