



General Conditions for the Acceptance of Parts Made in the Cooperation

(commissioned by Przedsiębiorstwo Produkcji Sprężarek Airpol Sp. z o.o.)

1. Accuracy requirements for machined parts.
 - a. The parts must be made according to the drawings provided.
 - b. All parts shall be manufactured in accordance with the supplied technical documentation, both as regards dimensions, dimensional tolerances, shape and position tolerances, grade of materials used, surface quality (roughness).
 - c. Tolerance in accordance with the independence principle of PN/M-01142.
 - d. For geometric elements (dimensions, shape and position deviations) having only nominal values without specifying their tolerances (general tolerances), the following rules shall apply:
 - Linear dimensions, diameters of holes and shafts must be within tolerance class IT12 according to PN-EN 20286-2 (PN-EN ISO 286-2), the tolerance must always be in the depth of the material; the actual dimension must be made in the centre of the tolerance field.
 - Angular dimensions must be within the tolerance class m (medium accurate) according to PN-EN 22768-2. Unless otherwise indicated on the drawing, the tolerances are to be arranged symmetrically with respect to the nominal dimension.
 - The straightness and flatness of parts must be within tolerance class K in accordance with PN-EN 22768-2.
 - The perpendicularity of the parts must be within tolerance class K in accordance with PN-EN 22768-2.
 - The symmetry of the parts must be within tolerance class K in accordance with PN-EN 22768-2.
 - The run-out of parts must be within tolerance class K in accordance with PN-EN 22768-2.
2. Additional requirements.
 - a. The raw surfaces (without chip treatment) must be free of metallurgical scale and corrosion.
 - b. The edges of the parts must be free of burrs and barbs. Sharp edges must be blunted unless otherwise specified in the documentation.
 - c. Parts should be clean, free of chips, residues of cutting fluids and other contaminants.
 - d. All materials and parts used in the production process must be approved by the manufacturer.
 - e. Parts must be protected from external influences and atmospheric conditions during transport to ensure that their serviceability is not impaired.
3. Requirements for material certificates and manufacturer's declarations.

All materials and parts used in the production process must have a 3.1 certificate according to PN-EN 10204 standard and have the appropriate manufacturer's declaration stating that the subject of the order has been manufactured in accordance with the order and the supplied technical documentation.

