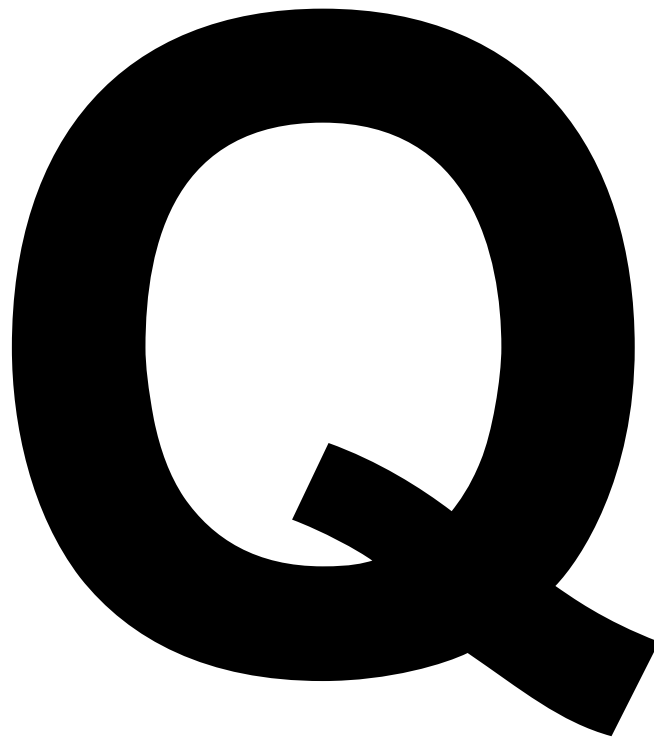




# **Technical Delivery Specifications**



**AVK HOLDING A/S**

Dear supplier

In publishing this supplement, "Technical delivery specification for castings", we have tried to gather all the conditions applying to the supply of castings, other raw materials, and components to the AVK Group. Our intention with this manual is to create a better communication, improving day-to-day working conditions for everybody.

Because of its clear definitions, this supplement will provide the individual AVK Departments with a simple and exact description for notification to the suppliers regarding faults and defects and required modifications which have been found through receiving inspection of the shipments.

AVK is an international organization with suppliers all over the world. Language often presents a problem - what is the English word for this and that. This supplement will eliminate the language barrier. In the supplement we have included all frequent errors and illustrated them by means of a series of photos. Each photo has a reference number which is to be used when communicating with the purchase department on quality issues.

Further, this supplement contains already known technical terms, handling and packing instructions etc.

We hope this supplement will be a good tool to everyone and we would like to know your opinion as a user. Also, if you would recommend any amendments in some fields.

Quality has to right first time and we hope this supplement will be a tool for this. Therefore, the objective for all of us must be to ensure

*The right quality at the right time.*

Kind regards

Jacob Hermansen  
Senior Group Procurement Manager AVK

Maybritt Søndergaard  
Group Quality Manager AVK

**REMARK:**

**This document is only for internal AVK use.**

**For our AVK selected supplier and deliveries into the AVK Group.**

<b>Document no.</b> 03.061	<b>Process owner</b> JACHER	<b>Revision</b> 08	<b>Date made</b> 19.08.2024	<b>Page 3 of 51</b>
-------------------------------	--------------------------------	-----------------------	--------------------------------	---------------------

**Contents:**

1.	Requirements .....	4
1.1	Castings .....	4
1.2	Coating .....	5
1.3	Materials.....	5
1.3.1	Nodularity .....	6
	Surface .....	6
3.	Casting defects .....	7
3.1	Defects on surfaces not to be machined .....	7
3.2	Defects on non-sealing faces .....	7
3.3	Defects on edges.....	8
3.4	Welding.....	8
3.5	Defects on sealing faces .....	9
3.6	Defects on surfaces to be machined .....	9
3.7	Part line deviations / mismatch / .....	9
3.8	Wall thickness .....	10
3.9	Subsurface material defects.....	10
4.	Machining allowance .....	11
5.	Quality inspection .....	11
5.1	Process of first Samples, approval, and release for production .....	11
5.2	Process for running batch production (inside AVK Group) .....	12
5.3	Process for any raw casting materiel (out of AVK Group) .....	13
5.4	Inspection reports and certificates .....	13
5.5	Marking, identification, and traceability .....	14
6.	Handling, storage and packing .....	15
7.	Rejection .....	15
8.	Purchase specification for new / replacement patterns.....	16
8.1	Ownership in pattern .....	16
8.2	Maintenance .....	16
8.3	Life of pattern.....	16
8.4	Identification .....	16
8.5	Purpose.....	17
9.	Responsibility and liability .....	17
10.	Confidentiality .....	17
	Non-Conformity Report.....	19
	Defects (codes) .....	21
	Inspection certificate.....	49
	Sample Plan .....	50
	AVK Inspection Form AVK.....	51

## Scope and application

The aim of this Specification is to provide suppliers to the AVK Group with details of AVK requirements for metal castings. This Specification covers all AVK companies, collectively referred to as AVK. The requirements in this Specification shall be supplementary to the requirements specified on AVK drawings and in relevant documentation. AVK will apply these specifications as a basis for their inspection processes during receiving inspection and production. All castings in grey or ductile iron, steel or copper alloys are required to comply with this Specification.

Information contained in this Specification may be superseded by information on the purchase order.

In case of ambiguity or dubiety about the meaning or effect of this Specification questions should be referred to AVK.

Any requirement specified on the purchase order shall take precedence over this Specification.

### 1. Requirements

#### 1.1 Castings

All castings supplied must meet the requirements in this Specification and must be in accordance with the relevant specifications stated on the order, drawing etc.

All castings supplied shall be free from contamination and impurities, surface imperfections & defects, porosities, and other defects unless within agreed tolerance limits as specified herein.

Edges and corners should not be sharper than a radius of 3 mm.

The casting material and specification shall be as stated on the drawing (minimum specification). Alternative materials may only be used upon written permission from AVK or when specified on purchase order.

The castings shall conform to the dimensions and tolerances stated on the drawing.  
If tolerances are not stated on the drawing, they shall comply to ISO 8062 DCTG10.

All castings shall be marked with date code, foundry identification mark and casting number (where applicable) to ensure traceability. The position of date code and casting number shall be agreed between AVK and the supplier, unless stated on the relevant drawing.

All castings shall be free from adhering or burnt-on sand and scale. They shall be well dressed and fettled and shot blasted to SIS 05 5900 SA 2 quality prior to coating.

No pitting, burnt-on sand, voids, porosity, indentations, weld splatter or other defects are acceptable. Surface profile shall be such as to enable a peak-to-valley height of between 50 m and 100 m after shot blasting. This is equivalent to a minimum standard of SIS 05 5900 SA 2 quality.

Where part lines exist that contain a step or flash, they shall be settled until they are smooth and blended in. The general profile of castings should be as smoothly contoured as other design considerations will allow. The maximum allowable mismatch, wall thickness variation and disposition of tolerances will be in accordance with ISO 8062 DCTG10.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 5 of 51
------------------------	-------------------------	----------------	-------------------------	--------------

Failure to meet the above requirements shall be cause for rejection of the casting.

**1.2 Coating**

When specified on purchase order, the castings must be completely covered with one even coat of zinc phosphate primer, applied either by brush, spray or dipping. The paint should be allowed to dry for one hour before further handling.

**1.3 Materials**

The European Standards EN 1561: 2011 & EN 1563: 2011 replace National Standards & introduce new designations to describe the irons in common usage throughout the AVK group.

This data sheet provides a cross reference to the previous designations.

New CEN Standards		Old National Standards		US Equivalent Standards
	European	UK	Germany	USA
<b>Grey Iron</b>				
Standard	EN 1561: 2011 (Grey Iron)	BS 1452 :	DIN 1691	ASTM A48
Grade Designation	EN-GJL-250	Grade 250	GG25	Class 35B
<b>Ductile Iron</b>				
Standard	EN 1563: 2011 Ductile Iron	BS 2789	DIN 1693	ASTM A536
Grade / Designation	EN-GJS-500-7	Grade 500/7	GGG50	80-55-06
	No Direct Equivalent Use EN-GJS-450-10 EN-GJS-450-10	Grade 420/12	No Direct Equivalent Similar to GGG40 GGG40	65-45-12

- NB:
- (1) It is advisable to specify on AVK purchase orders that hardness should be maintained within the range HB160 - 210.
  - (2) BS EN 1561 does not apply to Grey Iron used for pipes and fittings according to Pr EN 877-1. - 5 Rainwater goods.
  - (3) BS EN 1563 does not apply to ductile irons used for pipes, fittings and accessories which are subject to:
    - BS EN 545** Ductile iron pipes, fittings and accessories, and their joints for water pipelines (requirements and test methods).

