

## CUT-TO-LENGHT LINE

# FIMI CUT TO LENGTH LINE

## 1.200 x 0.3 ÷ 2.0 mm

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INDEX

INLET MATERIAL SPECIFICATION ..... 3

OUTLET MATERIAL SPECIFICATION..... 3

GENERAL DETAILS ..... 4

SCOPE OF SUPPLY ..... 6

PICTURES..... 7

PICTURES..... 8

PASS LINE & LAY OUT..... 9

DOCUMENTATION ..... 10

ON REQUEST ..... 11

COMMISSIONING AND SUPERVISION DURING ERECTION ..... 11

ON SITE ASSISTANCE FOR START-UP ..... 13

VENDOR LIST ..... 14

EXCLUSIONS ..... 16

GENERAL TERMS OF SALE APPLICABLE TO THE DELIVERY OF OUR MACHINES AND PLANTS..... 17

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**INLET MATERIAL SPECIFICATION**
***Inlet Material***

<b>Material Type</b>		Cold Rolled- Pre paint – Galvanized – Stainless steel	
Ultimate Tensile Strength		Max	750 N/mm <sup>2</sup>
Ultimate yield Strength		Max	450 N/mm <sup>2</sup>
Thickness	Min.	0.3	mm
	Max	2.0	mm
Width	Min.	500	mm
	Max	1200	mm
<b>Coil data</b>			
Weight	Max	10	T.
Internal diameter		508	mm
External diameter	Min.	850	mm
	Max	1600	mm

**OUTLET MATERIAL SPECIFICATION**
***Outlet Material***

<b>SHEET DATA</b>			
Length	Min-Max	300 - 4000	mm
Width	Min -Max	500 - 1200	mm
<b>BUNDLE DATA</b>			
Weight	Max	4	T.
Length	Min - Max	500 - 4000	mm
Width	Min - Max	500 - 1200	mm

## GENERAL DETAILS

### Characteristics of the line

Inlet Speed		0 – 10	m/min
Working speed	Max.	0 – 40	m/min
Working direction		Right-to Left	
Line reference		Center	
Pass Line height		1100 / 1200	mm about
Uncoiling		From the top side	
Working condition		Min. + 5°C Max. + 40°C	
Total length		18 Mt	
Total width		5 Mt	

### Electrical Characteristics

Three phase voltage		400 V	50 Hz
Auxiliary voltage		230 V	50 Hz
Solenoid valve voltage		24 V	50 Hz

### Hydraulic Characteristics

Hydraulic oil pressure		120	bar
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### Pneumatic Characteristics

Normal compressed air pressure		6	bar
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**Standard Colors**

Fixed parts	Green	Ral 6011
Mobiles parts	Cadmium Yellow	Ral 1021
Carters	Cadmium Yellow	Ral 1021
Hydraulic equipments	Galvanized	
Pneumatic equipments	Galvanized	
Electrical equipments	Grey	Ral 7035
Line protection:		
Net	Black	Ral 9005
Supports	Cadmium Yellow	Ral 1021

SCOPE OF SUPPLY

POS	DESCRIPTION	OPTION
1.01	COIL CAR	INCLUDED
1.02	UNCOILER WITH OVERHANG MANDREL	INCLUDED
1.03	COIL OPENING TABLE	INCLUDED
1.04	ENTRY PINCH -ROLL	INCLUDED
1.05	PEELER COIL OPENING	INCLUDED
1.06	FILM APPLICATOR DEVICE	INCLUDED
1.07	CROP SHEAR	INCLUDED
1.08	OVERPASSING TABLE	INCLUDED
1.09	SCRAP CARRIAGE	INCLUDED
1.10	6 HI LEVELLER 21 ROLLS	INCLUDED
1.11	TACHOMETER WHEEL	INCLUDED
1.12	FLYING CUT OFF	INCLUDED
1.13	FIRST EVACUATION CARPET	INCLUDED
1.14	OVERBRIDGE BELT CONVEYOR TO THE STACKER	INCLUDED
1.15	AUTOMATIC PACKING UNIT	INCLUDED
1.16	STACKING LIFTING PLATFORM WITH ROLLS CONVEYORS	INCLUDED
1.17	ROLLER WAYS FOR PALLET	INCLUDED
1.18	CHAIN CONVEYORS	INCLUDED
1.19	SAFETY PROTECTION	INCLUDED
1.19	HYDRAULIC & PNEUMATIC EQUIPMENT	INCLUDED
1.20	EXISTING ELECTRICAL CONTROL AUTOMATION SYSTEM	INCLUDED
1.21	INSTALLATION MATERIAL	INCLUDED
1.22	INSTALLATION AND SUPERVISION TO THE START UP	INCLUDED





