

GENERAL PROCESSING INSTRUCTIONS FOR PURCHASING OF CASTINGS & CASTING-MODELS



Spritzgiessautomaten

These work guidelines are based on the valid guidelines for drawing parts (supplied on request by BOY) as well as the Purchasing Conditions of Dr. Boy GmbH & Co. KG.

1. Starting point for the production of casting model are the drawings of the finish part including all information.
2. The casting model and the cast parts receive a 9401xxx part number. They can be found on the part drawing. Changes at the model have to be recorded and documented with an index (a-z).
3. On the cast part the respective model number, supplier label/mark and manufacturing date and, if required, a sequential number must be moulded clearly visible.
4. Changes at the modes are possible with the approval of Dr. Boy GmbH & Co. KG only.
5. The oversize material to be applied on the surfaces of the areas to be machined are specified in consultation with Dr. Boy GmbH & Co. KG.
6. The material and lifetime of the model have to be noted in the offer.
7. The models have to be approved by Dr. Boy GmbH & Co. KG. prior to production. In case of no release, BOY will not cover for any damages or costs of rework on the model.
8. Before production of serial parts the release of Dr. Boy GmbH & Co. KG is necessary.
9. Payment of the model takes place after successful machining of the samples and the first serial parts. After payment has been made, the model becomes property of Dr. Boy GmbH & Co. KG. Dr. Boy GmbH & Co. KG will receive comprehensive documentation (construction drawing & photos) of the model.
10. Verbal agreements are void.
11. The guideline for surface properties is DIN EN 1370. Following reference samples have been chosen (Scrata-card) A3 for surface roughness, B2 for inclusions on the surface and C2 to C3 for gaseous inclusions.
12. Components with (contraction/shrinkage?) cavities are to be separated, the damaged area is to be marked.

Furhter applicable documents

- form A000179: General guidelines for drawing parts
- drawing of the respective part

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Purchasing Department drawing parts