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 6 of 51
------------------------	-------------------------	----------------	-------------------------	--------------

**BS EN 598** Ductile iron pipes, fittings and accessories, and their joints for sewerage applications (requirements and test methods).

**BS EN 969** Specification for ductile iron pipes, fittings and accessories, and their joints for gas pipelines (requirements and test methods).

**ISO 2531** Ductile iron pipes, fittings, and accessories for pressure pipelines.

A draft standard Pr EN 1503-3 also is under development and will cover the additional requirements for irons for water shells etc. It should also include requirements resulting from the Pressure Equipment Directive.

Copper - Brass - Steels: To be as specified in AVK Purchase Order

**1.3.1 Nodularity**

Classification of ductile iron is given in EN ISO 945:2008.

Nodularity shall not be less than 80%, nodular shape shall be form V or VI.

**Surface**

To ensure compliance within international standard and AVK customers' requirements in respect to corrosion protection, fitness for purpose and performance and to ensure high-quality end-product surface finish the following requirements must be met:

1. Internal and external surfaces shall have a surface finish as follows:  
Ra = 25-50 my (µm) and 50-100 my (µm) for hand moulding.
2. Thin and/or sharp flashes and burrs must be ground off.
3. Cavities or flashes from core joints are unacceptable.
4. All surfaces shall be free from adhering sand and other impurities.
5. Feeder in-gates on machined surfaces shall not be higher than 3 mm.
6. Castings will be supplied with NO primer or paint (or no oil).  
(Unless other information is added to the drawing or orders).

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 7 of 51
------------------------	-------------------------	----------------	-------------------------	--------------

### 3. Casting defects

This TDS are used as guidance documents for acceptance of castings.

#### 3.1 Defects on surfaces not to be machined

3.1.1 The maximum acceptable number of single defects as described below (fig. 3.1.1) must not exceed 5 per 25 cm<sup>2</sup>

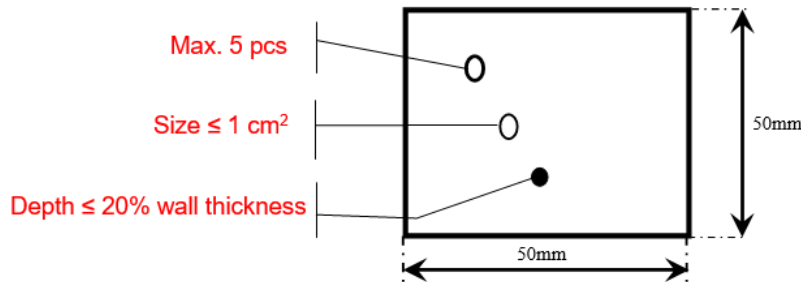


fig. 3.1.1

3.1.2 Spacing between defects must not be less than 5 mm.

#### 3.2 Defects on non-sealing faces

3.2.1 For non-sealing faces, defects within limits listed below will normally be acceptable, subject to agreement by AVK:

Category of casting defect	Pressure-carrying walls	Non-pressure-carrying walls
Max. cavity depth	See below table	See below table
Max. rise height	0.75 mm	0.75 mm
Max. Size	1.00 cm <sup>2</sup>	1.00 cm <sup>2</sup>

Wall thickness <20mm

When the wall thickness of the casting is less than 20mm.

The defect depth at any area on the casting should ≤10% of the wall thickness from the casting drawing.

Wall thickness ≥20 mm

When the wall thickness of the casting is more than 20mm,

The defect depth at Pressure-carrying walls should ≤10% of the wall thickness from the casting drawing.

The defect depth at non-pressure-carrying walls should ≤20% of the wall thickness from the casting drawing:

Wall thickness	Defect on Pressure-carrying walls	Defect on Non-pressure-carrying walls
<20mm	≤10%	≤10%
≥20 mm	≤10%	≤20%

The defect of castings can be repaired.

Defects shall not affect the appearance after coating.

If use welding as a method of repair (see section 3.4) AVK's approval is required before welding.

PT test is required after welding, make sure there are no welding cracks.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 8 of 51
------------------------	-------------------------	----------------	-------------------------	--------------

3.2.2 Spacing between defects shall be not less than 5 mm.  
Defective areas shall be ground smooth and be free from sharp edges.

**3.3 Defects on edges**

3.3.1 For edges not connecting with sealing faces, defects within limits listed below will normally be accepted subject to agreement by AVK:

Size: max. depth 2.0 mm, max. length 20.0 mm

Repair of casting defects on edges by grinding will normally be accepted, subject to agreement by AVK, if perfect surface is obtained. Grinding area shall not exceed above dimensions without prior agreement by

3.3.2 For edges connecting with sealing faces, defects within limits listed below will normally be accepted subject to agreement by AVK:

Size: max. depth 1.0 mm, max. length 15.0 mm

**3.4 Welding**

3.4.1 From supplier (raw casting) into our OC's:

1. Ductile iron
  - a. Repair of casting defects by welding or Iron Kit will not be accepted on ductile or grey iron.
  - b. AVK do not accept welding repair on raw casting (delivered by external supplier).
2. For Fitting we will comply standard DS/EN 545 – this standard allows minor level of welding. Local work instruction (repair plan) shall be available and shall describe detailed condition for welding and acceptance.
3. For Steel we will comply to standard DS/EN10213.
  - a. Welding on steel castings may be accepted provided the repair is at least 30 mm from cutting area for machining.
  - b. Weld repairs on steel castings shall be leak-tight under hydrostatic pressure of at least 1.5 x the maximum working pressure of the equipment.



Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 9 of 51
------------------------	-------------------------	----------------	-------------------------	--------------

**3.5 Defects on sealing faces**

3.5.1 For sealing faces defects within limits listed below will be accepted subject to agreement by AVK:

Category of casting defect	Sealing face
Max. cavity depth	0.2 mm
Max. protrusion height	0.2 mm
Max. size	1.0 cm <sup>2</sup>

3.5.2 Spacing between defects shall be at least 10 mm. Defective areas must be smooth and free from sharp edges.

Repair of casting defects by grinding will be accepted provided perfect castings are obtained. Grinding must not exceed the requirements of all clauses in section 3 of this Specification and the sealing face must remain intact. Additional grinding shall not be carried out without the prior agreement of AVK.

Where recesses are cast for the purpose of accepting a seat ring or other components, *without further machining*, the surface finish shall be uniform and free from protrusions or other defects that could interfere with good sealing or location. This shall also apply to "O" ring grooves cast in bonnets, etc. No steps at any core box "part line" can be accepted.

**3.6 Defects on surfaces to be machined**

3.6.1 Cavities of any form which disappear during machining are acceptable.

3.6.2 Solid protrusions or peaks of any kind within machining allowance as specified under section 4 are acceptable.

**3.7 Part line deviations / mismatch /**

3.7.1 Mold mismatch

Shall not exceed the relevant tolerance given in ISO 8062 GCTG5, table 1.

Grinding off mismatch must produce an even and smooth joint.

3.7.2 Core deviation

Shall not exceed the relevant tolerance given in ISO 8062 GCTG4, table 1, except for sealing faces, where the accepted deviation shall not exceed + or - 0.3 mm.

Smoothing / leveling of core deviations on sealing faces must be done with great care.

3.7.3 Foam production

3.7.3.1 Mismatch on flange (raw material)

<b>Document no.</b> 03.061	<b>Process owner</b> JACHER	<b>Revision</b> 08	<b>Date made</b> 19.08.2024	<b>Page 10 of 51</b>
-------------------------------	--------------------------------	-----------------------	--------------------------------	----------------------

For some foam casting material – there can be some mismatch on flanges.  
When this occurs, the following must be complied with:

1. Mismatch must not exceed  $> 0.5$  mm (before shot blasting).
2. The foot shall always be flat (pattern draft accepted).
3. The finished product after shot blasting and coating) must not have a sharp edge on the flange.



**3.7.3.2 Material Mismatch (on back)**

1. Mismatch on back - edges after shot blasting and coating may be visible - but may not be sharp. Those marks/areas are accepted (and not seen as a reject “mismatch”).



**3.8 Wall thickness**

3.8.1 Wall thickness shall not vary greater than the allowable tolerance specified in ISO 8062 - DCTG11, table 1.

**3.9 Subsurface material defects**

Included shrinkage cavities and holes will not normally be accepted. However, where the casting thickness exceeds the normal shell wall thickness, then provided the area is not required to be machined, internal shrinkage which has no detrimental effect on the strength or leak tightness can be accepted.

If included cavities and porosities are found in castings after machining or in pressure testing to an extent affecting density and/or strength, the castings will be rejected. In such circumstances AVK reserve the right to reject all castings from the same foundry production batch.

#### 4. Machining allowance

The material to be removed by machining shall not exceed 7 mm (see fig. 4.1) or the limits specified in table 4.1.