PICTURES

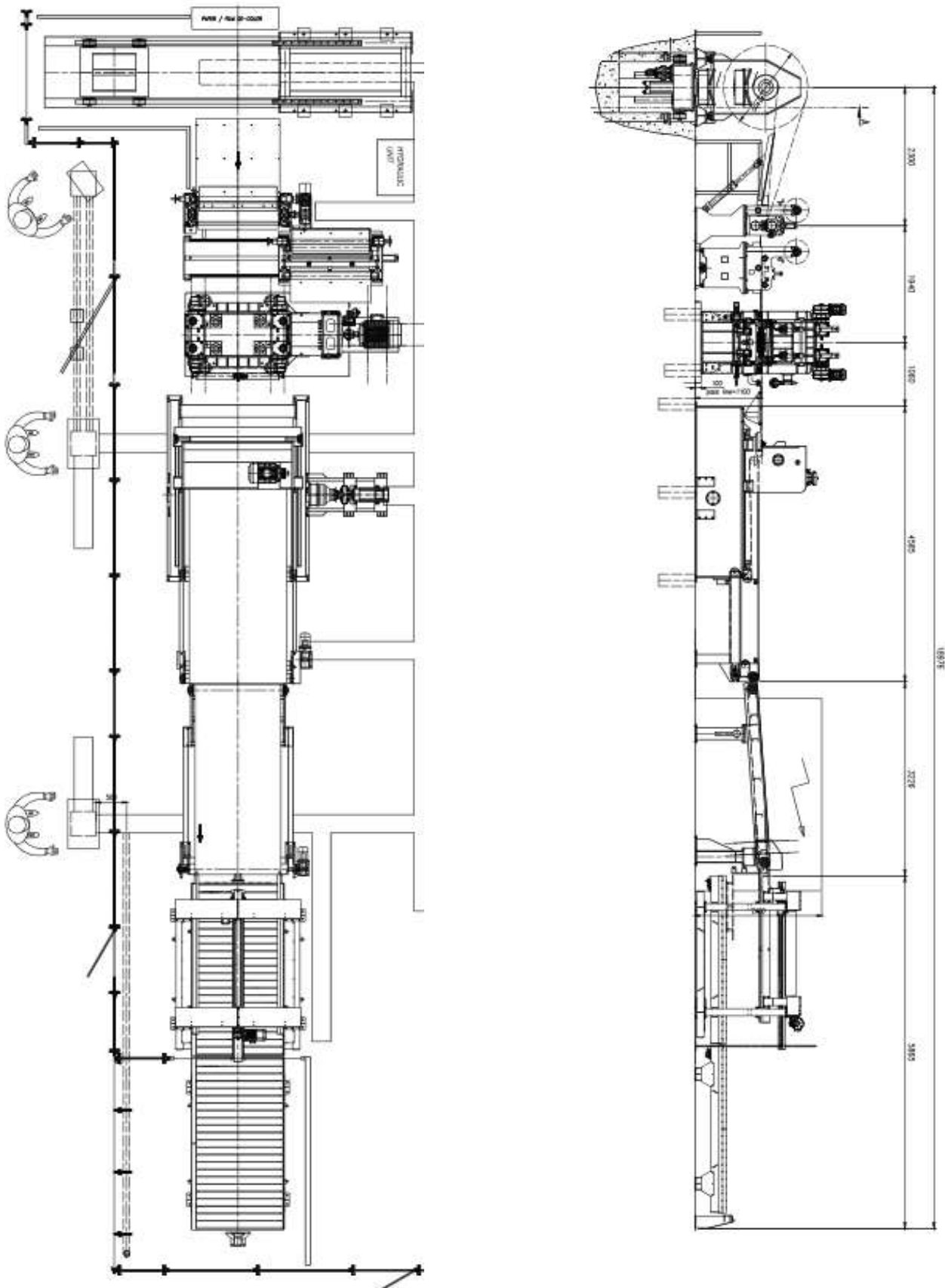




PICTURES





**PASS LINE & LAY OUT**


## DOCUMENTATION

Document	Language	CD copies
<b>During Basic Design stage:</b>		
Pass-line drawing	English	1
Lay-out drawing		1
Guideline foundation drawings with lists of the embedded materials		1
<b>Before delivery:</b>		
Quotation of recommended wearing and spare parts	English	1
<b>After line supply:</b>		
Handling instructions	English	1
General Safety Specification		1
Line manuals		1
Maintenance manuals		1
Assembly drawing of each machine, part list	English	1
Hydraulic, pneumatic and lubrication schemes with relevant component lists		1
Electric drawings		1
Control desks and electric cubicles lay-out		1
PLC software backup		1
Licence of run time software of Human Machine Interface		1

## EC DECLARATION

This offer is intended as supply of complete line, built, installed and launched by FIMI Spa.  
 For this supply Fimi will issue certification according to ANNEX II A to Directive 2006/42 / EC.

ON REQUEST

COMMISSIONING AND SUPERVISION DURING ERECTION

ACTIVITIES	RESPONSIBILITY		
	BUYER	FIMI	N.A
<b>INSTALLATION</b>			
RESPONSIBLE OF INSTALLATION	X		
SUPERVISORS		X	
SKILLED PERSONNEL	X		
TRAVELLING COSTS AND DAILY ALLOWANCES	X		
ACCOMMODATION	X		

<b>CONSTRUCTION WORK</b>			
FOUNDATIONS	X		
INSTALLATION ACCORDING TO LAYOUT	X		
DRILLING OF ANCHOR BOLT HOLES / POCKETS FOR ANCHOR BOLTS	X		
