

Instructions

for the Use of the Mobile Roll Forming
Machine on Site

Zambelli RIB-ROOF GmbH & Co. KG

1. Preliminary remark

The instructions for the use of the mobile roll forming machine constitute an integral part of this agreement, shall be binding upon both Parties and shall be firmly agreed. At the same time the instructions regulate the demarcation of the services between the Customer and Zambelli RIB-ROOF GmbH & Co. KG.

2. Weight of the mobile profiling machine

Mobile profiling machine RIB-ROOF Speed 500 max. 18,000 kg

Mobile profiling machine RIB-ROOF 465 max. 14,500 kg

Mobile profiling machine RIB-ROOF Evolution max. 9,000 kg

Depending on the weight, the Customer shall ensure that the access road to the construction site and its subsoil are reinforced for the road transport. If it cannot be guaranteed, the Customer shall take appropriate measures and shall bear costs for all necessary relocations or similar.

3. Dimensions and space requirements

Dimensions:

The mobile profiling machines are located in their own 20/40ft containers with the following dimensions.

Profiling machine RIB-ROOF Evolution

Length: 6.06 m

Width: 2.44 m

Height: 2.59 m

Profiling machine RIB-ROOF Speed 500/465

Length: 12.19 m

Width: 2.44 m

Height: 2.59 m

Required space:

a) For the profiling machine (container) incl. lateral space for coil change

Width: 5.00 m

Length: 15.00 m

b) Total required width:

Width: Profiling machine + lateral space for coil change

- c) Total required length:
Profiling machine + max. length of profiled sheets + 3 m working space

Additional space for intermediate storage:

- a) Coil material:
Sufficient storage space in accordance with the size of the construction project, in the vicinity of not more than 100 m away from the profiling machine.

The path between the warehouse and the profiling machine must be accessible for the appropriate hoisting equipment (forklift truck or wheel loader) to lift and put the coils into the profiling machine.

- b) Produced profiled sheets:
Sufficient storage space is required in accordance with the size of the construction project, in the vicinity of not more than 20 m from the exit of the profiled sheets.

4. Staff requirements

- A machine operator required to operate the mobile profiling machine shall be provided by Zambelli RIB-ROOF GmbH & Co. KG.
- The profiling machine shall only be operated by the machine operator being a staff member of Zambelli RIB-ROOF GmbH & Co. KG.
- Unless otherwise stipulated in the written form in the Zambelli RIB-ROOF GmbH & Co. KG offer, the Customer shall defray all the expenses if auxiliary workers need to be provided for the receipt, lashing of bundles, storage of the produced profiled sheets as well as assembling and dismantling of the mobile machine.
- The required number of auxiliary workers depends on the length of the profiled sheets (handling procedures) to be produced and the material to be processed. The following specifications are guide values; the final quantity shall be determined by the machine operator of Zambelli RIB-ROOF GmbH & Co. KG on site:
 - for aluminium sheets with the length exceeding 6 m:
 - every 6 m / 1 assistant
 - for steel, zinc or copper sheets with the length exceeding 6 m:
 - every 3 m / 1 assistant
 - for assembling and dismantling of the mobile profiling machine:
 - 2 assistants for each process

5. Working time

- The time required depends on the requirements of the production process and the scope of the contract and shall be determined by the machine operator in consultation with the responsible bodies.

- Normal working hours:
 - Monday-Friday: 10 hours per day (incl. 1-hour break)
 - Saturday, Sunday and holidays: 8 hours per day (incl. 1-hour break)
- No extra costs are charged for work on Saturdays. In case of high time pressure, the Customer and the Supplier can agree on working on Sundays and public holidays against corresponding additional charge.

6. Services to be provided by the customer on site

- Unloading and safe storage of the production material (maximum weight of a double coil incl. pallet approx. 3.0 - 4.0 t).
- Appropriate hoisting equipment for loading and unloading of the profiling machine (20 /40 ft container, see specified weight in point 2) from and onto the transport vehicle.
- Provision of a forklift truck suitable for the construction site (3.0 - 4.0 t) or of other suitable hoisting equipment for the unloading and transporting coils to the hydraulic lifting gear of the profiling machine.
- Provision of a sufficient quantity of squared timber or timber formwork planks which are to be placed under the manufactured profiled sheets (intermediate storage).
- Appropriate lifting equipment and spreader beams for the maximum length of the profiled sheets (maximum profile length less approx. 2.5 m on the left and right) for lifting of the profiled sheets onto the roof.
- Appropriate access blocking off to the production area, especially to the area of the profiled sheet exit, in accordance with the general safety regulations and instructions of the machine operator.
- Disposal of the production waste and packaging material.
- Securing the supplier's machines, coils and accessories against theft and damage.

7. Intermediate storage

In terms of the intermediate storage of profiled sheets or the production material (coils) the Customer shall be responsible for:

- maintaining the storage area in a clean condition and ensuring an even surface
- storing the coils on a wooden base
- making sure that no more than 2 coils are stacked on top of each other
- ensuring that the coils are protected against rain and moisture

Produced profiled sheets are to be stored on squared timber or timber formwork planks on clean ground. It is significant to store the profiled sheets lengthwise slightly inclined.

8. Transfer of risks

- Risks of damage to the profiled sheets shall pass from the Manufacturer to the Customer after the profiled sheets have left the profiling machine. For the time of intermediate storage of coil materials, from the delivery until the production end or collection of the remaining coil materials, the risk and liability lie with the Customer.
- Profiled sheets damaged during the transportation or lifting onto the roof, which therefore need to be produced again, must be specified and invoiced separately.
- The Customer is obliged to check the quality and dimensions of the profiled sheets immediately after the profiled sheets have left the profiling machine; subsequent complaints can no longer be filed.
- No claims can be filed after the profiled sheets have been transported to the construction site or during the installation on the roof (e.g. scratches, deformations, surface damage, etc.).

9. General remarks

- The Customer is liable for all occurring accidents. The Customer is also to prepare the construction site in accordance with the local safety regulations and to appropriately instruct the machine operator and auxiliary workers. The Customer shall bear all costs therefor.
- The Customer shall bear all costs for delays which have not been not caused by the machine operator and shall be charged 450 €/day.
- Should it be necessary to move the profiling machine at the request of the Customer or a third party, the Customer shall be charged for the costs incurred.
- The members of our operating staff are not authorized to accept and implement changes to the contract. If required, this shall be agreed with Zambelli RIB-ROOF GmbH & Co. KG or with the order processing office.

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- Profiling at outdoor temperatures below 5 degrees Celsius is only possible if the coils has been stored free of frost and ice at least at 10 degrees Celsius.
- Profiling of the sheets at temperatures below 5 degrees Celsius can lead to problems (e.g. material fracture).
- Assessment of the production area regarding its suitability for on-site roll forming can be carried out by Zambelli RIB-ROOF GmbH & Co. KG together

with the responsible bodies. The date shall be determined in advance and the costs incurred shall be invoiced.

- Free use of the facilities available on the construction site (laundry, changing rooms and WCs, telephone, fax and email service for the machine operator) shall be provided to the workers of Zambelli RIB-ROOF GmbH & Co. KG.
- If the production process is interrupted due to bad weather conditions, the workers of Zambelli RIB-ROOF GmbH & Co. KG shall be allowed to leave the construction site after a three-hour waiting period and continue working next day or under better weather conditions.
- The RIB-ROOF profiled sheets produced by the workers of Zambelli RIB-ROOF GmbH & Co. KG are specified in a bill of materials including such measurements as length and width.
- A responsible representative of the Customer shall be obliged to check these measurements and confirm them by signing the document.