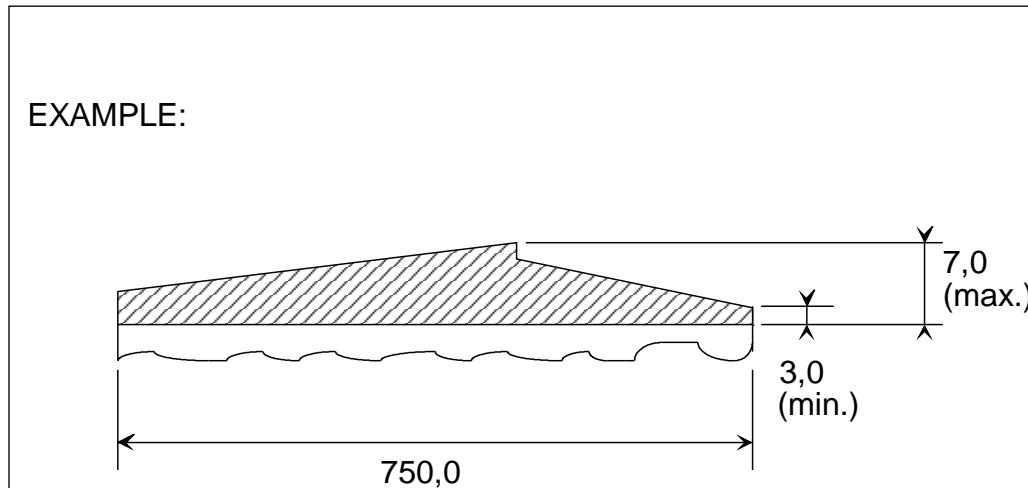


fig. 4.1

**Table 4.1 4.1**

Maximum length or width	Minimum mm	Maximum * mm
0 - 50 mm	1.5	2.5
51 - 100 mm	1.5	3.0
101 - 200 mm	2.0	4.0
201 - 500 mm	2.5	5.0
501 - 1.000 mm	3.0	7.0

\* Maximum allowance includes:  
casting draft, mismatch, inlet gates, flash etc.

#### 5. Quality inspection

##### 5.1 Process of first Samples, approval, and release for production

5.1.1 When new pattern equipment is laid down or renewed, test samples will be required by AVK. With the order for test samples AVK will enclose drawing, measuring record for casting and, if machining is to be carried out by the supplier, inspection form for machined part.

5.1.2 When the supplier has notified AVK that the test samples are ready, a preliminary measuring and inspection will be carried out by AVK inspection staff stationed near the supplying foundry, where possible. This inspection and measuring aims at excluding the worst and immediately measurable or visually detectable faults. Upon release of test samples by local inspection staff, the samples shall be forwarded to the AVK facility in question.

Certification according to clause 5.3 must be included.

5.1.3 The Quality Department at the AVK facility in question will measure and inspect the sample. Subsequently the sample will be machined (if not delivered in machined condition); coating will be carried out and then final assembly and pressure testing conducted.

5.1.4 The outcome of this process will be reviewed by the Quality Assurance Department and a report to the supplier will be issued in co-operation with the purchaser responsible at the AVK facility in question. Copies of the report will be sent to the supplier and in some circumstances to the Quality Assurance Department at Customer. The sample may then either be released for trial batch production or it may be rejected.

5.1.5 If the sample is released for trial batch production, AVK will order a suitably sized batch. If the sample has been rejected, the seriousness of the fault / faults will be evaluated and if the fault is minor, the sample may be approved for trial batch production. The fault must be corrected before the next shipment. If the fault is major, a new sample will be requested from the supplier.

5.1.6 The trial batch will be delivered to the future production site, where the Quality Department will carry out an extended receiving inspection, i.e. all functional dimensions will be measured and the castings will be inspected visually. If any difference from the drawing or original sample is found, and the difference is essential for the finished item, the Quality Assurance Department at the AVK facility in question will review the matter and the supplier will be notified of their conclusion and where applicable, AVK local inspection staff will receive copies of this notification. If no differences are found or if the differences are not essential or crucial to the finished product, trial batch documents will be prepared and will follow the production order through the production process.

5.1.7 The trial batch follow-up form will follow the production order documents through the production process in the AVK facility in question until the item has been finished satisfactorily. After each operation, the AVK operator will add his comments for each individual operation on the trial batch follow-up form.

5.1.8 Upon completion of the production process, the comments on the trial batch documents will be reviewed by the Quality Assurance Department, who will prepare a report for the supplier. If there are no comments, the casting will be released for batch production and the supplier will be notified; the Quality Assurance Department at Customer will receive copies of this Release Notification.

5.1.9 After release for batch production orders can be placed. After test samples have been approved and released for production by AVK, their function, look, quality and material and the production methods applied must not be changed without the prior written consent of the approval of any test samples by AVK shall not reduce the liability for warranty by the supplier. All cases of non-conformance with the specifications supplied by AVK shall be notified to AVK prior to any delivery with a view to obtaining a concession. Delivery, if any, shall be made separately and shall bear a note of the concession granted.

## **5.2 Process for running batch production (inside AVK Group)**

The supplier must ensure that finished goods complies to AVK specifications and the previously approved sample.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 13 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

5.2.1 Subsequent continual receiving inspection will be carried out by the AVK Quality Assurance Department and any comments on faults will be forwarded to the individual suppliers (Claim report); see also clause 7 of this Specification. Care shall be taken to ensure that descriptions are as clear and adequate as possible, supported by sketches or markings on drawings if needed. To prevent any misunderstandings, the Casting Defect Reference Master will be used as general illustration in the claim report. In case of major differences or substantial faults, the purchaser responsible at AVK and the Logistics Department will be advised and provided with copies of the report.

5.2.2 Batch production quality inspection. The supplier must ensure that the finished castings comply with AVK specifications. AVK representatives may visit suppliers to check pattern equipment prior to production and to inspect castings prior to shipment. AVK will focus on this inspection activity to reduce rejection and complaint rates.

AVK shall be entitled to inspect the production at the facilities of the supplier, to have samples taken and to make other appropriate tests at the suppliers. The scope of sampling and the inspection time shall be agreed with the supplier.

The supplier shall, free of charge, replace, rework, or repair any defective goods delivered or shade fray any expenses incurred by AVK in connection with the adjustment of any such defect goods delivered or faulty delivered subject to proper notification and agreement by the supplier.

AVK shall notify the supplier before reworking any defective goods delivered. Upon approval by the supplier such adjustment shall be made at the expense of the supplier. AVK has the right to make the decision on the best and most economical solution. In the case of defective goods delivered or faulty deliveries, the supplier shall refund to AVK the freight expenses of AVK, and upon proper notification and agreement by the supplier, the supplier shall further defray the return freight in case of a return of goods.

**5.3 Process for any raw casting materiel (out of AVK Group)**

For any raw casting materiel that may go out of the AVK group (after machining or other material handling) AVK will only measure drawing marked “Critical dimension” – using work instruction for identification and inspection of Critical dimension.

See AVK Q-document 03.160 “Critical dimension inspection”.

It recommends to progress one Quality agreement with external customer to agree condition for any delivery of raw casting material.

**5.4 Inspection reports and certificates**

5.4.1 Certificates

Material certificates complying with EN 10204 3.1, shall be available on all items, which acc. to the drawings, are marked with melt date.

Material certificates shall be uploaded to AVK SharePoint.

5.4.2 Material Certification

When required, and requested prior to manufacture, suppliers shall submit material certification for castings or other material/components supplied to AVK. This certification shall include mechanical, physical and chemical properties of the material supplied.

When required this certification shall comply with DIN 50049 / EN 10204 - 3.1.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 14 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

5.4.3 All samples from new, corrected or refurbished patterns shall be supplied with 100% dimension inspection reports according to the measuring record. Such samples shall be packed separately and bear proper markings on the packing (samples, order no., etc.).

**5.5 Marking, identification, and traceability**

5.5.1 All items must be marked clearly with all information shown on the relevant piece part drawing. The lettering must be legible and have no sharp corners.

5.5.2 When required the casting date shall be positioned on the casting below the AVK reference no. of the supplying foundry, or according with drawing specification.

The format shall be as the following example: **01H20**

The first two numbers are the year, followed by one letter indicating the month, followed by the two last numbers indicating the cast date.

Example of years:

- 24 = 2024
- 25 = 2025
- 26 = 2026

Letters for Months:

- January = A
- February = B
- March = C
- April = D
- May = E
- June = F
- July = G
- August = H
- September = K
- October = L
- November = M
- December = N

Examples of casting dates:

- 09 = day 9 in the month
- 20 = day 20 in the month

Letters / numbers shall be 10 mm high x 5 mm wide raised min. 1.5 mm above surface level.