BASE LINES AND LEVELS	X		
VERIFICATION OF ALIGNMENT AND LEVELS OF EQUIPMENT (if included in the scope of supply)		X	
GROUTING	X		
WIRING WORKS	X		
PIPING WORKS	X		
FLUSHING OF HYDRAULIC OIL PIPING	X		

<b>TOOLS AND ERECTION MATERIALS</b>			
JACKS, WINCHES, LIFTING STRAPS, CRANES	X		
COMMON TOOLS FOR PERSONNE	X		
SPECIAL TOOLS	X		
WELDING TOOLS	X		
WELDING MACHINES	X		
ELECTRODES/WIRES AND WELDING GASES	X		
EXTENSION CABLES	X		
POWER SUPPLIES DISTRIBUTION (BEFORE THE CABINET)	X		
HYDRAULIC FLUID	X		
COMPRESSED AIR	X		
WATER	X		
LUBRICATING FLUIDS	X		
LUBRICATING FLUIDS, INITIAL FILLING	X		
CONSUMING MATERIALS	X		

ACTIVITIES	RESPONSIBILITY		
	BUYER	FIMI	N.A

ON SITE UNLOADING, STORAGE AND ASSEMBLY OF EQUIPMENT ON FOUNDATIONS			
TRUCKS UNLOADING	X		
STORAGE AND PROTECTION (AS APPLICABLE)	X		
REMOVAL OF EQUIPMENT FROM CONTAINERS/ CRATES AND TRANSFER ON FOUNDATIONS	X		
ASSEMBLY OF EQUIPMENT ON FOUNDATIONS	X		
INSTALLATION TOOLS	X		

ERECTION EQUIPMENT			
OVERHEAD CRANES (LIMITED, IF AVAILABLE AT SITE)	X		
MOBILE CRANES (AS NECESSARY)	X		
FORKLIFTS (LIMITED, IF AVAILABLE AT SITE)	X		

GENERAL			
INSTALLATION-SITE CLEANING	X		
SAFETY EQUIPMENT	X	X	
PERSONAL PROTECTION EQUIPMENT		X	
FIRST AID EQUIPMENT	X		
FIRE FIGHTING EQUIPMENT	X		
FIRE SECURITY AT WORKSITE	X		
WORKS SECURITY	X		
MEDICAL HEALTH	X		
WORKSITE LIGHTING	X		
DRESSING ROOM/OFFICE FOR FIMI S.P.A. SUPERVISORS	X		

