



Coopérative Essaada, Zhun
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Alger - Algérie

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0666 931 900 / 0557 239 211

GYPSUM BOARD PRODUCTION FACTORY

Powder Gypsum Production Line

Gypsum powder production line with **6,25 tons/hour (150 tons/day, 45,000 tons/year)** calcination unit, crushing-screening unit, gypsum grinding-separation unit.

Plasterboard Production Line

Setting belt speed : 8 m/min.
(**576 m²/hour, 13 824 m²/day, 4.15 million m²/year**)
(**192 pcs/hour, 4 600 pcs/day, 1.38 million pcs/year**)

Board thickness : 12,5mm
Board width : 1200 mm
Board length : 1800- 3000 mm
Dryer evaporation capacity : 3.5 ton H₂O/hr

(calculated on the basis of 300 working days in a year.)



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1 – Technical Description

1.1 General Descriptions:

Plant Location & Conditions

Client	: SARL ISO PLAQUE
Country	: ALGERIA
State	:
City / Area	:
Elevation	:
Climate	:
Temperature Max.	: °C
Temperature Max.	: -°C
Operating time	: 24 h/day, 300 days/year (7,200 h/year)

Fuel

Natural gas	
Calorific Value	: 8,200 kcal/Nm ³
Supply pressure	: max. 0.2 bar (pressure at battery limit burner site)

Electric Energy

Voltage	: 380 V
Frequency	: 50 Hz
Control Voltage	: 220 V, 50 Hz
Signal Voltage	: 24 V, Direct Current

Raw material

Water	
Town water (the exact specification to be clarified)	
Supply pressure	: 4 - 5 bar gauge (flow pressure)
Water temperature	: max. 20 °C



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1.2 Technical Data

SECTION 1 – Gypsum Powder Production Line

Design :

Capacity of gypsum powder productionline - 150 tons/day (6,25 tons/hour)

Gypsum Powder (semi-product)

A3 ratio should be less than % 3.

Natural gypsum rock will be used and degree of purity considered to be 94.8 % (on average). Related samples will be tested after signing agreement.

Gypsum rock content: $CL \leq 0.01\%$, $Na_2O \leq 0.05\%$, Silicium $\leq 0.5\%$

All our calculations are made according to above given data. In case of existence of undesirable feature, we reserve the right to make changes in the design. The most important is that properties of the gypsum rock, to be used in production processes, should vary $\pm 2.5\%$. We assume that grindability of gypsum rock as 100%.

Daily usage of gypsum rock will be approx. 180 tons/day.

According to above assumptions, fuel consumption is 270 kCal/kg cooked gypsum.

By assuming natural gas as 8,200 kCal/Nm³, consumption will be 170 Nm³/hour. (in this calculation purity of gypsum rock is assumed as 94.8% and moisture ratio as 2%)

Dust leak at the filters will be below 30 mg/ Nm³.

Total electricity consumption will be 630 kW. (Voltage:380 V, Control Voltage 220 V and Frequency 50 Hz)

SECTION 2 – Plasterboard Production Line

Design :

The Plasterboard plant is designed for a setting belt speed of **8 m/min (576 m²/hr** by nominal board).

The equipment offered is able to produce gypsum wallboards according to DIN 18 180 specifications. The customer has not specified any standards or regulations to be met for the design of the plant.

Nominal board : **12.5 x 1,200 x 2,500 mm**

Standard Dimensions

Width : 900, 1,200 mm
Thickness : 9.5 mm, 12.5 mm, 15 mm
Length : 1,800 - 3,000 mm
Longitudinal edges : full & tapered edges

Dry Board Weight

Gypsum wallboards : 8,0-9.0 kg/m² by nominal board
This figure may change according to used additives, quality of paper and etc.

Setting Time

Setting belt is designed according to speed of 8 m/min

Total time from mixer to knife : approx.60 m (7 min. 30 sec.)

Board Drying

Dryer evaporation : 2.7 t/hr (4.5 kg/m² by nominal board)

Wet production time for nominal board : 11.0 min

Drying time for nominal board : approx. 34.5 min.

This figure may change according to used additives, quality of paper and etc.

Board tolerances (by nominal board)

Board thickness : ± 0.25 mm

Board width : + 0 - 2.5 mm

Squareness : ± 1.5 mm

Maximum off square in 1,200 mm of width (nominal board)

Requirements for the finished product (wallboard)

Requirements and testing according to TS370.