When a foundry operates their own cast dating system, this may be used in preference to the above provided AVK are provided with any information required to recognize the cast date.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 15 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

**6. Handling, storage and packing**

6.1 All castings are to be handled, stored and packed in such a way that each casting is prevented from causing damage to itself or another casting which would have a detrimental effect to its performance. Each package must bear quantity, AVK part no., description, supplier name, date, and purchase order no.

6.2 All shipments must comply to such technical requirements and other rules and instructions as are stated on the relevant order. The supplier shall be liable for any costs or damage inflicted upon AVK as a consequence of any non-observance of such rules and instructions on the part of the supplier.

6.3 All consignments shall be delivered on approved EURO pallets (1200 mm x 800 mm), According to DS/EN 13545, and AVK specification for pallets and Frames.

Maximum weight on each pallet shall not exceed 1000 kg. Frames must be used; max. 3 frames per pallet. The last frame shall cover the castings in such a way that further pallets can be placed directly on top of the first pallet.

Metal bands shall be secured around each pallet and frame assembly. All pallets shall have a label affixed showing item no. and quantity. Any necessary repacking of the castings on pallets will be invoiced by AVK to its supplier at current hourly wage rate.

6.4 If the above is not observed, the castings will be returned at supplier's cost. Furthermore, any costs incurred by AVK production will be invoiced to the supplier.

**7. Rejection**

7.1 In case of rejection, the supplier will receive a claim report from AVK and is required to reply immediately. The claim report will give the supplier details of the rejected items, such as position of defect(s) and type of defect according to Castings Defects Reference Master.

AVK

**Procedure for handling of NCR Material: NCR**

- I. The supplier/foundry has 7 days to decide on the following options:
  - A: Accept or rejection based on the NCR report
  - B: Accept or rejection of cost for rework at the plant at AVK.
  - C: Accept or rejection based on sample of NCR Material
  - D: Return of hole batch of NCR Material for rework by the supplier
  
- II. AVK cannot rework or scarp NCR Material doing above mentioned period. If this should happen by mistake or otherwise the supplier/foundry cannot be hold responsible for this, and AVK cannot claim compensation.



Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 16 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

- III. Should the supplier wish to have a sample of the NCR Material, AVK must deliver samples in the fastest possible way. The supplier then has 7 days to accept or reject after receiving the NCR Material.
- IV. If the supplier doesn't respond within above mentioned time frame, AVK. can scarp or rework the material and still claim compensation

7.2 Each supplier will receive monthly rejection reports when necessary (page 18) specifying number of castings rejected for specific items; specification of defects (Castings Defects Reference Master No. NX).

These reports will be the basis of financial settlements with the supplier. The supplier may request that rejected castings be returned to him (at his cost) or may visit AVK to verify rejections. The Castings Defects Reference Master will be a key instrument in the communication with the supplier. The pictures illustrate the most frequent faults and defects, found by AVK production world-wide. Therefore, the illustrations and numbers constitute the reference material everyone in the AVK Group shall refer to in their claim reports and monthly reports to the suppliers.

**8. Purchase specification for new / replacement patterns**

**8.1 Ownership in pattern**

AVK shall enjoy full ownership and title in all patterns purchased and shall have the right to withdraw the pattern from the possession of the supplier at any time.

**8.2 Maintenance**

The supplier shall be responsible for all maintenance of patterns. Routine maintenance of the pattern is to be provided free of charge by the supplier assuming the pattern remains in the uninterrupted possession of the supplier.

The supplier shall guarantee that the complete pattern, including any loose items, will produce components in accordance with drawings specified on the pattern order.

**8.3 Life of pattern**

All patterns shall have a guaranteed life as agreed between the supplier and AVK and as detailed on the order. This is the expected life before AVK would be liable for any cost associated with major repair or refurbishment, assuming the pattern remains in the uninterrupted possession of the supplier.

**8.4 Identification**

Patterns are to be permanently marked "Property of AVK" and are to include the part numbers of components produced by the pattern together with supplier's serial number.

The supplier is to maintain full records of quantities produced from the pattern and any maintenance carried out on the pattern. Each pattern must have a number and if there are more than one pattern of the same item in the moulding equipment, the patterns must bear consecutive numbering (e.g. 1-2-3-4).



## 8.5 Purpose

Castings produced for AVK are generally pressure-containing parts and shall be free of contamination and impurities, surface imperfections, porosity, or other defects.

Castings supplied may be subjected to a pneumatic or hydraulic pressure test at AVK works, after assembly.

Failure to meet specified requirements will result in components being rejected.

## 8.6 Specification

All components supplied from the pattern shall be in full accordance with the specification requirements. Application for concessions shall be made in writing to the AVK ordering company.

## 9. Responsibility and liability

When orders are placed for pattern equipment, the supplier shall take full responsibility for the design and manufacture of the pattern. However, AVK shall be consulted on the pattern design as the assembly and performance of the finished product may be affected. The position of ejector pin marks, the avoidance of split lines in critical areas and porosity are of paramount importance.

The supplier shall take full responsibility for the selection of size and output rate of the manufacturing process to meet AVK production requirements. AVK shall supply all necessary technical documentation and is responsible for the design & construction and retains the ownership of the Intellectual Property Rights in the equipment, designs and specifications etc.

## 10. Confidentiality

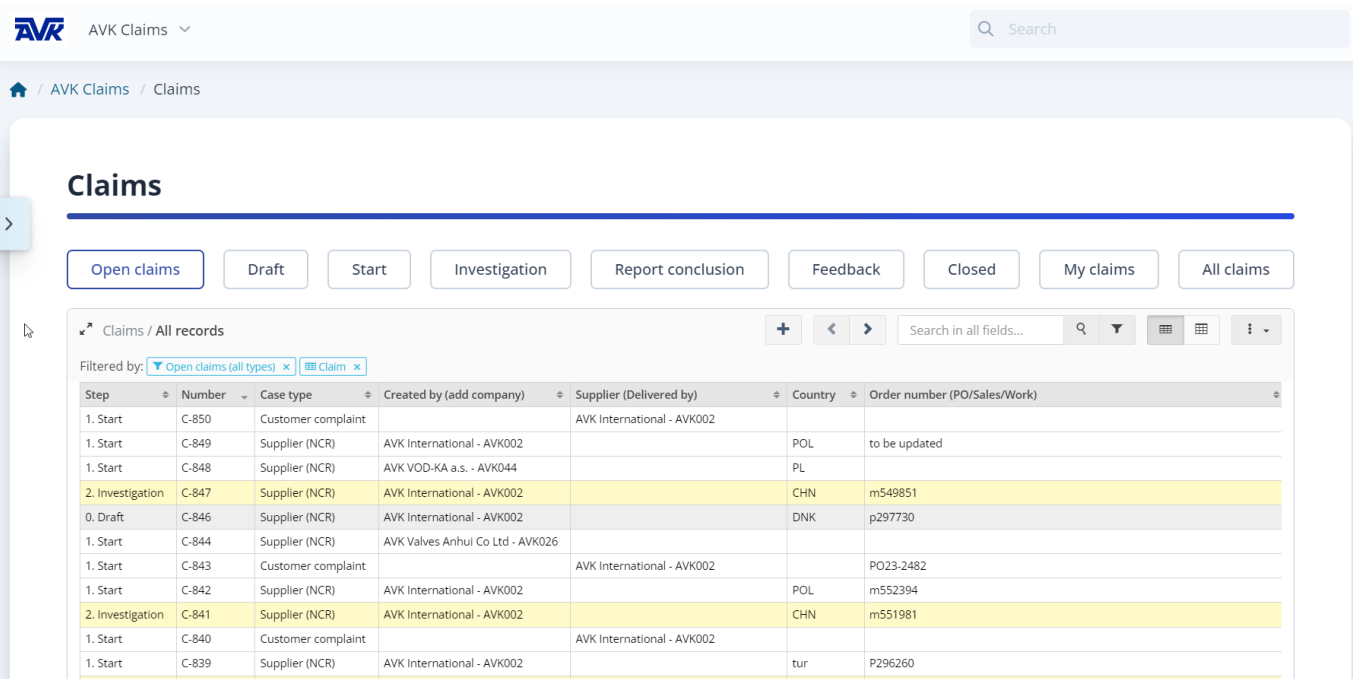
All aspects of the design of the product and production methods disclosed by AVK are strictly confidential and AVK's competitive position shall be protected all times. The supplier shall ensure that any subcontract suppliers maintain this confidentiality. They must not be disclosed to or used by any person within the organization of the supplier other than such persons as are involved in the production of goods for delivery to AVK. Without the consent of AVK in writing, the supplier must not advertise or in any other way make public that he is supplying castings to or has entered into any agreement for the supply of castings to AVK. The supplier does not have any rights to dispose of the pattern, transfer the pattern to another supplier or permit the pattern to be used for any other purpose without AVK's express permission in writing.