COMMISSIONING			
FIRST FILLING OF GEAR BOXES AND HYDRAULIC POWER UNITS	X		
COMMISSIONING RESPONSIBILITY		X	
MECHANICAL OPERATORS		X	
ELECTRICAL OPERATORS		X	
PERSONNEL SUPPORT (AS NEEDED)	X		
FIRST PLANT ENERGIZING (CABINETS AND MACHINE)		X	
CHECK OF MAIN ELECTRICAL CONNECTIONS		X	
HYDRAULIC POWER UNITS (HPUs) START-UP / TESTING		X	
PLANT START-UP AND INITIAL PRODUCTION TEST	X	X	
ACCEPTANCE TEST (IF ANY)	X	X	
TRAINING		X	

**ON SITE ASSISTANCE FOR START-UP**

The supply includes a total amount (excluding travel) of

40	Man / days
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for the verification of alignment and completeness of installation, commissioning and start-up of the tube mill **excluding the ancillaries.**

The intervention will be in two steps:

**Verification of alignment (step 1):** once the equipment has been assembled, levelled and aligned, one mechanical specialist will arrive to the site to check the correct alignment of the entire equipment and give instructions to the customer for final grouting, wiring and piping works.

**Commissioning, start up and acceptance testing (step 2):** once wiring and piping works are completed, FIMI S.P.A. will send field engineers (normally one mechanical and one electronic) to start up the machine, train the operators, supervise initial production tests and acceptance tests.

**The number of required technicians that take part to each stage of all the activities and the schedule of interventions are mutually agreed, between FIMI S.P.A. and the Buyer, at a later stage.**

In case of necessity to extend the permanence of the technicians for a period, exceeding the days foreseen here in this contract for reason due to **FIMI S.P.A.** the additional days will be at FIMI s.p.a. care (not additional charge).

**In case of necessity to extend the permanence of the technicians for a period, exceeding the days foreseen here in this contract for reason due to the Buyer, the additional days will be separately invoiced at the cost of:**

1000	€/days per person
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**Travel costs, board, lodging in a suitable hotel and local transport are included in the scope of supply**

**Travel costs** includes flight ticket, airport from/to transportation and excess baggage penalties (if required for technical instrumentation).



## VENDOR LIST

This is intended as a Vendor List among which we reserve to choose one of the Supplier depending on the required technical specifications, delivery time of sub-supplier etc. In case the Customer/Buyer imposes one of the Suppliers (or any other which is outside the list), we reserve the right to apply an additional cost.

COMPONENT	BUILDER
<b>HYDRAULIC COMPONENTS</b>	
Hydraulic electro-valves	REXROTH - HYDAC – DUPLOMATIC
Hydraulic pumps	REXROTH - METARIS
Hydraulic filters	HYDAC – MAHLE – MP - REXROTH
Pneumatic components	FESTO - AVENTICS (ex REXROTH)
Components for oil forced lubrication	- Pumps: CASAPPA - Filters: MAHLE – FBO - HYDAC
Components for grease forced lubrication	DROPSA
Fittings for hydraulic equipment	Up to outer $\varnothing$ 42: according to DIN 2353 with cutting ring and sealing gasket Over outer $\varnothing$ 42: flanges SAE3000.
Fittings for pneumatic and lubrication equipment	- On machine board: according to DIN 2353 with cutting ring and sealing gasket - Connections between machines for pneumatic equipment : cast iron fittings in inches according to ISO 49 UNI 5192
Pipes	according to DIN 2391 Remark: for the pneumatic interconnecting pipes between machines: FM UNI 5745 ICQ 8608 (galvanized pipe)
Flexible pipes	SAE 100 R1A-DIN 20022 - 1ST SAE 100 R2A-DIN 20022 - 2ST - crimp fittings female 24° with OR - crimp fittings stand pipes
Collars for pipes fixing	Made of polypropylene
All the rest of the components refer to the main international builders.	