- Type:
- Plasterboard building boards R volume mass $\sim 800 - 900 \text{ kg/m}^3$
 - Plasterboard fire-protection boards FR volume mass $\sim 850 - 1,050 \text{ kg/m}^3$
 - Plasterboard water resistance boards WR volume mass $\sim 850-1000 \text{ kg/m}^3$
 - Plasterboard WR boards and FR boards volume mass $\sim 850-1000 \text{ kg/m}^3$

Board cutting

The tolerances are better than $\pm 1.5 \text{ mm}$.

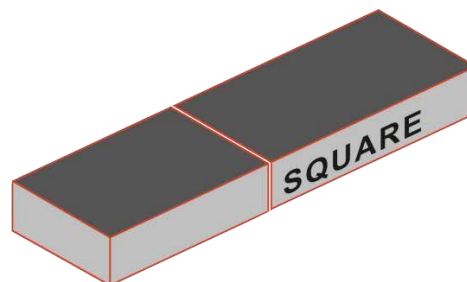
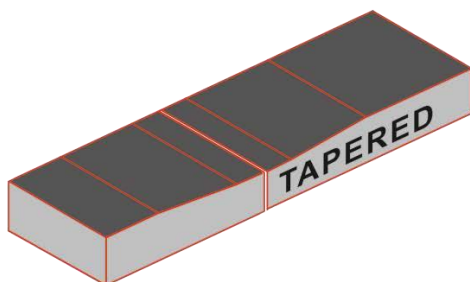
Based on the min. board length of 1,800 mm.

Board operating methods

Operating method A booking of 2 boards ivory side against ivory side

Edges

Full edge and tapered edge – are the two types of edges that will have the board be produced in the production line. These two types are included in our offer price. In case of need for other types of edge processing, they will be supplied for extra fee for each.





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Dryer data:

Dryer subdivision

The calculation for the dryer is based on the following conditions:

- direct heating
- running **more than 85 % nominal boards** (2 x side by side) 12.5 x 1,200 x 2,500 mm
- Water loss by nominal board : approx. 4.5 kg/m² (evaporation rate)
- Drying time by nominal board : approx. 34 min
- **Thermal consumption: 700 kcal/kg H₂O** (based on Net Calorific Value: 8,200 kcal/Nm³)

Number of zones total	: 10 pcs (each with a width of 2.4 m)
Deck space	: 300 mm
Number of decks	: 6
Dryer width	: 2,900 mm (2 boards 1.00 mm side by side)
Roller pitch	: 343 mm
Roller diameter	: 76.1 mm
In-feed tipple	: 10 m (moving)
In-feed	: 8 m
Total length of dryer	: 25.1 m
Out-feed - (cooling section)	: 10 m
Out-feed cascade	: 11 m
Overall length of the dryer including sealing sections, pre-zones and post-zones:	approx. 64m

Consumption values

Based on nominal boards and speed per m²

Plaster hemihydrates :	approx. 7.5 - 8.0 kg
Water : (max. 20°C)	approx. 5.6 - 6.5 kg
Paper :	approx. 2.1m ²
Starch :	approx. 0.020 - 0.040 kg
Edge glue :	approx. 0.005 - 0.006 kg
Retarder (depends on buyer)	approx. 0.040 - 0.060 kg
Accelerator (depends on buyer)	approx. 0.060 - 0.090 kg
Potassium (depends on buyer)	approx. 0.010 - 0.030 kg
Glass fibers (depends on buyer)	approx. 0.010 - 0.030 kg
Foam liquid (diluted) (depends on buyer)	approx. 0.004 - 0.010 kg
Natural gas :	approx. 0.350 - 0.430 m ³
Electric power consumption :	approx. 0.350 - 0.450 kWh
Compressed air (6 - 8 bar) :	approx. 0.300 - 0.400 m ³



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Energy Consumption:

Specific heat consumption

With a cross-ventilated Dryer with Heat Recovery system approx. **700 kcal/kg H₂O**, based on an evaporation rate of 4.5 kg H₂O/m² and calorific value of 8,200 kcal/kg with the designed setting belt speed and the nominal board.

Reservations:

As no analysis for the natural gas and the water was carried out at the time the proposal was prepared, the mechanical and electrical equipment and the prices calculated have been based on normal conditions. For other conditions we reserve the right to revise our prices correspondingly.