**Note:** This is supplementary to any instructions on specific casting drawings. In event of any dubiety or contradiction between instructions on drawings and this standard, the supplying foundry shall be responsible for obtaining clarification from AVK before proceeding.

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 18 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

**ENCLOSURES:**

Global AVK Claim system is used for handling all NCR and Customer complaints (Supplier / Customer)  
Link to this online system can be found on AVK Intranet or in ABS claim area.



The screenshot shows the AVK Claims system interface. At the top, there is a search bar and navigation links. Below the search bar, there are several filter buttons: "Open claims", "Draft", "Start", "Investigation", "Report conclusion", "Feedback", "Closed", "My claims", and "All claims". The main area displays a table of claims records with columns for Step, Number, Case type, Created by, Supplier, Country, and Order number. The table is filtered to show "Open claims (all types)".

Step	Number	Case type	Created by (add company)	Supplier (Delivered by)	Country	Order number (PO/Sales/Work)
1. Start	C-850	Customer complaint		AVK International - AVK002		
1. Start	C-849	Supplier (NCR)	AVK International - AVK002		POL	to be updated
1. Start	C-848	Supplier (NCR)	AVK VOD-KA a.s. - AVK044		PL	
2. Investigation	C-847	Supplier (NCR)	AVK International - AVK002		CHN	m549851
0. Draft	C-846	Supplier (NCR)	AVK International - AVK002		DNK	p297730
1. Start	C-844	Supplier (NCR)	AVK Valves Anhui Co Ltd - AVK026			
1. Start	C-843	Customer complaint		AVK International - AVK002		PO23-2482
1. Start	C-842	Supplier (NCR)	AVK International - AVK002		POL	m552394
2. Investigation	C-841	Supplier (NCR)	AVK International - AVK002		CHN	m551981
1. Start	C-840	Customer complaint		AVK International - AVK002		
1. Start	C-839	Supplier (NCR)	AVK International - AVK002		tur	P296260

Below is one example of NCR

<b>Document no.</b> 03.061	<b>Process owner</b> JACHER	<b>Revision</b> 08	<b>Date made</b> 19.08.2024	<b>Page 19 of 51</b>
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## Non-Conformity Report

Claims / Edit / C-833

General Notification log 2 Files 16 History 7 Properties

---

**Info**

Number: C-833  
 Case responsible: Stella.FJS@avkshanghai.com - Stella Feng  
 Step: 2. Investigation  
 Created: 2023-07-06 08:39:00  
 Created by: wojcik.mw@avkpolska.pl - Michał, Wójcik  
 Case type: Supplier (NCR)

---

**General information**

Created by (add company): AVK Polska Sp. z o.o. - AVK016

---

**Supplier information**

Supplier: GP9351  
 Supplier name: Fengcheng Euse Tool Ltd  
 Country: CN




---

**Attachments**

Files	Icon	File name	
		20230706_063831	...
		20230706_063838	...
		20230706_063847	...
		20230706_063856	...
		20230706_063954	...
		20230706_064003	...
		20230706_064051	...
		20230706_064101	...
		20230706_064409	...
		summary claim report C-833	...




Choose a file

**Images**

Choose an image x
 Choose an image x
 Choose an image x

**Images**

Choose an image x
 Choose an image x

# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 20 of 51

## Case information

Supplier response date *	<input type="text" value="2023-07-13"/>
Order number (PO/Sales/Work)	PO032343
Item lookup	1815047 - TRIPLE FL. BODY RAW DN150
Item no.	1815047
Item description	TRIPLE FL. BODY RAW DN150
Item type	
Product series	PARTS
Total batch quantity *	<input type="text" value="23"/>
Quantity of rejected *	<input type="text" value="3"/>
Quantity of scrapped	<input type="text"/>
Heat/serial number *	<input type="text" value="2211"/>
Failure group *	<input type="text" value="Bad casting"/>
Failure code *	<input type="text" value="6U Blow holes"/>
Failure description *	<p>3 pcs. porosities on the M12 hole surface. The supplier will be charged for waste production time process. We prepared summary claim report with costs. M12螺纹孔疏松, 所有相关生产费用由供应商承担。</p>
Root cause code (RC) *	<input type="text" value="SELECT"/>
Root cause *	<input type="text"/>
Comments	<input type="text"/>

## Tasks

Step	Action	Choose task responsible	Task description	Deadline	

## Corrective and preventive actions

Corrective action code *	<input type="text" value="SELECT"/>
Corrective preventive action *	<input type="text"/>
Final deadline for actions	<input type="text" value="YYYY-MM-DD"/>
Comments	<input type="text"/>

## Costs

Currency	<input type="text" value="USD"/>
Item cost	<input type="text" value="213,08"/>
Sorting cost	<input type="text"/>
Rework cost	<input type="text"/>
Production cost	<input type="text"/>

**Defects (codes)**

- 1A: Not coated properly: holiday in coated surface
- 1B: Not coated properly: run in coated surface
- 1C: Not coated properly: coating mask not used
- 1D: Not coated properly: excessive coating
- 1E: Not coated properly: failed holiday free test
- 1F: Not coated properly: chipped
- 1G: Not coated properly: wrong color
- 1H: Not coated properly: color bleed
- 1I: Not coated properly: over spray
- 1J: Not coated properly: blast media not cleaned out before coating
- 1K: Not coated properly: debris in coating
- 1L: Not coated properly: old coating not removed
- 1M: Not coated properly: out gassing
- 2A: Not machined properly: hole not drilled
- 2B: Not machined properly: hole not tapped
- 2C: Not machined properly: not machined, missed operation

Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 22 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

- 2D: Not machined properly: not machined parallel
- 2E: Not machined properly: not to print requirements, too big
- 2F: Not machined properly: not to print requirements, too small
- 2G: Not machined properly: chatter on machined surface
- 2H: Not machined properly: surface too rough
- 2I: Not machined properly: hole in wrong location
- 2J: Not machined properly: chucked off center
- 2K: Not machined properly: broken tap
- 2L: Not machined properly: rough grinding
- 3A: Failed pressure test two times: A1 dimension out of tolerance
- 3B: Failed pressure test two times: B1 dimension out of tolerance
- 3C: Failed pressure test two times: core shift at parting line
- 3D: Failed pressure test two times: parting line gap
- 3E: Failed pressure test two times: excess material
- 3F: Failed pressure test two times: lack of material
- 4A: Cracked or broken casting:

- 4B: Cracked or broken part:
- 5A: Stripped threads: bolts
- 5C: Stripped threads: bolt hole
- 5E: Stripped threads: other
- 6A: Bad casting: lack of material, poured short, metal bleed
- 6B: Bad casting: excess material, scap / swell / sag / erosion of mold
- 6C: Bad casting: cold shut, rat tail or misrun
- 6D: Bad casting: sand fall-out, drop
- 6E: Bad casting: cast to wrong dimension
- 6F: Bad casting: excessive chilling, hard spots
- 6G: Bad casting: pattern cracking, fin, vein
- 6H: Bad casting: core shift
- 6I: Bad casting: cope and drag shift
- 6J: Bad casting: inclusion, dirt / sand / slag etc.
- 6K: Bad casting: poor chemistry
- 6L: Bad casting: hot tears

# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 24 of 51

- 6M: Bad casting: rough surface / bad marking
- 6N: Bad casting: excess material, sand sticker
- 6O: Bad casting: warped
- 6P: Bad casting: gap, core fin not removed or not cleaned  
,
- 6Q: Bad casting: run out, weak core
- 6R: Bad casting: welded
- 6S: Bad casting: core improperly set
- 6T: Bad casting: wash
- 6U: Bad casting: blow holes
- 6V: Bad casting: mismatch
- 7A: Porosity: minor
- 7B: Porosity: moderate
- 7C: porosity: major
- 8A: Thorn: gasket
- 8B: Thorn: O-ring
- 8C: Thorn: other