COMPONENT	BUILDER
MECHANICAL COMPONENTS	
Gearboxes	GSM – ROSSI - BREVINI – SEW
Hydraulic cylinders	Main national and international builders conform with ISO Norm 6020/2
Pneumatic cylinders	Main national and international builders conform with ISO Norm 6431
Bearings	Main national and international builders
Pneumatic brakes	COREMO
Mechanical jacks	UNIMEC
Geared A.C. motors	ROSSI - SEW
ELECTRICAL COMPONENTS	
A.C. drives	SIEMENS
A.C. VF type, main motors	SICME – SIEMENS - ABB
A.C. auxiliary motors	I.E.C. standards
Main contactors and relays	SIEMENS - SCHNEIDER
PLC of the line	SIEMENS
Modular cubicles with opening only on the front	FIMI standards
Limit and proximity switches	SICK - BALLUF
Push buttons, lamps a.s.o.	CEMA – SCHNEIDER - SIEMENS

## EXCLUSIONS

All that is not specified in our offer, and mainly:

- Sound-proof cabinets and devices for the line or single machine according to local, regional, State Laws and Regulations
- Environmental safety devices according to local, regional, State Laws and Regulations.
- Civil works
- Foundations
- Foundation plates with foundation plates supports, underground passages coverings
- Coverings in-between the machines and profile of foundation; coverings to be shaped at site according to profile of foundation
- Galleries and service boards
- Line basements over floor level and operator platform
- Compressor for compressed air
- Oil and grease for first filling
- Bridge crane and Hoists for erection at site (Buyer's supply)
- Air conditioning system
- Grounding system
- Lightning protection system
- Fire detection and fire-fighting systems
- Lights and sockets
- Communication and telephone system
- Video and cameras system
- Electric power supply with distribution transformers, protections and power centers
- Connection, protections and cables from our cubicle to low voltage distribution
- Strapping machines
- Load cells, operator terminal, label printer and system approval
- Spare parts
- Wearing parts
- Material for line test i.e. coils and packaging materials
- Development software of the PLC (Programmable Logic Controller)
- Development software of HMI (Human Machine Interface)
- Any taxes and/or import duties
- Everything, which is not stated in the present offer.

*The constructor reserve the right to modify the specification of the machine in order to improve the performances or other opportune reason.*

**GENERAL TERMS OF SALE APPLICABLE TO THE DELIVERY OF OUR MACHINES AND PLANTS****1 CONTRACT**

All Sales Contracts entered into by the Supplier incorporate these Conditions in so far as such conditions are not modified by any special terms or conditions agreed to in writing between the parties. An order from the purchaser is deemed to be accepted only after confirmation in writing by the Supplier. Any variations proposed by the Purchaser at a later date than the date of the Contract shall be valid only if accepted in writing by the Supplier. The Purchaser shall not assign his rights under the Contract without the previous written consent of the Supplier.

**2 SCOPE OF SUPPLY**

The scope of the supply shall be specified in the Technical Specification of the Contract. The supply of services and materials not provided for in the Contract will be invoiced separately and the invoices relating thereto will be payable on sight, unless otherwise agreed to in writing.

**3 PRICES AND TERMS OF PAYMENT**

- a) The prices, unless otherwise agreed in writing, are quoted ex-Supplier's factory and all payments are to be made to any of the Supplier's bank accounts in Italy. The said prices are quoted net of Italian Value Added tax and of any other taxes, duties or levies which may be payable in the case of supplies outside of Italy. Any additional expenses (e.g. for packing, shipping, import permits etc.) shall be borne solely by the Purchaser. If, notwithstanding the above provisions, it is expressly agreed that certain of the above expenses are included in the Purchase price and are thus to be borne by the Supplier, the latter shall have the right to amend the Purchase price accordingly if between the date of the Contract and the date of payment there has been an increase in such expenses.
- b) Delayed payments shall automatically bear interest at the rate of 1.4 per month from the due date, without formal notification to the Purchaser being required and without prejudice to the Supplier's right to terminate the contract and/or to claim damages. The Purchaser shall not be entitled to withhold payment of any amount payable under the contract to the Supplier if the Purchaser has not complied with the contractual terms of payment and the "solve et repete" doctrine shall apply in this connection.
- c) Where it is agreed that payment is to be effect by means of drafts, bill of exchange or endorsements, all duties and other expenses in connection with such instruments shall be borne by the Purchaser and the said instruments must be released before the delivery of the goods. In case of default the Supplier may terminate the contract without prejudice to his right to claim damages.
- d) If the Supplier agrees to vary the terms of payment stipulated in the contract by accepting payment by means of drafts, bill of exchange or endorsements, such variation shall not constitute a novation of the contract. In the event of such variation being agreed, the Purchaser undertakes to bear the costs of the discounting or financing operations and any commissions and associated expenses which may become payable.
- e) If delivery of the supplies is postponed either at the Purchaser's request or due to causes beyond the control of the Supplier's, the Supplier may at his discretion adjust the contract price to recuperate any additional expenses resulting from such postponement.