Electrical consumption:

The maximum electricity consumption : 0.45 kWh/m² (by nominal board).
Maximum power requirement : 630 KW

Stacking of boards:

One stack : stacking height from 600 mm to 800 mm
Stacking bearers will be placed on the stacks manually by hand (without pallets)
In case of use of pallets, pallets should be fed manually.



Manpower requirement for commissioning (should be provided by Customer)

This does not include administrative or management staff (plant manager, accounting, shipping.)

Gypsum Powder Production

	Personnel	Shifts	Total
Production			
Shift manager	1 supervisor	1	1
Wheel loader operator	1 Operator	1	1
System operator	2 Operator	3	6
Maintenance			
Machinery	2 mechanic	3	6
Electrical equipment	1 electrician	3	3
Laboratory			
Laborant	1 chemist	3	3

Plasterboard Production

	Personnel	Shifts	Total
Production			
Shift manager	1 supervisor	3	3
Cardboard and additives	1 operator	3	3
Mixer	2 operator	3	6
Setting line up to dryer inlet	1 operator	3	3
Dryer outlet	1 operator	3	3
Forklift truck	1 worker	3	3
Maintenance			
Machinery	1 mechanics	3	3
Electric	1 electricians	3	3
Laboratory			
Laborant	1 chemist	3	3

Erection and Commissioning for the Gypsum Powder and Plasterboard Production Factory

During erection process 1 (one) mechanical engineer and 1 (one) electrical-electronics engineer, during erection 1 (one) process engineer will be assigned by us.

The required auxiliary personnel (such as mechanical fitters, welders, electricians, etc.) plus the necessary tools for erection works will be furnished by the Buyer.

Duration of Erection Work: approx. 4.0 months

Duration of Commissioning: approx. 2.0 months



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The following MMM CODIN'S SUPPLIER - personnel will be at the site for the supervision of the erection and commissioning:

Gypsum Powder Production Line

Erection:

1 chief erector	: approx. 4.0 months;
2 masters (mechanics)	: approx. 4.0 months;
1 master fitter - electric	: approx. 1.5 months;
Total	: max. 13.5 man-months

Commissioning:

1 commissioning engineer	: approx. 1.0 months;
1 process engineer	: approx. 1.0 months;
1 mechanics master	: approx. 1.0 months;
2 electrical engineers	: approx. 1.0 month;
1 process engineer - for dryer	: approx. 2.0 month;
1 engineer - for burners	: approx. 0.5 month;
Total	: max.7.5 man-months

One (1) months before the start of the erection work, the Seller will hand over to the Buyer a list of the personnel (specifying number and qualifications for skilled workers and unskilled workers, i.e. helpers), and the list of the tools and/or lifting devices for erection which are also to be provided by the Buyer.

During the period of erection and commissioning, the parties to the contract will prepare regular reports each week on the status/progress of the erection/commissioning work.

Plasterboard Production Line

Erection:

1 chief erector	: approx. 3.0 months;
2 masters (mechanics)	: approx. 3.0 months;
2 master fitter - electric	: approx. 2.0 months;
Total	: max. 13.0 man-months

Commissioning:

1 chief commissioning	: approx. 1.0 months;
1 commissioning engineer	: approx. 1.0 months;
1 process engineer	: approx. 2.0 months;
1 mechanics master	: approx. 1.0 months;
3 electrical engineers	: approx. 1.0 month;
1 process engineer - for dryer	: approx. 2.0 month;
1 engineer for burners	: approx. 0.5 month;
Total	: max.10.5 man-months

One (1) months before the start of the erection work, the Seller will hand over to the Buyer a list of the personnel (specifying number and qualifications for skilled workers and unskilled workers, i.e. helpers) that the Buyer must provide plus a list of the tools and/or lifting devices for erection which are also to be provided by the Buyer.

During the period of erection and commissioning, the parties to the contract will prepare regular reports each week on the status/progress of the erection/commissioning work.



