

## 01. Preliminary remark

The instructions for the use of the mobile rollforming machine are a component part of the contract and are binding, firmly agreed upon for both parties. At the same time, the instructions also govern demarcation of the performances between the customer and BEMO SYSTEMS GmbH.

## 02. Weight of the mobile rollforming machine

BEMO is using its different machines according to the special conditions and profiles of the order. Information about the rollformer coming into operation at your project and its corresponding weight can be obtained in our office in Ilshofen-Germany.

BEMO SYSTEMS GmbH  
Max-Eyth-Str. 2  
74532 Ilshofen - Germany  
Tel.: +49 - 7904 - 29899-60  
Fax: +49 - 7904 - 29899-61  
Mail: [sales@bemo.com](mailto:sales@bemo.com)

As rough indication you can calculate with the following weight – without guarantee:

Semitrailer motor vehicle (depending on forwarder)	approx.	18.000 kg
Container with built-in panel former (without Coil inside)	approx.	24.000 kg
		-----
Total:	approx.	42.000 kg

Please calculate for the weight, at lifting up the rollformer to the roof level, an additional weight for the coil material of approx. 4.000 kg!

In accordance to the total weight the customer has to ensure that the lifting equipment (cranes), transport equipment (truck + trailer), public roads (weight + permissions) and the access road to the building site and the sub-soil of the site are reinforced for road transport. If this is not guaranteed, it is the customer's responsibility to take appropriate measures and to accept the costs for necessary moving or similar.

## 03. Dimensions and space requirements

- Dimensions of the vehicle with container:

height	4.15 m*
width	2.50 m*
length	16.00 m*
  
- Space required to unload the container:

height	20.00 m*
width	15.00 m*
length	30.00 m*

(min. length of the access road)

(\*only approximate data)

- Required space for rollforming:
  - a) For the rollforming machine (container) inclusive lateral space for charging the coils:

width:	7.50 m
length:	15.00 m
  
  - b) For the profile run-out:

depending on the longest profiles to produce  
(+ 3.00 m of range)
  
  - c) Required total length:

15.00 m + longest length of profile + 3.00 m
  
- Additional space requirement for intermediate stock of coil material and produced material:
  - a) Coil material:

Such a place is needed in a sufficient size, according to the size of the project, not more than 100 m from the rollforming machine.

The road between the stock and the rollforming machine must be passable for a suitable lifter (fork lifter or wheel loader) to put the coils into the rollforming machine.
  
  - b) Produced material:

Such a place is needed in a sufficient size, according to the size of the project, not more than 20 m from the profile run-out.

Additionally we want to refer to item 12 of these instructions.



## 05. Safety regulation

- The rollforming machine has for health and safety protection a photocell in front of the rollers.
- The doors of the rollforming machine are able to lock from the inside.
- The machine could be operated (start + stop) from outside of the container, programming of the quantities and length as well as adjustments must be done inside of the container.
- The BEMO staff will be equipped with the standard dress code for site working:
  - ✓ Safety boots with steel caps and soles
  - ✓ Helmets (without chin holder)
  - ✓ Security jackets
  - ✓ Working trousers (long)
  - ✓ Gloves
- In case there are additional local safeties regulations the customer has to inform BEMO at least 4 weeks before leaving of machines and staff from Germany.

## 06. Staff requirement

- The requested machine-operator for operating the mobile rollforming machine is provided by BEMO.
- The equipment may only be operated by a BEMO machine operator.
- The customer has to provide assisting workers at his own expense for the handling and storage of the produced panels.
- The necessary number of support-people depends on the length of the panels to be produced (handling) and the material to be processed. The following details are guide values, the definitive quantity is to be settled with the BEMO operator on site:
  - For aluminium profiles with a length over 8 m:  
**each 8 m / 1 helper**
  - For steel, zinc or copper profiles with a length over 6 m:  
**each 3 m / 1 helper**

## 07. Operating / Working time

- The required time depends on the demands of the production process and the size of the project and is determined by the machine operator in agreement with the responsible offices.
- Normal working time:

Monday – Friday:	10 hours per day (incl. 1 hour break)
Saturday, Sunday and public holidays:	8 hours per day (incl. 1 hour break)
- Saturday working is without additional charges. If time pressure is high, the customer and the supplier can agree upon working on Sunday and public holiday for appropriate additional charges.