**4. ERECTION AND START-UP**

Unless otherwise agreed in writing, the erection and start-up of machinery or equipment is not included in the Contract. For these services the Supplier will provide the Purchaser at the appropriate time with the applicable ANIMA rates and such services will be invoiced separately. If erection is included in the contract, the Supplier's erectors shall work a 40 hour week (8 hours a day, Saturdays excluded), unless otherwise agreed in writing. During erection work the Purchaser shall be responsible for providing the necessary safety measures. The Supplier shall not be liable for any direct or indirect damages to goods or persons which may occur during erection work, or be caused by it. The Purchaser shall be responsible for obtaining any entry visas or work permits which may be required for the Supplier's personnel. The Purchaser shall also provide for the free entry into its country of all materials and tools required for the erection work. Furthermore, Supplier provides for erection and setting at work of equipments purchased in whatever period of the year, **except** for December and August. As soon as the buyer informs about:

- foundations achieved;
- available energies;
- raw materials ready for general tests and inspections;

the supplier binds himself in reaching the spot by 25 work days to carry out necessary setting at work services. If erection and start up are carried out by the Purchaser, at least one of the Supplier's supervisors must be present throughout the work and its services shall be invoiced to the Purchaser at the above mentioned ANIMA rates. In the absence of such supervision, the Supplier accepts no responsibility whatsoever for the proper operation of the machinery or equipment.

**5. PROPERTY**

The risk in all goods shall pass to the Purchaser upon delivery, but the property of the goods delivered shall remain vested with the Supplier until such time as the Supplier shall have received payment of the purchase price in full, whether or not agreement shall have been reached between the Supplier and the Purchaser for deferred payment terms. The Purchaser shall accordingly not be entitled to resell the goods nor to use any part thereof as security, until the purchase price has been paid in full. In the event of any legal action being brought by third parties which affects the goods in any way, the Purchaser shall promptly inform the Supplier thereof by letter, telex or telegram to enable the Supplier to take the appropriate steps forthwith. Non-compliance with the obligations contained in this clause shall give the Supplier the right to terminate the contract, such termination to be notified to the Purchaser by registered letter, without prejudice to any right of the Supplier to damages.

**6. DELIVERY**

Unless otherwise agreed in writing, delivery shall be made ex-Supplier's factory in Viganò. Dates or periods for delivery stated in the contract are approximate and not binding unless the parties agree to guaranteed delivery dates in the Contract. In such a case the delivery period shall start to run from the date of receipt of the first down payment specified in the contract and for the purposes of compliance with such terms, delivery shall be deemed to have taken place when notice is received by the Purchaser that the Goods are ready for shipment. The Supplier shall have the right to make partial shipments and to claim partial proportional payments. The delivery terms, whether guaranteed or otherwise, shall not apply if

- a) The Purchaser is late with payments.
- b) The Purchaser has failed to comply within the time specified, with any requirements requested by the Supplier to enable the latter to perform his obligations under the contract.
- c) The Purchaser has failed, upon the Supplier's request, to indicate within the time specified his approval of any drawings or plans sent to him by the Supplier.
- d) After the Contract is signed or the Supplier confirms the acceptance of the Order, the Purchaser request construction modifications, or any postponement of deliveries provided for in the contract.

Any variations or amendments requested by the Purchaser shall not relieve it from his obligations to comply with the terms of the contract, at the times specified therein. Any delays due to such events shall not entitle the Purchaser either to cancel the contract or to claim damages.

**7. TRANSPORTATION**

The goods shall travel at the Purchaser's risk, whether or not it is the Supplier who chooses the forwarding agent or carrier and whether or not under the terms of the contract the costs of transportation are borne by the Supplier. Should shipment of the goods or any part thereof be delayed by the Purchaser, the goods shall be stored at the Purchaser's risk and any storage expenses incurred shall be borne by the Purchaser. In such cases the warehouse receipt shall substitute the delivery documents for payment purposes.