Engineering Services

Process engineering

- a) Plasterboard plant Layout with key dimensions
- b) Plasterboard plant Flow sheet
- c) Technical Specification

Detail engineering

Mechanic

- a) Plasterboard plant Layout with all necessary / important dimensions (more detailed)
- b) Preparing station Layout with all necessary / important dimensions
- c) Foundation / Platform drawings Plaster plant
- d) Foundation / Platform drawings Preparing station- Technical specification (more detailed)
- e) Layout / Load plan / Foundation plan for Board line
- f) Layout Dryer with air pipes and all important dimensions
- g) Flow sheet / PID Preparing station
- h) Flow sheet / PID Dryer
- i) Penetration drawings (Board line and Preparing station) general

General

- a) Process Description with block diagrams
- b) Energy consumption plans (Board line and Preparing station)
 - gas
 - compressed air
 - water
- c) Emission plans (Board line and Preparing station)
 - waste water
 - dust
 - NO_x
 - CO

Electric

- a) Installed power per main work shop
 - Preparing station
 - Setting line
 - Wet transfer
 - Dryer inlet
 - Dryer
 - Dryer outlet
 - Bundler (lining)
- b) Electric power single line Diagrams
- c) Control system architecture general

General

- a) Erection/Commissioning time schedule
- b) List of tools, manpower and shifts necessary for the erection



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Electrical Engineering

- Motor list
- List of sensors
- Circuit diagrams
- MCC projects
- PLC projects
- Terminal connection diagram
- Cable list
- PLC program in ladder-diagram format on CDs
- Erection planning with indication of required materials

Design Standards

General Notes

The equipment is designed and manufactured in compliance with the prevailing EC safety regulations. More in particular, the following standards apply:

- 98/37 EC Machinery directive
- 73/23 EEC Low voltage directive
- 89/336 EEC Electromagnetic compatibility

Subject to design modifications resulting from technical development or im- provement.

2. Milestones

2.1 Time of Delivery

Approx. Ex-works 6 - 10 months after clarification of all technical and commercial details.
(Concrete foundation plans will be delivered by us within 45 days after receipt of advance payment, the first shipment will be done the week after the finish of concrete works)

3. Commercial Conditions

The complete scope of supply remains the property of the seller until receipt of all payments. The application of the retention of ownership is not considered as a termination of the contract.

3.1 Effective Date of Contract

Unless and to the extent that no other terms will be agreed on, a contract between and binding upon the Parties shall become effective only after all of the following conditions have been fulfilled:

- The purchaser places an official purchase order with the vendor, or alternatively purchaser and vendor enter into a contract of sale.
- In case of a purchase order being placed in accordance with the conditions of this proposal, the vendor shall have sent the purchaser an acknowledgement of order within eight (8) days after receipt of the purchase order.
- The vendor has received the agreed down payment and can freely dispose of it.
- Required payment guarantees or other securities acceptable to the vendor have been submitted.
- All required permits and approvals (such as import and export licenses, re-import authorizations, building permits, etc.) have been obtained. The time of delivery as well as all other contractual periods will be counted from the date on which all of the above mentioned conditions have been fulfilled.



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3.2 Payment Conditions

3.2.1 Prices

Our proposal is based exclusively on the technical conditions set out in the technical specifications and shall apply only to the scope defined therein. In the event that only part of the scope offered is ordered by the purchaser, the vendor reserves the right to adjust its prices. The prices quoted in Section 4 of this proposal are **net** prices, not including any applicable taxes.

3.2.2 Delivery Conditions

All shipping expenditures is met by buyer. Goods will be delivered as loaded on trucks.

3.2.3. Price Basis for Erection and Commissioning

All expenses of accommodation, food and transportation is met by buyer. Food quality should be close to Turkish food and accommodation quality should be min. 3-star hotel level.

3.2.4. Price Basis, Taxes and Other Levies

The prices of this proposal do not include any parts, supplies and services that are not specifically mentioned nor any applicable taxes (such as value-added tax or sales tax in purchaser's country etc.), customs duties or other fiscal or parafiscal levies and fees.

3.2.5. Insurance

Our prices do not include transport insurance. The erection all risk (EAR) insurance cover will be contracted by the purchaser at its own expense.

3.2.6. Validity of Prices

The prices of our proposal are based on the current costs of materials and labor. In the event that this proposal does not result in a contract within the period of validity of this proposal, we reserve the right to adjust our prices in accordance with the change in these costs until a contract is concluded.

3.3. Terms of Payment

3.3.1. Payment Conditions of Supply

Payment of supply should be done as followings:

As payment security the purchaser provides a payment guarantee issued by a first class Bank in an amount of 70% of the total contract value to the vendor within 14 working days after receipt of the Vendor's acknowledgement of order.

We are open to discuss and agree with you alternative payment terms provided these are performance-oriented.

Payments for supplies shall be made as follows:

30 % of the order value as down payment. These 30 % shall be transferred cash to the account of MMM CODIN'S SUPPLIER MAKİNA A.Ş. in Turkey within 10 working days after the Buyer has confirmed the order with MMM CODIN'S SUPPLIER MAKİNA A.Ş.

