

TECHNICAL CONDITIONS OF DELIVERIES

Dear Customer,

these technical delivery conditions are based on our experience with deliveries of perforated materials. Please read them and they can help you understand some important details in the selection of a particular material and in its proper use.

Thank you.

Perforated sheets

- Perforated sheets are manufactured in accordance with DIN 24041.
- The tolerance of external dimensions is in accordance with the above standard and dimensional standards for metallurgical material EN10025, EN10029, EN10051, EN10131, EN10088.
- Common stock items - sheets and coils - in standard dimensions 1000x2000mm, 1250x2500mm and 1500x3000mm are not cut. Therefore perforated sheets can be up to 5 mm larger in width and length compared to the common tolerance of the input raw material. This size difference of the sheet metal is formed by perforation and depends on the size of the holes and their density, as well as on the thickness and quality of the raw material.
- Custom sheets are cut with a tolerance of + -3mm up to a thickness of 2mm. Sheets with a thickness greater than 2 mm are cut with a tolerance of + -5mm. In case of other requirements, please state this in your order or supply a dimensioned drawing. There must be a mutual agreement or approval of the testing sample.
- To avoid breaking and cracking of our tools, we use the special tools (mainly for small holes) with 2 times bigger pitches between the punches. These tools cause the first and the last perforated rows uncompleted, especially for smaller holes,
- The punching die may break during punching which will cause several missing holes. In case you will use the perforated sheets as decorative elements we therefore kindly ask you to notify our company of this fact in your order.
- When using punching dies, burrs (chips) are formed on the reverse side. While flattening, these burrs can be pushed back into the holes. In case this will have an effect on the function of the perforated sheet, or if the perforated sheet will be used as a decorative element, we kindly ask you to notify our company of this fact in your order.

Technical recommendations

- Perforated sheets made of pre-galvanized sheets have untreated inner cutting edges of the holes. These perforated sheets cannot be used in the exterior or in other oxidizing environment.
- Surface protection of steel sheets by electro-galvanizing is also not suitable for outdoor use and any other oxidizing environment. It is necessary to make the second surface treatment (powder coating etc.) to use the perforated sheets outdoors.
- The surface treatment hot powder coating of mild steel sheets in one layer is not suitable for outdoor use and any other oxidizing environment. It is necessary to make another surface treatment such as galvanizing or cathoporesis beforehand, or to use perforated sheets made of pre-galvanized steel.
- Surface protection done by hot-dip galvanizing is the most effective protection. It can be performed on perforated sheets with holes greater than 8mm and sheet thickness 1mm and larger. This surface treatment serves only for the protection of steel sheets and it cannot be considered as a decorative element. The white rust that is formed by oxidation of the zinc surface is not a product defect. Partially filled holes, diverse disparities and cuticles, which are caused by galvanizing, are not considered to be the defect of the product.
- When punching, to lubricate and cool, we use the special oil which contains removable grease substances (silicone). If a non-greasy surface is required, state this requirement in your order. The sheets will be lubricated with volatile oil, which will leave a minimal trace.
- When producing perforated sheets, the surface may be scratched due to the torsion of the sheet directly on the machine when being punched. These are mostly the sheets thicker than 2 mm. If you need a flawless surface, please notify us of it in your order. After the agreement, the sheets will be provided with a protective foil or will be flattened several times during punching.