

## 01. Preliminary remark

The instructions for the use of the mobile curving machine 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 BEMO SYSTEMS GmbH.

## 02. Weight of the mobile curving machine

BEMO is using its different curving machines according to the special requested conditions and profiles. Information about the curving machine coming into operation at your project and its corresponding weight can be obtained in our office in Ilshofen-Germany.

BEMO SYSTEMS GmbH  
Max-Eyth-Str. 2  
74532 Ilshofen - Germany  
Tel.: +49 - 7904 - 29899-60  
Fax: +49 - 7904 - 29899-61  
Mail: [sales@bemo.com](mailto:sales@bemo.com)

As rough indication you can calculate with the following max. weight – without guarantee:

### For curving tapered & MONRO BEMO panels:

Machine is installed in a 20" container approx. 6.500 kg

Occasionally BEMO sends the machine with a transport agency by truck. In such a case the weight of the vehicle is approx. 40 to. The exact details please ask at BEMO office.

In accordance to the total 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 trans-loading, moving or similar.

## 03. Dimensions and space requirements

- Space required for curving:

**The curving machine should be located close (max. 20 m) to the storage area of the straight standing seam profiles.**

- a) For the curving the space need to be considered as follows:
  - Curving machine
  - Lateral space for the storage
  - Inlet and outlet of the curved panels (panel length x 2)
  - Working space (3.00 m each side)

Based on this you have the following calculation:

- b) Required overall width:  
Machine + rising of vault of the curved panels + storage space
  - c) Required overall length:  
Machine + longest profile length x 2 + working space 6.00 m
- Additional space requirement for the intermediate storage of the curved sheets is to be provided in sufficient scale in accordance to the size of the project near the panel run-in and run-out.

Additionally we want to refer to item 12 for storage of these instructions.

## 04. Electric supply

It is **absolutely** necessary to look to it that there is an **adequate electric supply** available at site.

- Distance from the curving machine: max. 50 m
- Connection: 5 - pole Cekon – socket  
32 Ampere  
(3 x 380 V +/- max. 5 % +N+PE)
- Frequency: 50 Hz +/- max. 1 %
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- Emergency power generator (if used): Connected load: on request
- If using fuse (FI) safety system an idle current of min. 300 mA from our machines is to be taken into account (FI class B).
- Each curving machine is fuse protected that the engines do not work when the power is lower!
- A stable and constant power supply must be guaranteed. Unexpected power interruptions or power fluctuations can lead to malfunctions and damage to the machines!

Any downtime and repair work are to be borne by the client.

## 05. Safety regulation

- The curving machine has for health and safety protection a photocell in front of the rollers and an emergency switch-off.
- The machine could be operated (start + stop) from outside of the container.
- The BEMO staff will be equipped with the standard dress code for site working:
  - ✓ Safety boots with steel caps and soles
  - ✓ Helmets (without chin holder)
  - ✓ Security jackets
  - ✓ Working trousers (long)
  - ✓ Gloves
- In case there are additional local safeties regulations the customer has to inform BEMO at least 4 weeks before leaving of machines and staff from Germany.

## 06. Staff requirement

- The requested machine-operator for operating the mobile curving machine is provided by BEMO.
- The equipment may only be operated by a BEMO machine operator.
- The customer has to provide assisting workers at his own expense for the handling and storage of the produced panels.
- The necessary number of support-people depends on the length of the panels to be curved (handling) and the material to be processed. The following details are guide values, the definitive quantity is to be settled with the BEMO - operator on site:
  - For aluminium profiles with a length over 8 m:  
**each 8 m / 1 helper x 2 (run-in and run-out)**
  - For steel, zinc or copper profiles with a length over 6 m:  
**each 3 m / 1 helper x 2 (run-in and run-out)**

## 07. Operating / Working time

- The required time depends on the demands of the production process and the size of the project 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.

## 08. Permissions

- The local required working permissions for the BEMO employees have to be organized by the customer.
- The permissions to enter the construction site and work there have to be organized by the customer for the BEMO employees and their vehicles.
- The client is responsible for all Visa and Work permissions, Medical Controls, Safety trainings or regulations etc.  
He has to inform BEMO at least 6 weeks before leaving of machines and staff from Germany about them and request from BEMO to provide documents in a reasonable time. Local actions have to be organized by the customer.

## 09. Daily production reports

- The BEMO profiles curved by the BEMO operator will be specified in a production list / daily report, stating the number of pieces, length and width.
- The customer has to announce responsible person(s) for signing the daily reports and confirm the quantities, dimensions and proper quality of the curved panels.
- BEMO is entitled, without any penalties, not to go ahead with the production, if the previous daily report is not signed and stamped by the customer.

## 10. Site office / Local accessibility

- The site office and equipment could be used free of charge from the BEMO staff.
- The customer will provide free of charge a desk inside their site office for the BEMO staff.
- Permanent internet access is free of charge available in the site office.
- If the on-site production is longer than 1 week, the customer has to provide for the BEMO operator a mobile internet flat and a local phone number.

