

AIR DUCTS

a) Pictures & Typical Paintshop



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a) Pictures & Typical Paintshop Amounts



Typical Paintshop Amounts:

» 500-50000 m² (contracted as one or several packages)

Installation period: 4-6 months

b) Requirements for Suppliers

- » Preferable manufacturing capacities for process ducts more than 500 m² per week
- » Scope for the supplier: Detail Design incl. assembly drawings, manufacturing and installation
- » ISO 9001 certification
- » Installation possible throughout Europe (desirably USA, Mexico, South Africa)
- » Site Manager must be fluent in German or English.



VENDOR DATA

Company: Klicken oder tippen Sie hier, um Text einzugeben.
Name: Klicken oder tippen Sie hier, um Text einzugeben.
Address: Klicken oder tippen Sie hier, um Text einzugeben.

	YES	NO
1. Tender preparation based on basic design layouts and duct lists	?	?
2. Detail design of the ducts and the fastening	?	?
3. work preparation department existing	?	?
4. Labeling of the ducts	?	?
5. Delivery of paint-compatible sealants (siliconefree)	?	?
6. Creation of shipping documents	?	?
7. Packaging (if necessary sea freight)	?	?
8. Timely delivery and transportation of the ducts to the construction site	?	?
9. Delivery of the entire holding and fastening material	?	?
10. Assembly organisation in accordance with agreed schedule	?	?
11. professional assembly	?	?
12. EN1090-certified	?	?
13. Construction site management	?	?
14. Site facilities (container, equipment) available	?	?
15. Temporary storage of the produced parts	?	?

b) Scope of work

1. Engineering Detail Design

- » Detail design of ducts as well as of fixing and suspension elements.
- » Production drawings and planning/process engineering for manufacturing
- » Assembly drawings incl. Parts list for installation on site.

2. Manufacturing and Shipment

- » „state of the art“ manufacturing according to drawings
- » Acceptance of Dürr quality standards
- » Labelling of components
- » Clean surfaces (silicon free paint compatible)
- » Packaging and shipment documents preparation
- » Transport and on time delivery

b) Scope of work

3. Installation

- » Unloading and storage on site (organized by contractor)
- » On site equipment transport (from storage to final positions)
- » Professional installation of the ducts according to assembly drawings, coordination of work
- » The erection of ducts will be done in time blocks, together with other work packages
- » Finishing, and touch up works
- » Disposal of Dürr materials and cleaning of work areas
- » All tools and lifting equipment to be provided by contractor (incl. office containers and scaffolding)
- » Dürr has experienced and qualified site organizer. The contractor manages its own part and assure to have experienced site manager as interface to Dürr .

c) Technical Information: Overview

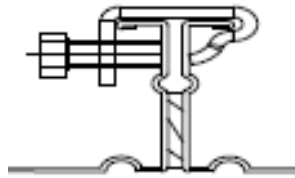
- » Geometrical designs are tubes and rectangular, main joining processes are welding, screwing and folding.
- » Dimensions of welded and bolted ducts are in range of max. 5000x4000 mm and diameter of max 2000 mm.
- » Typical materials: Stainless Steel (1.4307, 1.4541), aluminized steel (FAL), galvanized steel
- » Thickness: 0,7 mm – max. 3,0 mm.

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c) Technical Information: Types of Ducts

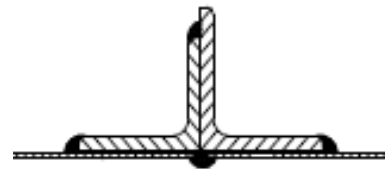
Air duct: Clamped flange

- Max edge length 2000 x 2000 mm
- Galvanized sheet, thickness 0,5 - 1,2 mm
- Edge folded
- Flange size 30 x 15 mm



Air duct: Angle steel

- Airtight welded
- Galvanized sheet, thickness 1,5 - 3 mm
- Straight site, welded

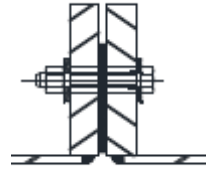


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c) Technical Information: Types of Ducts

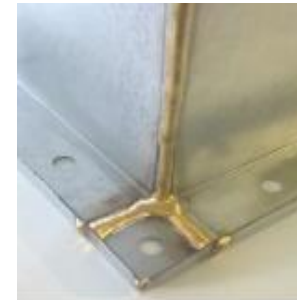
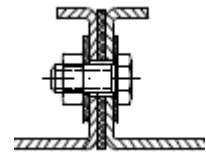
Air duct: Plate flange

- Galvanized, aluminized and SUS sheet thickness 1,5 - 3,0 mm
- Straight site, welded duct



Air duct: Edge folded flange

- Galvanized steel and Aluminized steel sheet (welded with AlBz8) thickness 1,5 - 3,0 mm (4 thickness variants in scope)
- Flange size 40 x 15 mm
- Bolted duct or welded, no rivets



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c) Technical Information: Types of Ducts

Air ducts : Turnup flange

- Galvanized, SUS and aluminized steel sheet (welded with AlBz8)
- thickness 1,5 - 2,0 mm
- Flange size 35 x 50 mm (example)
- Oven recirculation hot air, welded airtight



Air ducts : No flange, round

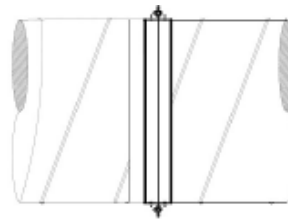
- Galvanized, aluminized steel sheet (welded with AlBz8) and SUS
- thickness 1,5 - 3,0 mm
- Flange size 35 x 50 mm (example)
- Sheet metal tubes welded tight.



c) Technical Information: Types of Ducts

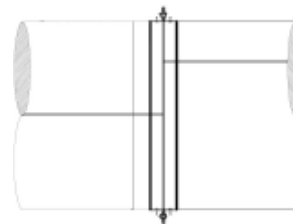
Air ducts : Round duct spiral wound

- Galvanized sheet metal thickness 0,6 - 1,2 mm
- Duct length ~ up to 6000 mm



Air ducts : Round duct longitudinal seam

- Galvanized sheet metal thickness 0,6 - 1,2 mm
- Flange size 8 mm



d) Basic Design

- » Tendering and contracting process on basis of basic design layouts and parts list of ducts and components.
- » The scopes are contracted based on unit prices (€/m²). Mounting parts are calculated per piece. Extra work on site will be payed on basis of claim notes signed by Dürr Site Management.