## 08. Permissions

- The local required working permissions for the BEMO employees have to be organized by the customer.
- The permissions to enter the construction site and work there have to be organized by the customer for the BEMO employees and their vehicles.
- The client is responsible for all Visa and Work permissions, Medical Controls, Safety trainings or regulations etc.  
He has to inform BEMO at least 6 weeks before leaving of machines and staff from Germany about them and request from BEMO to provide documents in a reasonable time. Local actions have to be organized by the customer.

## 09. Daily production reports

- The BEMO profiles produced by the BEMO operator will be specified in a production list / daily report, stating the number of pieces, length and width.
- The customer has to announce responsible person(s) for signing the daily reports and confirm the quantities, dimensions and proper quality of the produced panels.
- BEMO is entitled, without any penalties, not to go ahead with the production, if the previous daily report is not signed and stamped by the customer.

## 10. Site office / Local accessibility

- The site office and equipment could be used free of charge from the BEMO staff.
- The customer will provide free of charge a desk inside their site office for the BEMO staff.
- Permanent internet access is free of charge available in the site office.
- If the on-site production is longer than 1 week, the customer has to provide for the BEMO operator a mobile internet flat and a local phone number.

The costs for the mobile internet flat and local phone number could be separately charged to BEMO as expenses of the number.

## 11. Services to be provided by the customer at the project site

- Unloading and safe storage of the raw material (maximum weight of a double coil incl. pallet approx. 4.0 to) must be organized and paid by the customer.
- The client need to provide suitable offloading equipment/crane for the rollforming machine (40' container, weight on request) for loading and unloading the rollforming machine off and onto the transporting vehicle.
- The client need to provide a fork lifter suitable for grounds on site (3.0 to) or another suitable lifting device to unload and transport the coils to the hydraulic lifting gear of the rollforming machine.
- The client need to provide a sufficient quantity of square-shaped timber or boards to place under the produced profiles (intermediate storage).
- The client need to provide suitable lifting belts (e.g. straps etc.) as well as lifting beams for the maximum profile length (maximum profile length less approx. 2.5 m left & right) for lifting the BEMO - profiles onto the roof.
- The client is to ensure appropriate cordoning off of the production area, especially in the region of the panel run-out, in accordance with the general safety regulations and the instructions of the machine operator.
- The costs for the distribution and supply of power respectively fuel for the aggregate (for rollforming machine and curving machine production and if necessary the site containers on site) are to be borne by the client.
- The client has to take care of the disposal of production waste or packaging materials declared as such by the BEMO staff.
- The client ensures that BEMO's machines, coils and accessories are secured against theft and damage.
- BEMO's transport insurance ends when the truck arrived on the construction site. The client or the crane company commissioned by him is responsible for unloading, moving the machines on the construction site, loading for return transport, etc. and provide related insurances in the height of the replacement value of the machines on his charge.
- If machine, personal or other third-party damage occurs through movement of the machine on the construction site, BEMO is not liable.
- BEMO is not liable for a production interruption (machine failure) caused by movement damage.

## 12. Intermediate storage

- The intermediate storage of the coils is to be organized by the client.
- For the intermediate storage of raw material (coils) the client is responsible for taking care that
  - the stockyard is clean and has a levelled surface
  - the coils are stored on a wooden base track/plate/pallet
  - not more than 2 coils are stacked on top of each other
  - the coils are protected against rain and moisture
- Produced profiles are to be stored temporarily on square-shaped timber or boards on clean subsoil. It is essential that the panels are stored with a slight downward slope in longitudinal direction.

## 13. Please note additional criteria at rollforming straight onto the roof

- At production on the roof or on the edge of the roof, it must be precisely defined in advance where the rollformer will be placed and in which direction the BEMO standing seam profile is to be laid. This is the only way to ensure that the BEMO halters are placed in the right direction.
- A crane to lift the rollforming machine onto the roof level/edge must be provided by the customer at his own expense for the duration of production.
- The customer must ensure that the access road to the construction site and the subsoil of the production area are reinforced for road transport and production (weight rollforming machine with coils on request + weight of crane).

The needed crane capacity according to the local circumstances has to be clarified with a specialist of a crane company by the customer himself – the following numbers are just unbinding guidelines.