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 25 of 51

- 9A:           Improper set-up: machining center
  
- 10A:           Damage: during packing or handling
  
- 11A:           Incorrect packing: between pallets
  
- 11B:           Incorrect packing: pallet and frames
  
- 11C:           Incorrect packing: in box

**Painting defects**

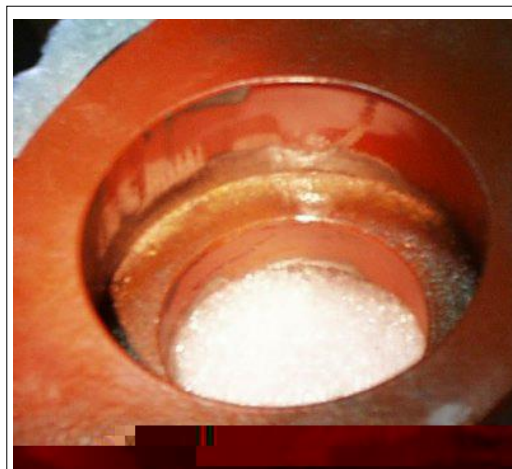
**1A:**  
holiday in coated surface



**1B:**  
run in coated surface



**1C:**  
coating mask not used



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

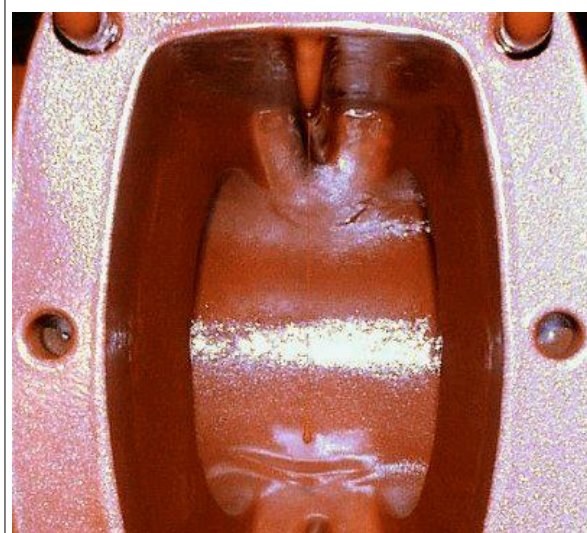
Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 27 of 51

**1D:**  
excessive coating



**1E:**  
failed holiday free test

NO PHOTO

**1F:**  
chipped



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

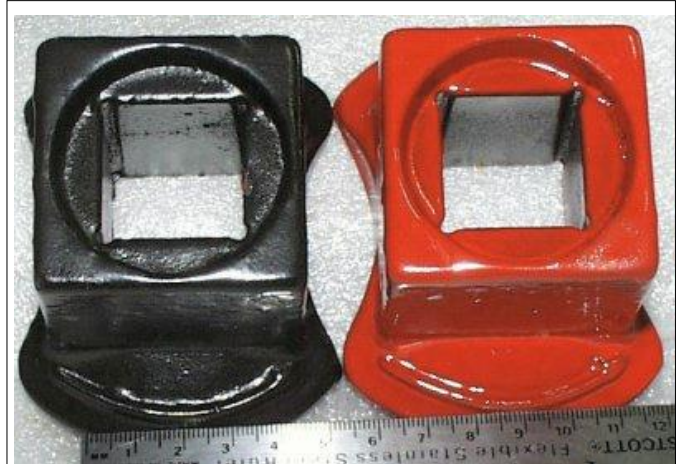
Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 28 of 51

**1G:**  
wrong color



**1H:**  
color bleed

NO PHOTO

**1I:**  
Over spray





# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 29 of 51

**1J:**  
blast media not cleaned out before coating



**1K:**  
debris in coating



**1L:**  
old coating not removed



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 30 of 51

**1M:**  
out gassing



## Machining Defects

**2A:**  
hole not drilled



**2B:**  
hole not tapped

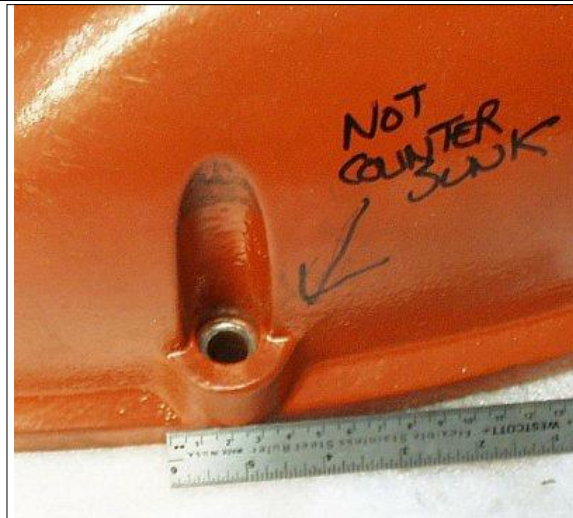


# TECHNICAL DELIVERY SPECIFICATION



Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 31 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

**2C:**  
not machined, missed operation



**2D:**  
not machined parallel



**2E:**  
not to print requirements, too big





# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

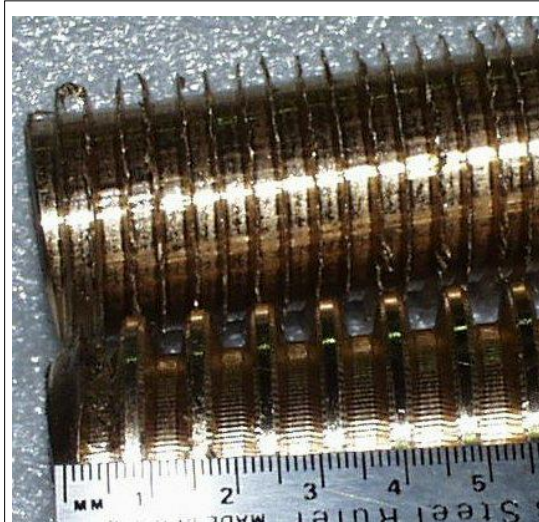
Date made  
19.08.2024

Page 32 of 51

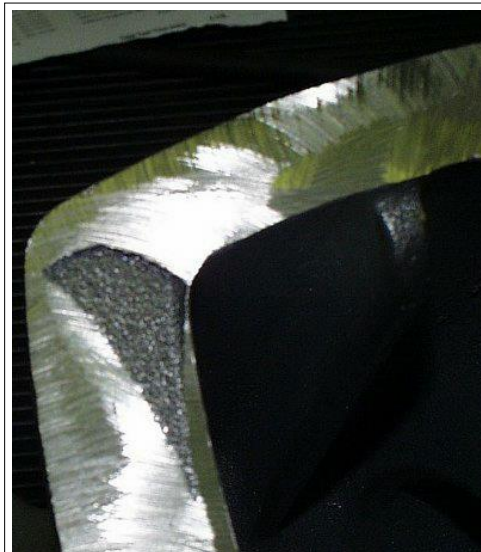
**2F:**  
not to print requirements, too small



**2G:** chatter on machined surface



**2H:**  
surface too rough





# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

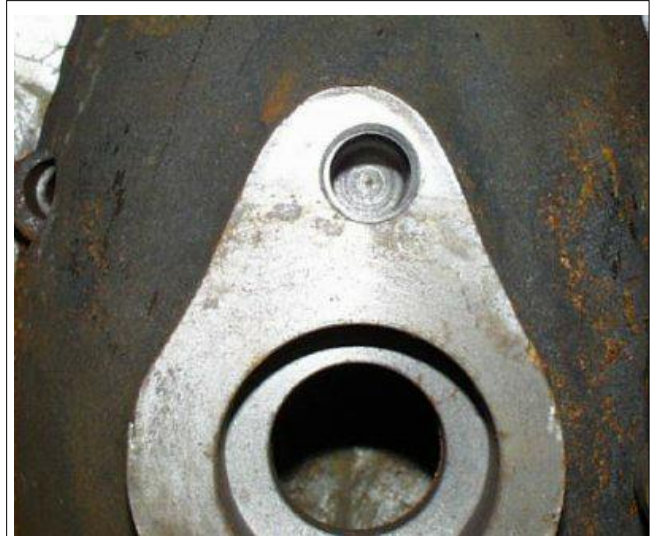
Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 33 of 51

**2I:**  
hole in wrong location



**2J:**  
chucked off center



**2K:**  
broken tap



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 34 of 51

**2L:**  
rough grinding



## Failed pressure test:

**3A:**  
A1 dimension out of tolerance

NO PHOTO

**3B:**  
B1 dimension out of tolerance

NO PHOTO

**3C:**  
core shift at parting line

NO PHOTO

**3D:**  
parting line gap

NO PHOTO

**3E:**  
excess material

NO PHOTO

**3F:**  
lack of material

NO PHOTO

**Cracks**

**4A:**  
Cracked or broken casting



**4B:**  
Cracked or broken part



Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 36 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

