

February 4, 2025

## **MIVRAG Finishing Department - External Work – Notes for Price Quotation**

### **General:**

- Transport and collection of the products are the responsibility and at the expense of the customer.
- Parts will be packaged after processing according to the nature and type of packaging in which they were received. If different packaging is required, it must be specified at the time of the price quote request.
- Delivery time – up to 10 business days. Upon completion of the work, a notification will be sent to the customer.

### **Technical Notes on Process and Product Quality:**

#### **1. Cathodic Painting Performed in Trays:**

- The type of raw material must be specified.
- The paint distribution on the part is uniform with an accuracy of  $\pm 5 \mu\text{m}$ .
- Due to the nature and method of painting, there may be electrical contact marks, an uneven appearance of the paint, and uncoated areas (such as air bubbles), depending on how they were placed during the coating process.
- If there are critical areas requiring a uniform appearance without contact marks, this must be explicitly stated in the drawing. In some cases, hanging the parts may be necessary. If no specific placement instructions are provided, the parts will be placed, coated, or painted in the best possible manner at the professional discretion of the department manager.

#### **2. Electrolytic Zinc and Zinc Alloys Coating in Drums:**

- The type of raw material and hardness grade must be specified if the item has undergone hardening treatment.
- Electrolytic metal coating thickness varies across different areas of the item.
- The process tolerance for thickness deviation from the required target is  $\pm 2 \mu\text{m}$ .

#### **3. Thickness Inspection:**

- The location of the thickness inspection must be specified on the drawing/order. If the customer requires a specific thickness at a certain location,

they must indicate on the drawing where the coating thickness should be measured.

- In the absence of special thickness inspection instructions, the thickness will be measured at the professional discretion of the department manager.
- By default, the inspection point will be on a main surface, meaning a point that can be contacted with a 1 cm diameter sphere.
- For parts requiring painting, it is recommended to attach an accompanying sample made of the same raw material as the product. If no accompanying sample is provided, the inspection will be performed on a standard accompanying sample from Mivrag.

#### **4. Salt Spray Test:**

- Mivrag conducts annual salt spray resistance validation for various processes. A copy of this annual test report is available upon request.
- A specific test for a product/order is performed only upon request and at an additional cost.
- If a separate test is required for a product/order, a matching sample corresponding to the base metal must be sent, or alternatively, approval must be given to use the coated parts supplied (as this is a destructive test).