



GENERAL TERMS AND CONDITIONS FOR POWDER COATING AT MODERN METAL SP. Z O.O.

Opole, 24 November 2017

- Modern Metal Sp. z o.o. shall not warrant or be liable for the quality of re-coated elements.
- Re-coating – an extra charge in excess of the prices specified in the price list shall be applicable; 1m² +10%.
- In the case of profiles of different lengths, a 10% extra charge in excess of the prices specified in the price list shall be applicable.
- A 15% extra charge for each 1m² shall be applicable in the case of the colours specified in the price list and available in the mat or structure variant.
- Calculation of the surface of coated elements in the case of aluminium and steel sections – 100% of the external surface. In all other cases, for one-sided coating (sheets, chimney flashings), the surface shall be calculated in the following manner:
 - 0 - 0.15m – total surface;
 - 0.15 - 0.25m – coated surface +50%;
 - over 0.25m – coated surface.
- Indicated prices are net values (+23% VAT).
- Payment terms: first three orders shall be paid with cash or in advance, subsequent orders – to be arranged.
- In line with article 589 of the Polish Civil Code, the product shall remain the property of Modern Metal until the full sale price has been paid. Failure to pay the price within the agreed deadline shall result in a recollection of the product by Modern Metal.
- In the case of enquiries sent via e-mail, an offer with a cost estimate shall be prepared on case-by-case basis.
- The deadline for completion of the order shall be agreed on with the manager of the powder paint shop based on the production planning schedule.
- The surface to be coated must be raw (not subject to any previous processing/treatment).
- Coated material subject to mechanical processing shall be made according to the instructions specified in the catalogue, i.e. raw aluminium cross sections (cut locations) shall be protected with a two-component adhesive or silicone.
- Coated elements shall not be subject to mechanical processing (bending, rolling, etc.).
- Even though all hot-dip galvanised elements are subject to the gas stripping process, outgassing from the galvanised surface may occur, which shall not be considered a valid reason for complaints related to further treatment, i.e. powder coating.
- With strong colours, considerable differences in shades may be visible when coating various types of materials (carbon steel, aluminium, galvanised steel).
- We recommend using a primer suitable for particular types of materials (carbon steel, aluminium, galvanised steel) prior to powder coating process in order to eliminate the difference in shades, particularly when coating elements which are components of larger structures.
- A quality acceptance inspection for coatings is carried out according to Qualicoat standards prior to prefabrication of the elements. Materials for which a complaint is made must not be previously processed.
- Please specify the side to be coated in the coating job order. Otherwise, the entire element shall be coated.



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- When placing an order for powder coating, the customer shall specify the location for hanging on the elements (process holes); otherwise, the contractor shall have the right to refuse to complete the order or to provide the service, as the contractor shall deem fit (according to its engineering experience) – in such a case any and all liability for the preparation and setting of the process holes for hanging the coated elements shall be excluded.
- Each order shall include material specification for the delivered elements (primarily its thermal resistance). In the event no such information is provided, Modern Metal shall not be liable for any unwanted effects resulting from the applied powder coating technology.
- Upon accepting an order for powder coating using a specified RAL colour, if the same colour is to be used in the future for the purpose of a follow-up job, the customer shall make a request to keep the paint in order to be able to reproduce the original colour and shade.
- When sections and other elements are coated, allow for scrapping of approximately 2 cm on each side due to suspension marks.
- Galvanised surface of products to be coated shall meet the requirements stipulated in PN-EN-ISO 1461 *Hot dip galvanized coatings applied on steel articles (individual galvanising) – requirements and tests*, which is a translation of a German language version of EN-ISO 1461:1999, which introduces the international standard ISO 1461:1999.
- No warranty is given for and no complaints shall be accepted in the case of coating of castings.
- Coating irregularities may occur on galvanised elements due to uneven galvanisation – these shall not be the basis for complaints.
- Welds at joints must be 100% sealed in order to prevent the ingress of blasting medium and chemical bath inside the element, which could lead to reduced adhesion of the coating, corrosion at those spots as well as coating defects – these shall not be considered a valid reason for complaints.
- Coated profiles damaged mechanically and chemically or exposed to an aggressive agent or environment during their use shall not be covered with the warranty.
- Powder coatings made using the paint delivered by the customer shall be covered with the warranty provided the powder paint in question was manufactured by a company holding a valid Qualicoat certificate, the packaging is originally sealed and the product is not expired. Along with the powder paint, the customer shall deliver the process specification (duration and temperature of polymerisation, static electricity charge during spraying).
- The warranty shall not cover coated elements in the case of which defects discovered during their use do not exceed 5% of their surface.
- The warranty shall not cover elements where coating defects are due to coating exposure to temperatures above 60°C.
- The warranty shall not cover coated elements prepared for transport, i.e. wrapped with a plastic wrap/stretch film, if exposed to high temperatures (above 45 °C).
- Coated material must be stored in a dry and well ventilated room, where it is protected against exposure to weather conditions.