



General terms of trade of the SC Plasmaterm SA. Investment casting foundry

1. Based on a request the seller prepares a written, non-binding quotation.
 2. A contract is to be issued between the seller and the buyer upon the buyers written order.
 3. The tools for the production may either be presented by the buyer or they may be manufactured by the seller according to the terms of the contract. The general manufacturing time is 45-60 days after the contract date and an advance payment of 50% of the tooling costs. The remaining amount of the tooling cost will be paid after the confirmation of the test samples. The products covered by the issued invoices are the property of SC Plasmaterm SA until full payment has arrived at Plasmaterm's bank account.
 4. The tools are the property of the buyer and are stored free of charge by the seller. The seller may only use the tools to produce the products ordered by the buyer and he may not give it to a third party.
 5. The products covered by the issued invoices are the property of SC Plasmaterm SA until full payment has arrived at Plasmaterm's bank account.
 6. Test samples (1-2 pcs) of the castings will be produced free of charge within 4 weeks after the tools are ready; will be placed at the buyer's disposal.
 7. The buyer is obliged to check the quality and dimensions of the cast samples and to inform the seller on his observations. The buyer will give free for production when all the observations and eventual modifications are correlated and confirmed. The blue print and any other technical documentation has to show clearly those modifications, which were consented by the parties.
 8. Delivery of the products can commence in 6 – 8 weeks from the date of confirmed PO, based on first come first served principle.
 9. The price and delivery conditions are EXW; the packaging will follow according to the contract specifications. Shipment costs are charged separately on the Invoice.
 10. The buyer accepts the obligation to pay the Invoice before delivery. Transfer costs are on the obligation of the buyer.
 11. Any transaction between the buyer and the seller is considered confidential.
 12. Technical specifications on deviations and tolerances as well as surface quality are according to D1/IT14 – VDG P690 DIN. On request a premium quality may be covered according to D2/IT14, which in most of the cases covers a higher price category. For information the most important specifications are given below. Any other data or conditions are subject to the agreement or contract.
 13. Any particular or special requirement will be made on the series of test samples and will be specified and emphasized in the contract, prior to the mass production.
 14. Any non-conformity has to be mentioned within a period of maximum 6 month from the receipt of the products.
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Investment castings tolerances

Specified by an international standard: VDG P690

Linear Tolerances

Nominal size mm	D1 Tolerance (general dimensions)	D2 Tolerance (some functional dimensions)
to 6	±0.15	±0.12
6 to 10	±0.18	±0.14
10 to 18	±0.22	±0.17
18 to 30	±0.26	±0.20
30 to 50	±0.40	±0.31
50 to 80	±0.45	±0.37
80 to 120	±0.55	±0.44
120 to 180	±0.80	±0.65
180 to 250	±1.20	±0.95
250 to 315	±1.30	±1.10
315 to 400	±1.80	±1.40

Tolerances for straightness, flatness, parallelity, shape

Precision class	Length of the tolerated element		
	to 25 mm	25 to 50 mm	up to 50 mm
	allowed difference		
D1	0.15 mm	0.25 mm	0.6%
D2	0.10 mm	0.20 mm	0.4%

Tolerances for angle values and right angles

Precision class	Nominal dimensions			
	to 30 mm	30 to 100 mm	100 to 200 mm	up to 200 mm
	allowed deviation			
D1				
minute degree	30	30	30	20
mm / 100 mm	0.87	0.87	0.87	0.58
D2	allowed deviation			
minute degree	30	20	15	15
mm / 100 mm	0.87	0.58	0.44	0.44

Surface quality according to ISO R 468, DIN 4769 and VSM 10321

	Ra [µm]	Rz [µm]	Rt [µm]
N 9	6.3-3.2	23-32	25-38