

Production guidelines



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Production guidelines

1 Application

The production guidelines are general rules for the production respectively for the suppliers of KOCH Pac-Systeme GmbH (hereinafter referred to as KOCH) to produce the parts according to the KOCH specifications. Drawing specifications take precedence over the provisions of these production guidelines.

The technical information by KOCH is binding on the suppliers. It takes precedence over universal specifications of the supplier.

2 Repair | deviation

Quality deviations especially repair of defects may only be carried out after consultation with the production planning department.

The production parts must not be polished with non-woven abrasives (e.g. Scotch-Brite™, or similar) or must not be processed with an orbital sander.

Additionally, the production parts must not have scratches or grinding marks.

Components having a manufacturing defect must not be filled or welded.

3 Employee self-inspection

A substantial part of the KOCH quality assurance system is the employee self-inspection. The employee is responsible for the required dimensions and the required shape of the workpiece. The measuring and testing equipment is to be used according to its intended purpose. The measuring and testing equipment is subjected to the inspection equipment monitoring. Repairs and adjusting works have to be initiated via the inspection equipment monitoring.

3.1 General tolerances

Following general tolerances have to be observed for all assemblies and individual parts unless otherwise indicated on the drawings:

- all linear and angular dimensions: acc. to **DIN ISO 2768-1 m**
- all geometric tolerances: acc. to **DIN ISO 2768-2 K**
- all welded constructions: acc. to **DIN EN ISO 13920 A**

Deviations from these tolerances are not permitted or must be explicitly approved by KOCH.

3.2 First production

Check the whole part for completeness: fits, threads and thread depth, surface, deburring and numbering. Milling tools may only be used specific to material.

Milling cutters for steel must not be used for stainless steel to avoid ferrite carryover. Additionally, sharpened milling cutters must not be used.

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The use of raw materials on the basis of the material specifications and compliance with all specifications is mandatory.

3.3 Repeat parts

Check the fits, threads and thread depth, surface, deburring and numbering modification. In addition, the modified drawing must be updated with regard to drawing number, date, editor and modification information in the customer file management system.

The date of issue is changed with modified KOCH drawings and also a modification history is maintained. Whereby the modified positions are marked with the relevant character of the modification history. A revision level is not maintained but with regard to drawings you always have to observe the date of issue.

3.4 Deburring

The components must be deburred **perfectly**. KOCH deburrs the components with a machine-made chamfer of **0.5 mm x 45°**. Manual deburring is only carried out in exceptional cases.

3.5 Inspection tolerances

- **Linear dimensions, tolerance $\geq \pm 1.0$ mm**
Steel rule, measuring tape (vernier caliper, micrometer, gauge blocks, altimeter)
- **Linear dimensions, tolerance $\geq \pm 0.1$ mm**
Vernier caliper (micrometer, gauge blocks, altimeter, measuring machine)
- **Linear dimensions, tolerance $\leq \pm 0.1$ mm**
Micrometer, gauge blocks, altimeter, measuring machine
- **Fits**
Fits with gauges (plug gauge)
special diameter with three-point micrometer, altimeter, measuring machine
- **Geometric** **tolerances**
appropriate measurement setups, measuring machine, altimeter
- **Surface**
With comparison standard, surface measuring instrument

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4.3 Sheet metal parts

- External contours must not have sharp edges
- Round surrounding edges by 0.3 mm x 45°
- Surface treatment in accordance with drawing
- KOCH sheet metal parts are constructed with a K factor of 0.35
- Ensure that the **micro-bridge** is removed when cutting respectively cutting out contours

4.4 Sheet metal parts made of stainless steel

- Surfaces in accordance with drawing specifications
- Parts with indication of the arrow direction (↔) must be carried out in brushed surface quality (max. Ra 0.5 µm).
- Weld seams must be pickled. The components must be cleaned inside and outside from pickling residues!

4.5 Plastic parts

Parts made of plastic must not be barrel finished (trowalized).

4.6 Vacuum hardening

The drawing indicates whether the production part must be hardened and which hardening method shall be used.

4.7 Design surface | design part

Design surfaces respectively design parts must be manufactured with the highest quality and must appear optically perfect.

5 Welded assemblies

Almost all necessary information for welding is on the drawing.

Additionally, following guidelines apply:

- Black material with scale layers must not be used
- Welding beads must be removed from the component
- All external weld seams must be evenly slurred
- The KOCH part number must be placed so that it is also visible after varnishing
- The components must be exactly filled and grinded. Special attention should be paid to ensure that the roughness values are smaller than Rz = 100
- **Stainless steel welded assemblies:** weld seams must be pickled. The components must be cleaned inside and outside from pickling residues!

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6 Marking of production parts

6.1 Font size

- Font size: 3 mm
- Length of the seven-digit number: **28 mm** (standard)

All production parts must be marked with the product or drawing number, except it is not possible due to the size and characteristics of the parts.

Orientation and position see drawing details.

If there is no positioning of the marking given in the drawing, it is freely selectable.

6.2 Parts without marking

- Plexiglass parts, thin-walled tubes, pre-machined parts must be marked with adhesive labels. Small parts can be packed in labeled bags. Long, thin parts gathered in bundles (if possible) and mark bundles.

6.3 Round parts

Observe diameter:

- The product number or drawing number can be engraved on the lateral surfaces from a diameter of 10 mm. Front side marking of round parts is possible from a diameter of 20 mm

6.4 Form of marking

- Serial parts must only be marked with the seven-digit drawing number (e.g. 0307192)
- The marking must be carried out without blanks

If further code letters or numbers must be engraved on a part, they must not be used in connection with the drawing number.

General marking methods:

- Machine-made marking with full radius milling cutter ($r = 1\text{mm}$)
- Marking with engraving device (needle or graver)
- Marking by etching
- Adhesive labels with printing or manual marking (adhesive labels must be removed residue-free)
- Equip bags with printed adhesive tapes or bags with manual marking
- Markings with electric engraver, letter/number punches and waterproof pens are not permitted

For sheet metal parts the following must be observed:

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Sheet metal parts are equipped with drawing numbers by laser. The general marking methods are valid in special cases.

6.5 With steel frames

With marking of steel frames, it must be ensured that the drawing number is always in the vicinity of the leveling foot and clearly legible on the outside.

6.6 Machine-made marking

- Font size: **3 mm**
- Depth: **0.15 +/- 0.05 mm**
- Font: **Arial**

7 Shipment of production parts and assemblies

With shipment of production parts, it is preconditioned that they are:

- free from dirt
- wrapped in paper, cardboard or air bubble film
- not wrapped in stretch film
- well packed

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