**Stripped threads**

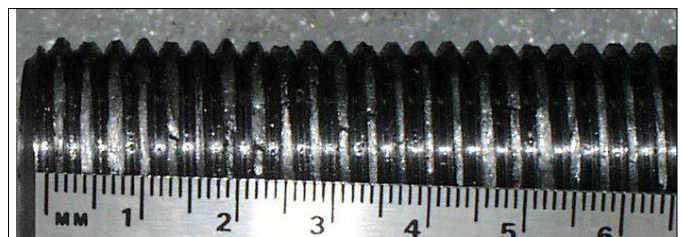
5A: Stripped thread :bolts



5B:  
bolt hole



5C:  
Other

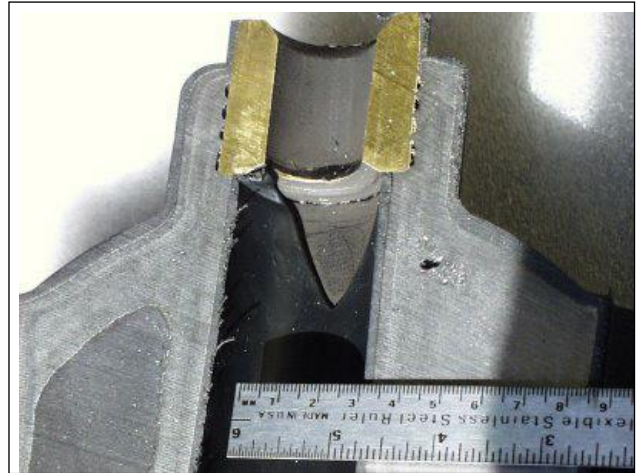




## Casting defects

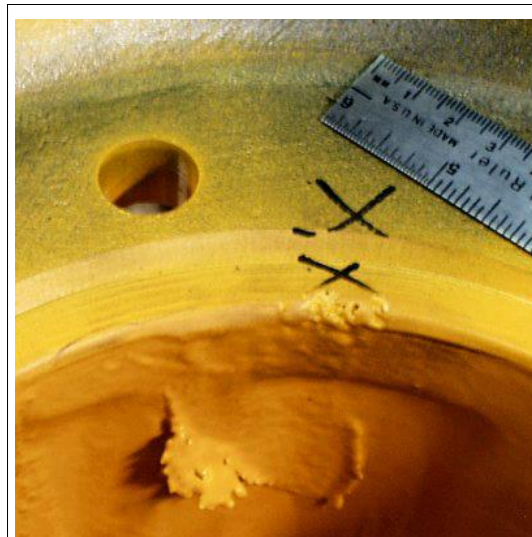
### 6A:

lack of material, poured short, metal bleed



### 6B:

excess material, scap / swell / sag / erosion of mold



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 38 of 51

**6C:**  
cold shut, rat tail or misrun



**6D:**  
sand fall-out, drop



**6E:**  
cast to wrong dimension



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 39 of 51

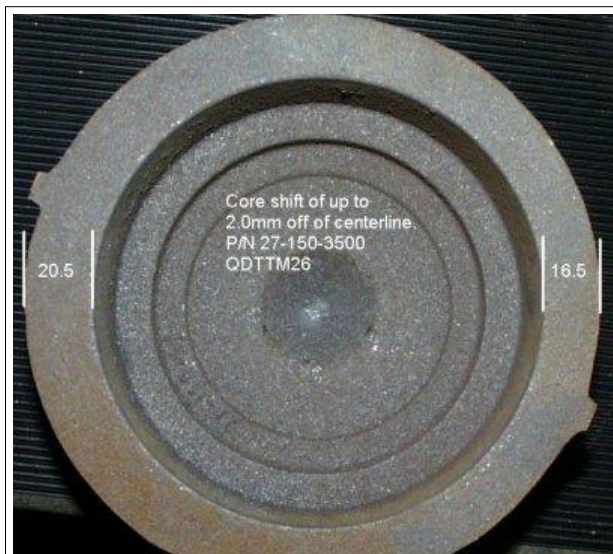
**6F:**  
excessive chilling, hard spots



**6G:**  
pattern cracking, fin, vein



**6H:**  
core shift



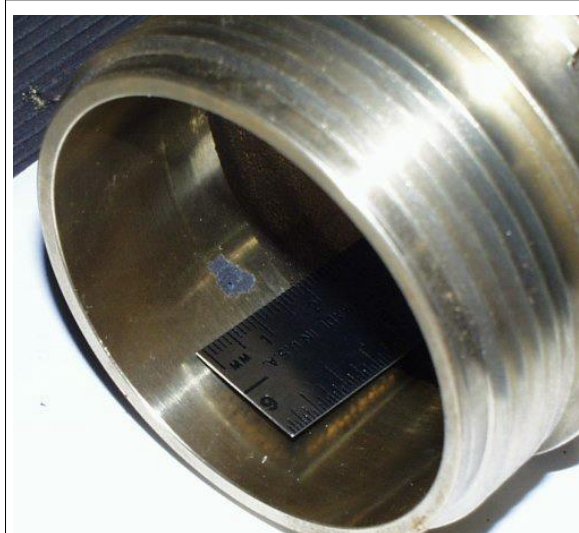


Document no. 03.061	Process owner JACHER	Revision 08	Date made 19.08.2024	Page 40 of 51
------------------------	-------------------------	----------------	-------------------------	---------------

**6I:**  
cope and drag shift



**6J:**  
inclusion, dirt / sand / slag etc.



**6K:**  
poor chemistry

NO PHOTO



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

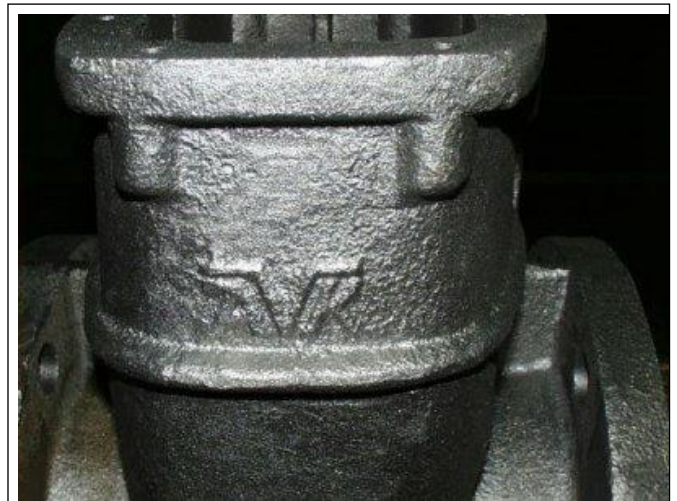
Date made  
19.08.2024

Page 41 of 51

**6L:**  
hot tears

NO PHOTO

**6M**  
rough surface / bad marking



**6N:**  
excess material, sand sticker



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 42 of 51

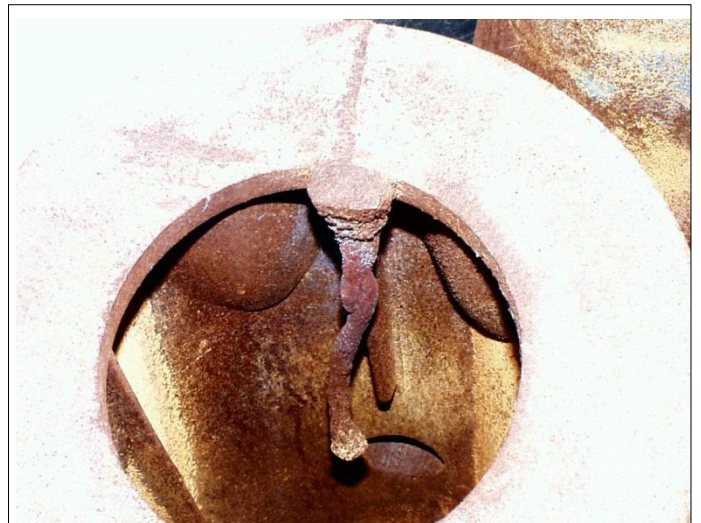
**6O:**  
warped

NO PHOTO

**6P:**  
gap, core fin not removed or not cleaned



**6Q:**  
run out, weak core



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 43 of 51

**6R:**  
Welded



**6S:**  
core improperly set

NO PHOTO

**6T:**  
Wash





Document no.  
03.061

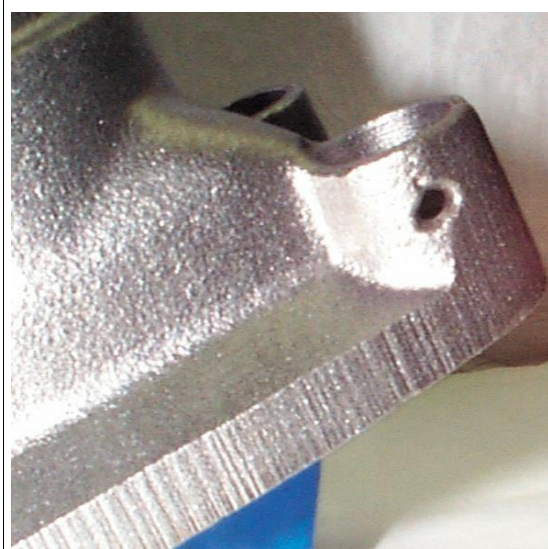
Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 44 of 51