- If the crane will not slew the lifted load (rollforming machine) and has to move from one spot to another, which means the crane is directly under the lifted load (rollforming machine) or rather directly under production field, a 160 ton crane is normally sufficient (under reserve).
- If the crane is to reach several production fields directly from one position, higher permissible lifting loads are required. Here, depending on the outreach, 250 - 350 to permissible lifting load are quickly required. It is therefore essential to check the situation on site before starting the construction site and arrange accordingly.



- On both sides of the rollforming machine on the roof a barricade in form of a net of minimum 3.0 m is to be provided and installed by the client.
- The BEMO machine operator must have the possibility to attach the rope of his fall prevention on the roof according to DIN 795 (German Standards Institution).
- The area below the lifted-up rollforming machine has to be closed off spacious by the client.

#### 14. **Passing of risk**

- The responsibility for damage to the BEMO profile is transferred from the manufacturer to the client after the profile has left the rollforming machine. For the period of interim storage of the coil material, from the time of delivery to the end of production or collection of the residual coils, the risk and responsibility lies with the client.
- Panels which get damaged during handling or during the uplifting onto the roof and have to be produced once again must be paid separately by the client.
- The client is obliged to check the panels' quality and dimensions immediately after handover of the BEMO panels, later complaints can no longer be invoked.
- Claims after moving the panels on the building site or installation on the roof can no longer be invoked (e.g. scratches, deformations, surface damage etc.).

## 15. General remarks

- The customer is liable for any accidents. The customer also has to prepare the building site according to the local safety regulations and to instruct the machine operator as well as support-persons in an adequate way. The customer has to pay all costs therefore.
- Delays and no-show times which are not caused by the machine operator are charged to the client and will be invoiced at 2.000 €/day.
- If moving of the rollforming machine is necessary, due to demand of the client or a third party, the resulting costs will be charged to our client.
- Our operating staff is not authorised to accept and carry out any changes to the contract. If required, these are to be agreed with BEMO respectively with our co-ordination office

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- A production at an outdoor temperature less than 5 degrees Celsius is only possible, when the coils had been stored tempered at minimum 10 degrees Celsius and are free of frost and ice.
- Seaming the panels at temperatures below 5 degrees Celsius can lead to problems (e. g. material breakage).
- An evaluation of the production area regarding the suitability or facility for the panel production on site can be made by BEMO, together with the persons in charge. A date must be fixed beforehand and related costs will be charged.
- The BEMO staff must be given free use of the existing construction site facilities (sanitary, changing and lounge rooms; telephone and e-mail use).
- If production is interrupted due to bad weather, the BEMO staff can leave the construction site after a waiting time of 3 hours and only continue with production the next day or after the weather has improved.

**CHECKLIST / CONFIRMATION OF DATES:**

Rollforming on site:

Our order number: \_\_\_\_\_

Your order number: \_\_\_\_\_

Project name: \_\_\_\_\_

Start of production: \_\_\_\_\_ . \_\_\_\_\_ . \_\_\_\_\_

Time: \_\_\_\_\_ : \_\_\_\_\_ a.m. / p.m.

End of production: \_\_\_\_\_ . \_\_\_\_\_ . \_\_\_\_\_

1. Access road for vehicles guaranteed according to the rollforming conditions  Yes  No
2. Appropriate crane available for loading and unloading the rollforming machine  Yes  No
3. Required space available for unloading and production and intermediate storage  Yes  No
4. Electrical supply for the rollforming machine available  Yes  No
5. Sufficient manpower who are instructed accordingly before production starts  Yes  No
6. Dry, tempered and secure stockyard for coil material available  Yes  No
7. Forklift available, to lift coils onto machine for the period of production  Yes  No
8. Stockyard with square-shaped timber / planks available  Yes  No
9. Sufficient barricades around the working area according general safety regulations  Yes  No
10. Others:

## Instructions for the use of the mobile Rollforming Machine on site



Please confirm above mentioned items within 5 working days before productions starts.

If the check list is not sent back, filled out and signed, we reserve the right not sending the machine!

**With the signature the current “Instructions for the use of the mobile Rollforming Machine on site” are being acknowledged.**

*You can also download the current version on our homepage.*

\_\_\_\_\_  
(place)

\_\_\_\_\_. \_\_\_\_\_. \_\_\_\_\_.  
(date)

\_\_\_\_\_  
(stamp + signature)