



## Purchase Process Specification

### **QEP-PS-01 COILED MATERIAL**

The purpose of this specification is to ensure the safe and economical usage of material within the press shop facility. **Deviations to this specification must be agreed in writing between QEP and the supplier before materials can be accepted.**

**Material Specification:** - As stated on the orders

**Country of Supply:** - Only European/American sourced material to be supplied.

**(Under no circumstances is Far Eastern manufactured material to be supplied.)**

**Tolerance:** - To the relevant British Standards or as stated on the order

**Form:** - To the relevant British Standards.  
In coil with rotary slit edges with minimum edge curvature and burrs. All coils must be flat across the strip width and **coil bow must be towards the inside of the coil not the outside, burrs from slitting must be facing down.**  
Coils must be tightly banded with one radial and three from the center to outside diameter **steel bands.**

**Coil Size:** - Inside diameter 400mm +/- 10mm  
Outside diameter 1 meter max +Nil / - 50mm or as stated on the order

**(Under no circumstances should batches of small coils not to the above sizes be supplied).**

**Quantity:** - Unless agreed in writing by QEP, the delivered quantity must be within **+/- 10% as stated on the order,**

Approved – P Harding

Date – 09/2/2016

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- Material Batches: -** All material of the same size shall be supplied from the same batch and C of C number per QEP order. Under no circumstances shall different batches of material be supplied to make up the ordered weight, unless agreed in writing.
- Surface finish: -** To the relevant British Standard.  
**(Must be free from scratches, rolling marks or imperfection)**
- Identification: -** Coil batches must be identified with labels and all paperwork must be supplied with the delivery.
- Certification: -** **A copy of the mill cert from the mother coil or full mechanical and chemical test certificates that reference the cast number** must be supplied, as well as stating the actual hardness values of the material, on all batches of steel supplied / delivered.
- SPC data on the material thickness, in the form of upper and lower CPK values must be available upon request for each batch of material supplied.
- Transport: -** Coils are to be dispatched on wooden pallets or bearers that allow easy access from the side of the vehicle so that a standard reach fork-truck can safely unload. The maximum weight of each lift shall be 1500Kg. **Each coil shall be separated by 20mm plus bearers** so that it allows safe and easy handling when they are to be used within QEP
- Packaging: -** The pallet of coiled material must be protected by stretch wrap, shrink wrap or polythene bag.
- Under no circumstances should different sized Coils be placed on the same Pallet.**
- Sticky tape must not be used to bind end of coils**