**8. WARRANTY**

- a) Subject to the provisions hereof the Supplier undertakes to repair and make good any defect or failure which may arise within six months from the date of start-up or within 12 months from the date of the notice that the goods are ready for shipment, whichever is later.  
The Supplier shall bear the cost of replacing any defective parts, which shall become his property thereafter.  
The labour cost for the replacement of such parts shall be borne by the Purchaser.
- b) For equipment not manufactured by the Supplier, the applicable warranties shall be those given to the Supplier by his suppliers.
- c) Any claim or request for intervention must in order to be valid be made in writing on the day on which the defect or failure becomes apparent to the Purchaser or on the following day, and the Purchaser shall enable the Supplier or his representatives to carry out the necessary inspections and repairs. In this connection the Purchaser shall make available all the equipment and auxiliary personnel that the Supplier's representatives may require, as well as any accessory work (masonry work etc.).
- d) The Supplier shall not be liable for damage or injury to persons or goods resulting in any way from any defect in the goods, machinery or plant supplied under the contract. The Purchaser shall not be entitled to make any claim against the Supplier in respect of loss resulting from any shut down of the plant or from indirect or consequential damages.
- e) The warranty shall cease to be applicable if the Purchaser has in any way modified the goods, machinery or plant without the written consent of the Supplier; if the erection and/or start-up has been carried out without the Supplier's supervision (as mentioned in Clause 6); in any defect is due to material supplied or work carried out by the Purchaser or to improper use or maintenance (e.g. excessive loads, unsuitable materials, polluted water, etc.).
- f) Furthermore, the warranty shall cease to be applicable if the Purchaser is late with any payment due to the Supplier, even if such payment is related to another supply contract.

**9. SUSPENSION OR TERMINATION OF CONTRACT**

If the Purchaser shall make default in or commit a breach of any of its obligations to the Supplier, the Supplier shall have the right forthwith to suspend any supply under any order then subsisting. If the default or breach continues, the contract to which it relates and any other contract subsisting between the Supplier and Purchaser may be terminated by the Supplier by giving 15 days written notice of termination to the Purchaser. In the event of such termination the Supplier shall be entitled:

- a) To retain any payment made by the Purchaser up to the date of termination by way of indemnity.  
b) To claim further damages.  
Should at any time:  
(i) any event occur or proceedings commence as the result of which, under the laws of the country in which the Purchaser is incorporated or carries on business and/or the constitution of the Purchaser, the Purchaser must or may be placed wholly or partially in liquidation; or  
(ii) the Purchaser compound with its creditors or enter into any similar arrangement or have a Receiver or Trustee (or person with a similar function) appointed over all or any part of its assets or take or suffer any similar action in consequence of debt; or  
(iii) the Purchaser lose the whole of its paid up capital the Supplier shall be entitled, without prejudice to any right which he may have, to claim damages against the Purchaser, to require the Purchaser to furnish such guarantees as the Supplier may consider appropriate or to terminate the contract forthwith.

**10. FORCE MAJEURE**

The Supplier shall not be liable for any delay or for any consequence of any delay in the production, delivery or commissioning of any of the goods if such delay shall be due to fire, strike, lock-out, dispute with workmen, flood, accident, delay in transport, shortage of fuel, default of any sub-contractor, inability to obtain material, embargo, act or demand or requirement of any government department or local authority or as a consequence of war or of hostilities (whether war be declared or not) or to any other cause whatsoever beyond the Supplier's reasonable control. If any such delay occurs, the Supplier shall have the right either to claim an extension of the time for performing its obligations hereunder by such period (not limited to the length of the delay) as the Supplier may reasonably require to complete the performance of its obligations or to terminate the contract, without thereby incurring any liability for damages to the Purchaser, by giving 15 days written notice of termination to the Purchaser.

**11. JURISDICTION**

The contract shall be governed by and constructed in accordance with the laws of Italy. The Purchaser on entering into the contract submits to the jurisdiction of the Law-court of Milan. Any registration expenses shall be borne by the Purchaser.

As agreed upon that the supplier is the owner of the goods supplied as per contract till the last payment on the base of the regulations better specified in the art. 1523 and following of the Italian civil code.

**12. REGISTRATION OF THE CONTRACT**

In particular, in accordance with the provisions of art.1341 of the Civil Law, he approves the clauses n°3 (price & Payment), n°5 (Property), n°6 (Delivery), n°8 (Warranty), n°11 (Jurisdiction).

PURCHASER'S SIGNATURE