70 % of the order value out of an irrevocable, confirmed and divisible Letter of Credit to be opened in favor of MMM CODIN'S SUPPLIER MAKİNA A.Ş. with a major Turkish bank, within 30 days after placing the order, payable in Turkish against presentation of the shipping documents. Payment out of the L/C will also be effected against warehouse receipt, if and as far as delivery cannot be performed at all or not in due time for reasons beyond the control of MMM CODIN'S SUPPLIER MAKİNA A.Ş.. Confirmation fees will be charged to account or according to special agreement.



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3.3.2. Late Payments and Default Interest

As regards default in payment, the purchaser shall be in default if a payment is due and the purchaser has not made the payment although the vendor has served a reminder, a court injunction or a default judgment on the purchaser.

For payments to be made on fixed calendar dates, the purchaser shall be in default as soon as the fixed payment date has passed and the purchaser has not paid punctually.

In such a case there will be no need for the vendor to serve a reminder on the purchaser to prove that the purchaser is in default.

For the duration of default 5 days should be added to the delivery time for each day of due payment. In late payments %2.5 of late payment fine will be invoiced to the buyer.

3.3.3. Reservation of Ownership

The ownership of the equipment supplied shall vest in the vendor until the equipment has been completely paid for.

3.4. Warranty

The vendor accepts liability for defects in its scope of supply which have their origin in faulty design and construction, use of bad materials or careless and faulty manufacture. The vendor shall, however, not be liable for defects resulting from normal wear and tear, faulty or negligent operation by the purchaser, non-observance of operating instructions or manuals, use of unsuitable consumables and utilities, improper use of the equipment or force majeure. More-over, the vendor's defects liability shall not apply to vendor-supplied parts which the purchaser has replaced or modified during the defects liability period without the vendor's prior consent.

The period during which the vendor can be held liable for such defects (defects liability period) under contracts for work and materials shall begin with the acceptance of the equipment by the purchaser and shall end twelve (12) months thereafter or at the latest twenty four (24) months after delivery of equipment.

Under a supply contract, the twelve (12) months defects liability period shall start upon delivery of the equipment.

In the event that a scheduled acceptance is delayed for more than two (2) months for reasons not attributable to the vendor, the equipment or plant supplied shall be deemed to have been accepted by the purchaser upon simple notification by the vendor.

The purchaser shall notify the vendor in writing of any defects that occur not later than two (2) calendar days of their discovery.

The vendor will remedy the defects under its defects liability by repairing or re-placing the defective parts at its own expense as soon as possible.

The vendor does not assume any liability for supplies and services provided by the purchaser.

Data, descriptions or other statements given in this proposal in respect of the quality, nature or characteristics of the goods and services to be provided shall not constitute guarantees or warranties unless such data descriptions or statements have been clearly and unequivocally characterized as such. In case of any serious flaws in the technical documents or in the engineering documentation, the vendor undertakes to eliminate these flaws by replacing at its choice either single pages, chapters or the entire documentation. Any further claims by the purchaser in connection with technical documents or engineering documents are excluded.

Any claims by the purchaser exceeding the limits set by this Section 3.4 shall be excluded. This shall apply in particular to claims for compensation for damage which did not occur to the equipment supplied. This limitation shall not apply whenever mandatory provisions of law, such as the law on product liability, provide for compensation for bodily injury or damage to privately owned property.



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3.5. Governing Law, Place of Jurisdiction

The contractual relationship between purchaser and vendor shall be governed and construed in accordance with Turkish substantive law. Purchaser and vendor shall settle amicably any disputes arising out of or in connection with the present contract between them. If they fail to reach an amicable settlement, these disputes shall be finally settled under the Rules of Conciliation and Arbitration of the International Chamber of Commerce by one or three arbitrators appointed in accordance with said rules. The place of arbitration shall be Ankara, TURKEY. The language of arbitration shall be the English language.

3.6. Force Majeure

The vendor does not assume any liability for disruptions and/or delays occurring during the performance of a contract as a result of force majeure. Force majeure shall mean any event that was unforeseeable at the time the contract was concluded, that was neither intended nor caused by the vendor or the purchaser, and that makes it impossible for the vendor and/or the purchaser to fulfill its contractual obligations. Events of force majeure shall include but not be limited to the following: Acts of God (such as earthquakes, fires, floods), wars, embargoes, riots and rebellions, strikes and lockouts, as well as laws, orders and/or regulations having the force of law issued by any governmental authority after the contract was signed.