The costs for the mobile internet flat and local phone number could be separately charged to BEMO as expenses of the number.

## 11. Services to be provided by the customer at the project site

- Suitable loading equipment for the curving machine for loading and unloading the curving machine off and onto the transporting vehicle.
- Providing a sufficient quantity of square-shaped timber or boards to place under the produced or curved profiles (intermediate storage).
- Suitable lifting belts (e.g. straps etc.) as well as lifting beams for the maximum profile length (maximum profile length less approx. 2.5 m left & right) for lifting the curved BEMO - profiles onto the roof.
- The customer is to ensure appropriate cordoning off of the production area, especially in the region of the panel run-out, in accordance with the general safety regulations and the instructions of the BEMO machine operator.
- The costs for the distribution and supply of power and for the curving machine if necessary the site containers are the responsibility of the client.
- At delivery by truck, the uncurved/straight profiles are to be unloaded at the construction site by the client and at his charge and stored in accordance with the curving area.
- The client has to take care of the disposal of production waste or packaging materials declared as such by the BEMO staff.
- The client ensures that BEMO's machines, coils and accessories are secured against theft and damage.
- BEMO's transport insurance ends when the truck arrived on the construction site. The client or the crane company commissioned by him is responsible for unloading, moving the machines on the construction site, loading for return transport, etc. and provide related insurances in the height of the replacement value of the machines on his charge.
- If machine, personal or other third-party damage occurs through movement of the machine on the construction site, BEMO is not liable.
- BEMO is not liable for a production interruption (machine failure) caused by movement damage.

### 12. Intermediate storage

- Curved 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.
- For the intermediate storage of uncurved/straight profiles the client is responsible for taking care that they are stored on square-shaped timber or boards on clean subsoil. It is essential that the uncurved/straight panels are also stored with a slight downward slope in longitudinal direction.

### 13. Passing of risk

- The responsibility for damage to the BEMO profile is transferred from the manufacturer to the client after the profile has left the curving machine. For the period of interim storage of the uncurved/straight profiles, from the time of delivery to the end of curving, the risk and responsibility lies with the client.
- Panels which get damaged during handling or during the uplifting onto the roof and have to be produced once again must be paid separately by the client.
- The client is obliged to check the panels' quality and dimensions immediately after handover of the BEMO 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.).

## 14. 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.
- Delays and no-show times which are not caused by the machine operator are charged to the client and will be invoiced at 1.000 €/day.
- If moving of the curving machine is necessary, due to demand of the client or a third party, the resulting costs will be charged to our client.
- Our operating staff is not authorised to accept and carry out any changes to the contract. If required, these are to be agreed with BEMO respectively with our co-ordination office

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- Curving at an outdoor temperature less than 5 degrees Celsius is only possible if the uncurved/straight profiles had been stored tempered at minimum 10 degrees Celsius for 2 days and are free of frost and ice.

At radii < 10.000 mm special conditions are to be agreed with the BEMO project management.

- Seaming the 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 the panel production on site can be made by BEMO, together with the persons in charge. A date must be fixed beforehand and related costs will be charged.
- The BEMO staff must be given free use of the existing construction site facilities (sanitary, changing and lounge rooms; telephone and e-mail use).
- If production is interrupted due to bad weather, the BEMO staff can leave the construction site after a waiting time of 3 hours and only continue with production the next day or after the weather has improved.

## CHECKLIST / CONFIRMATION OF DATES:

### Curving on site:

Our order number: \_\_\_\_\_

Your order number: \_\_\_\_\_

Project name: \_\_\_\_\_

Start of production: \_\_\_\_\_ . \_\_\_\_\_ . \_\_\_\_\_

Time: \_\_\_\_ : \_\_\_\_ a.m. / p.m.

End of production: \_\_\_\_\_ . \_\_\_\_\_ . \_\_\_\_\_

1. Access road for vehicles guaranteed according to the curving conditions  Yes  No
2. Appropriate crane available for loading and unloading the curving machine  Yes  No
3. Required space available for unloading and production and intermediate storage  Yes  No
4. Electrical supply for the curving machine available  Yes  No
5. Sufficient manpower who are instructed accordingly before production starts  Yes  No
6. Stockyard with square-shaped timber / planks available  Yes  No
7. Sufficient barricades around the working area according general safety regulations  Yes  No
8. Others:

## Instructions for the use of the mobile Curving Machine on site



Please confirm above mentioned items within 5 working days before productions starts.

If the check list is not sent back, filled out and signed, we reserve the right not sending the machine!

**With the signature the current “Instructions for the use of the mobile Curving Machine on site” are being acknowledged.**

*You can also download the current version on our homepage.*

\_\_\_\_\_  
(place)

\_\_\_\_\_. \_\_\_\_\_. \_\_\_\_\_.  
(date)

\_\_\_\_\_  
(stamp + signature)