

Operating conditions and principles for handling the products of STROJÍRNÝ POLDI, a.s.

1. Storage

- Use appropriate tools when unpacking from transport and protective packaging to prevent damage to the product
- Store products on a soft surface to prevent damage to functional parts
- Avoid extreme temperatures or temperature changes during storage, minimum temperature 15 °C
- The surface of the pins and the working part must be preserved with a continuous layer of preservative

2. Transport and handling

- It is not permissible for the rolls and tools to touch each other with the working parts without interlayers
- The product must be laid in such a way that the working part is not damaged
- When transporting by crane, use hemp ropes or similar lings that do not damage the surface of the product
- Prevent the products from hitting each other during transport

3. Care of products during their use

- The products may only be used for the purpose for which they were manufactured and only for the given product in the usual manner. The operating load must not exceed the drawing parameters or the permissible load values given by the equipment manufacturer. The manufacturer is not liable for damage caused by improper use of the products

3.1 Care of rolls during their employment in the stand

- Pairing of rolls with a deviation of max. 0.02 – 0.03 mm
- Preheating the roll in the prescribed manner
- Avoid uneven heating of the roll
- The rolls must not be under pressure when they are at rest (except when stopped during reservation) or when there is no rolled material between the rolls
- During rolling there must be no impacts of the rolls on each other (when driving out the strip, etc.)
- The rolls must not be loaded when rotating without material
- Monitor the rolling process (cooling and lubrication, rolling failure, etc.)
- Use only prescribed drafts

- Load the rolls for extremely strenuous rolling gradually. For the first few applications choose a smaller load (eg. smooth rolling)
- Determine the maximum number of rolled km of sheet metal after which it is necessary to build and regrind the rolls
- Keep records of operation of the roll (employment, rolled tones and km, grinding, roll rejection)
- Record all rolling incidents

3.2 Roll grinding

- The roll must be stored and transported by the pins after removal from the stand
- Grind only after the roll has cooled down naturally to ambient temperature
- The purpose of grinding the roll is not only the geometry and surface quality, but especially the removal of the worn layer from the roll surface (removal of all microcracks and the hardened layer of the roll)
- Grind with the prescribed technology to avoid heating and cracking of the surface layer (in case of doubt to check the surface, eg. eddy currents, magnetic methods, etc.)
- After grinding the rolls, store them in the prescribed manner and protect them against corrosion
- Back-up rolls must be ground regularly and sufficiently to remove the hardened layer – perform a hardness check before and after grinding – if necessary, relieve the roll body edge in a suitable manner

4. Other provisions

- The manufacturer is not liable for any defect, malfunction or other defect or malfunction of the goods caused by the Buyer when handling the goods contrary to the above conditions or caused by wear and tear or under conditions which were not taken into account during delivery or of which the Seller is not informed;
- The manufacturer is not liable for any defect, malfunction or other defect or malfunction of the goods caused by improper use, improper maintenance, non-compliance with the operating instructions (if supplied) or by use of tools not intended for such use, improper transport, improper handling and use of products e.g. when regrinding.

These conditions shall enter into force and effect on 30. 6. 2020.