



**Technical conditions of work execution (TCWE)**  
**the paint shop of FK system – povrchové úpravy, s.r.o.**

These TCWE do not replace the General Terms and Conditions of FK system – povrchové úpravy, s.r.o.

**1. Acceptance of a part for surface treatment**

- 1.1. An order to be emailed at least 1 day in advance to [fksystem@fksystem.cz](mailto:fksystem@fksystem.cz), which is the only address to receive and process orders. Orders are confirmed only electronically by a confirmation sent from the system. Without an order, goods will not be released for treatment. An order must state:
  - customer identification
  - ref. No. of our offer, if any has been made, or the agreed price
  - identification of the part(s) or order
  - required surface treatment (blasting + painting, only painting, etc.)
  - material (carbon steel, stainless steel, aluminium, etc.)
  - specification of the coating system (types of coating materials, layer thickness, pre-treatment of the surface before coating)
  - the weight of the part if it is over 1000 kg
  - any special requirements for packaging, handling, masking, etc.
- 1.2. Parts must be delivered with a delivery note referring to the order number under which treatment was ordered.
- 1.3. Parts to be painted must be delivered dry, without grease, without any paint or marker markings, etc. and without mechanical impurities including adhesives, burnt foils, etc. Delivery of parts contrary to this point may result in poorer quality or visual quality of the painted surface; or additional work required to prepare the surface to maintain quality will be charged.
- 1.4. Parts must be supplied with a suitable surface preparation for painting (blasting, etc.). In the event of a ground surface, the suitability of the pre-treatment will be assessed by the technician before painting. The surface can be additionally pre-treated by blasting or another suitable method according to the technician's assessment. An additional fee will be charged for this pre-treatment. If it is not possible to prepare the surface sufficiently for coating, we do not provide a guarantee for the quality and adhesion of the coating.
- 1.5. If there are places and surfaces on the parts that do not need to be painted (it is not necessary, they are not visible), the customer must explicitly draw attention to this fact in the order, and at the same time, the customer must add a drawing to the part where these places will be clearly and unmistakably marked (e.g. with a colour highlighter). In these places, there may be a splash of paint (overspray), but this is not considered a painting defect.
- 1.6. If there are places and surfaces on the parts that must not be painted (e.g. machined surfaces, sealing surfaces, seating surfaces, internal surfaces of tanks and vessels, threads, etc.), the customer must explicitly draw attention to this fact in the order, and at the same time, the customer must provide a drawing where these places will be clearly and unmistakably marked (e.g. with a colour highlighter).
- 1.7. During the winter chemical treatment of roads (salting), we recommend transporting parts only on a tarpaulin cargo area. Salt acts very aggressively on the metal surface, and even possible packaging in PE foil will not sufficiently protect the parts. We recommend the transport of parts after painting by tarpaulin vehicles all year round.
- 1.8. Only a random check is performed on receipt. Any damage can only be detected after work on the parts has started. The number of pieces is not checked. On request, it is possible to order 100% acceptance of parts.
- 1.9. The date of execution and completion of work will be decided by the paint shop technician.



## **2. Quality standards:**

- 2.1. The specification of the coating system (NH type, layer thickness, colour shade, etc.) is always consulted with the customer. By default, the specification is based on the ČSN EN ISO 12944 standard, which also specifies recommended coating systems according to the material to be painted and the required corrosion resistance. In the event of specific customer requirements beyond this standard, an additional fee may be charged for an above-standard paint quality.
- 2.2. When evaluating the finished coating system, a visual inspection of the surface and measurement of the coating thickness is performed as per the ČSN EN ISO 12944 standard.
- 2.3. Painted parts are shipped at the earliest in the drying or hardening stage, suitable for handling. However, the coating system does not acquire its final mechanical and chemical resistance until at a time that is precisely determined by the technical sheet of the paint.
- 2.4. Wrapping parts in PE foil and their subsequent storage outdoors can lead to a change in colour shade or the appearance of defects. In the event of a complaint, such defects will not be recognized.

## **3. Problem areas in terms of painting**

- 3.1. If there are closed or otherwise inaccessible places on the product, these places will not be coated.
- 3.2. If there are hard-to-reach places on the product, i.e. places where it is not possible to apply a layer of paint by spraying, these places will be painted manually.
- 3.3. Visual defects visible before painting (deep grooves, large unevenness, etc.) become even more pronounced after painting. This is not considered a paint defect. At the customer's request, such defects can be sealed, provided that the paint system contains at least 2 layers of paint. Sealing must be approved by the paint shop technician and will be billed as additional work.

## **4. Packaging**

- 4.1. In order to avoid damage to the painted surface and deterioration of the work, each part is packed and shipped no earlier than the second day after the finishing of the painting operations.
- 4.2. The individual parts on the pallets are separated with cardboard or miralon. Small parts are also packed in PE stretch film. Parts are stacked on pallets preferably in the same way as they were delivered. If, after packing, the parts no longer fit on the original number of pallets, they will be stored on additional pallets. The price of these pallets will be added to the invoice.
- 4.3. In the event of a request for a different packaging method or not to pack at all, this must be agreed with the technician and included in the order.
- 4.4. Packaging is not intended for open trucks and is not intended for storage in outdoor, unsheltered places.

## **5. Shipment of parts after surface treatment**

- 5.1. If parts are picked up by an external carrier, it is necessary for the driver to report the name of the company that ordered the surface treatment and the order number for which the treatment was ordered. Without this, it is not possible to identify the order and carry out the loading.
- 5.2. Our company does not arrange transport nor does it assume any responsibility for proper and careful securing of goods for the purpose of transport on a vehicle. The driver/carrier assumes responsibility for the subject of the order on loading the goods and signing the delivery note.