**6U:**  
blow holes



**6V:**  
mismatch



**Porosity**

**7A:**  
Minor



# TECHNICAL DELIVERY SPECIFICATION



Document no.  
03.061

Process owner  
JACHER

Revision  
08

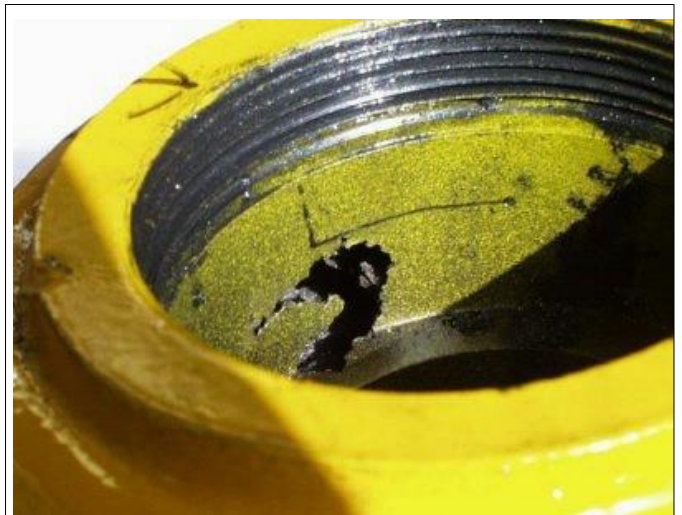
Date made  
19.08.2024

Page 45 of 51

**7B:**  
Moderate



**7C:**  
Major



**Torn:**

**8A:**  
Gasket



Document no.  
03.061

Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 46 of 51

8B:  
o-ring

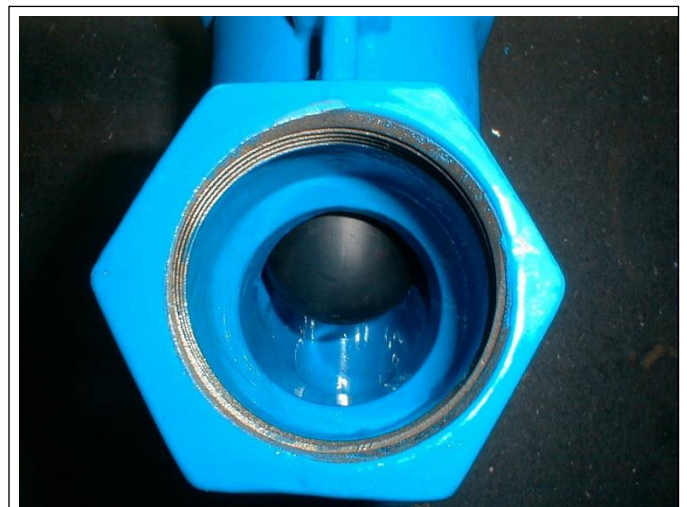


8C:  
Other



Improper set-up

9A:  
machining center



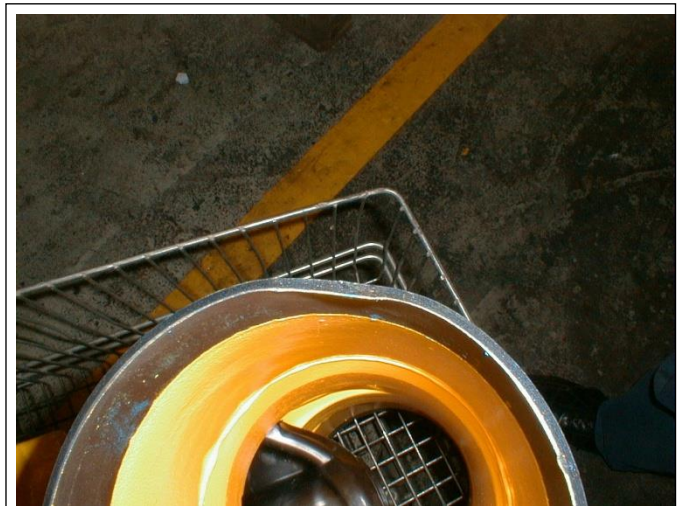


**Damage**

**10A:**  
Packing



**10B:**  
Drop





## Incorrect Packing

**11A:**  
between pallets



**11B:**  
pallet and frames



**11C:**  
in box



**TECHNICAL DELIVERY SPECIFICATION**



Document no.  
03.061

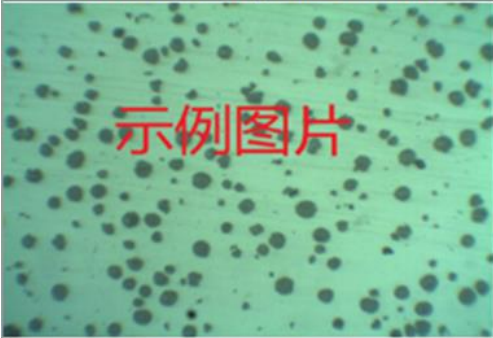
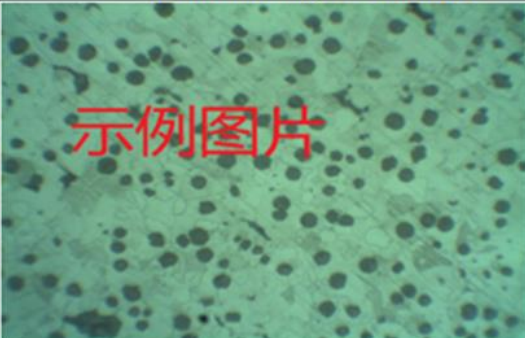
Process owner  
JACHER

Revision  
08

Date made  
19.08.2024

Page 49 of 51

**Inspection certificate**

<b>XXXXXX Foundry Co., Ltd.</b>			
<b>Material Test Certificate</b>			
Melt Number:		Certificate No:	
Material:	Item No.		
	Item Description		
Technical Specifications Or Standard:		Quantity	
Customer: AVK Group		Purchase Order No.:	
MECHANICAL PROPERTIES	SPECIFICATIONS		Results
	Minimum	Maximum	
Tensile Strength (Mpa)			
Yield Strength (Mpa)			
Elongation (%)			
Hardness (HB)			
CHEMICAL COMPOSITION	SPECIFICATIONS		Results
	Minimum	Maximum	
C (%)			
Si (%)			
Mn (%)			
S (%)			
P (%)			
Re (%)			
Mg (%)			
Graphite Form (min80%form V orVI)	Graphite Size (5-8)	Pearlite %	Ferrite %
Microstructure Photo			
no corrosion /magnification:100x		corrosion/ magnification:100x	
			
Inspection Date		Inspector	Approved By
Inspection Certificate Comply With3.1, EN10204			

**Sample Plan**

Note: The sample plan complies with the standard of ISO 2859 Inspection S4 and S2 Level AQL=2,5

Batch Size	Sample Size (level)		Accept	Reject
	S4	S2		
2-8	5*	5*	0	1
9-15	5*	5*	0	1
16-25	5*	5*	0	1
26-50	5	5*	0	1
51-90	5	5*	0	1
91-150	8	5*	0	1
151-280	13	5	1	2
281-500	13	5	1	2
501-1200	20	5	1	2
1201-3200	32	8	2	3
3201-10000	32	8	2	3

\* Minimum sample level established by AVK exceeds AQL requirements.

Roles for inspection:

- AVK supplier use sample size S4.  
Sign of shall be done by Suppliers quality manager and production responsible.
- AVK SH use sample size S4.  
Sign of shall be done by AVK SH inspector.
- AVK customer (IQC) use sample size S2.

If there are any problems experience with the sampling – contact the AVK Quality department for further action.

TECHNICAL DELIVERY SPECIFICATION



Document no. 03.061

Process owner JACHER

Revision 08

Date made 19.08.2024

Page 51 of 51

AVK Inspection Form AVK



INSPECTION REPORT

Released (BOX dimension)
 Prototype (ALL dimension)

Supplier, Drawing no., Item no., Order No., Supplier no., Drawing Rev., SD weight, Batch size, Inspection date, Material, Description, Approval Supplier, Approval SH, Inspection report no., Approval Customer

Table with 17 columns: NO, Drawing Location, OOST, Drawing, Dimension, Min, Max, and 6 columns under Actual Measurements (By Supplier, By Local Engineer, By local AVK). Includes Remark column.

Form sections for inspection details: Melt date, Checked for open NCRs, Surface inspection, Text and Logo, Part Number, Size, Pressure class, Year, Visual check bolt hole patterns, Cast surface roughness & porosity, Machined surface roughness, Measure Brinell hardness, Core shift, Sharp edges, Weight, Material certificate.

Legend for symbols: A=, B=, C=, D=, E=, F=, G=, H=, I=, J=, K=, L=, M=, N=