3.7. Limitation of Liability

Apart from the vendor's liability for bodily injury or damage to property which the purchaser or any third party might suffer during the performance of the contract through the fault of the vendor or its employees, the vendor shall not be liable, for what ever legal reason, for indirect or consequential damages, in particular not for compensation of loss of use, revenue, profit or production, nor for compensation of costs resulting from any recall of products produced on the equipment supplied by the vendor. In the case of plain engineering jobs, the vendor's liability shall be limited to a maximum of thirty per cent (30%) of the contract value of such jobs. This limitation of liability to thirty per cent (30%) of the contract value shall also apply to damage caused in a downstream phase of the project as a result of incorrect or faulty engineering provided by the vendor. Any liability for engineering jobs exceeding this limitation shall be excluded. The limitation and exclusion of liability as per Section 3.7 shall apply to the extent consistent with mandatory law and regardless of whether the liability claim is based on breach of contract, breach of warranty, negligence, strict liability, tort or other legal theory, notwithstanding any provisions to the contrary that this proposal might contain.



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4. Prices

The stated prices are net prices and have a validity of 2 (two) months. Our prices may be subject to alteration in case the purchase order is placed after expiration of this validity period. Subject to price adjustment resulting from the clarification of all technical details and or the local, on-site conditions

4.1. Scope of Supply

4.1.1. Section - 1 : Gypsum Powder Production Line

100-Crushing-Screening Unit

200-Calcination Unit

300-Grinding Unit

- Electrical and Automation Equipments

- General Process Engineering

Price - Gypsum Powder Production Line :

1.255.000 Euro

4.1.2. Section - 2 : Plasterboard Production Line

200-Dry Preparing Unit

300-Wet Preparing Unit

400-Cardboard Preparing Unit

400-Forming, lining, cross-conveying

400-Dryer inlet, dryer, dryer outlet

400-Conveying

1600-Bundler feeding, Bundler and Packaging

- Electrical and Automation Equipments

- General Process Engineering

Price - Plasterboard Production Line:

2,830,000 Euro

4.1.2.2 Steel or Reinforced concrete building

Calcination Unit Building

Plasterboard plant building

Stock area building

Auxiliary units" building

Building coverings, isolation of roof, side surfaces, single layer steel sheet and skylight panels

2 x Automatic doors

3 x Personnel doors

Ventilation system to balance moisture in the plant building

Price - buildings:

CUSTOMER

TOTAL:

4,085,000 Euro



5. Limits of supply

Exclusions from our scope of supply

The following is *n o t* included in the scope of our offer:

- the soil investigations;
- the foundation work;
- the civil work (ONLY PROJECT);
- the road truck scale;
- the work shop equipment;
- the laboratory equipment;
- the furniture for the laboratory;
- the fire extinguishing equipment;
- the gas supply up to the consumers for the plaster- and plasterboard plant;
- the gas pressure reduction station;
- the internal equipment and electric equipment for the administrative building;
- the water supply for the plasterboard plant;
- the piping and ductwork for water;
- the quarry equipment and vehicles;
- the incoming cables up to the transformer with fastening material;
- the electric power;
- the transformer for the plaster and plasterboard plant;
- the medium and low voltage switch gear;
- the cable and installation material from the low-voltage distribution to the MCC cabinets;
- the cable and cable tray;
- the all silos, bins, pipes, chutes and reduction pipes, ladders, safety rails, platforms, support steel structure;
- the emergency power supply;
- the lighting system and fire protection equipment;
- the sound insulation of the plant;
- the thermal insulation of the plant;
- the telephone system;
- the camera and monitors;
- the fuel, coolants and lubricants as well as auxiliary materials, paper bags, pallets and foil;
- the compressed air generating and supply incl. all piping up to the consumers;
- the visualization system;
- the UPS system;
- the measuring device for measuring dust and gas emissions;
- the monitoring system for dust and gas emission;
- the spare and wear parts;
- the training of the personnel; (*)
- the cost of electric power and water during the erection time;
- the work shop drawings;
- the customs clearance;
- the transport from manufacturer's works to the site;
- the possible cost of customs duties, taxes and further charges in the country of Customer in connection with the deliveries;
- the bank and confirmation charges for the L/C; the parts not expressly mentioned in the technical specification.

(*) training of the personnel will take place during erection and commissioning.