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	Approved:	Dato: 25.01.2024

## 1. Responsible and scope

### 1.1 In general

Internal system for quality control of products and devices for:

Maskinfabrikken Cormall A/S  
Tornholm 3, Ragebøl  
6400 Sønderborg


Maskinfabrikken Cormall A/S's quality control must ensure that customers experience the company's products as professionally executed and that the quality of these live up to customers' expectations. Furthermore, quality control must form the basis for continued quality development of the company's products and the service of its customers.

Responsible for the internal quality control: CEO

The internal quality control is divided into seven main groups as listed below:

- 2.0 Control of raw materials.
- 3.0 Control of filler materials (welding) and other technical products.
- 4.0 Control of semi-finished products.
- 5.0 Checking of completed subcontracts.
- 6.0 Production control.
- 7.0 Final inspection.
- 8.0 Procedures for handling complaints.
- 9.0 Applicable standards and norms

Appendix 1: Aisi 316L procedure

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## 1.2 Scope


The quality system includes internal control of products in the following areas:

### Dairy farming products:

Auger mixers  
 Silos  
 Feeding table  
 Robot feeders

### Industrial plants:

Bale conveyors: BC  
 String remover: SR  
 Bale breakers: SBB  
 Straw mills: HDH and LSM  
 Meetering augers: TDA and TA  
 Straw scratchers: SS  
 Stone trap: ST  
 Filters: SF  
 Cyclones: C  
 Ventilators: Vent  
 Dust extraction units: DEU  
 Specially designed machines.  
 Specially ordered constructions and tasks .

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## 2. Control of raw materials

**2.1 Responsible:** Production & Logistics purchase

### 2.2 Control of raw materials

The control includes the following main topics:

1. Steel plates
2. Steel pipes
3. Profile pipes
4. Rod steel
5. Construction profiles

Procedure for receipt and control of raw materials


It is checked that quality and quantity correspond with the delivery note for each individual raw material category. The quality is examined by ordinary visual inspection. In case of doubt, control measurement is performed.

Materials that do not meet the requirements are marked "Do not use".

It is checked that the delivered raw materials according to the delivery note correspond to the requisition.

Delivery note is compared with invoice and requisition, after which delivery note, invoice copy and requisition are archived in alphabetical order. Raw materials are driven to the raw material warehouse immediately after approval.

The foreman decides what to do with any discarded raw materials.

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### 3. Control of additives and other technical products

**3.1 Responsible:** Logistics purchase

#### 3.2 Control of additives and other technical products

The control covers the following topics:

1. Welding consumables
2. Welding gases
3. Paint
4. Other technical products

#### 3.3 Procedure for receiving and checking additives and other technical products

It is checked that quality and quantity correspond to the delivery note for each product category.

The quality is examined by ordinary visual inspection.


Materials that do not meet the requirements are marked "Do not use".

It is checked that the delivered goods according to the delivery note comply with the commission.

Delivery note is compared with invoice and requisition, after which delivery note, invoice copy and requisition are archived in alphabetical order.

Raw materials are driven into stock immediately after approval.

The foreman decides what to do with any discarded goods.

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## 4. Control of semi-finished products

**4.1 Responsible:** Service & Stock Logistic

### 4.2 Definition of semi-finished products

Components whose properties and function are specified in the supplier's data sheet.

### 4.3 The control includes the following main topics:

1. OEM products (bearings, gears, electric motors, screws, bolts, etc.)
2. Components supplied according to Cormall's specifications

### 4.4 Procedure and scope


Control of semi-finished products is carried out on receipt.

The check is performed by comparing the ordered item and the supplier's type designation as well as general visual inspection.

Semi-finished products included as spare parts are checked upon dispatch.

Delivery note is compared with invoice and requisition, after which delivery note, invoice copy and requisition are archived in alphabetical order.

The foreman decides what to do with any discarded semi-finished products.

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## 5. Control of subcontracted deliveries

**5.1 Responsible:** Service

**5.2 Definition of subcontracting deliveries**

Components whose properties and function are specified by Maskinfabrikken Cormall A/S.

**5.3 The control includes the following main topics:**


1. Electrical controls.

**5.4 Procedure and scope**

Subcontracting is checked when the product is part of the production or at the final assembly.

When the system is connected to the power supply, it is checked that the controls meet the requirements specified by Cormall by performing a function test (see section 7, Final inspection).

Specification material is stored in a technical file for each individual product.

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## 6. Production control

**6.1 Responsible:** Production and CEO


**6.2 Procedure and scope**

According to the order, the respective drawings are handed out to the employees in production.

The operator checks that the working drawings provided comply with the drawings and specifications of the approved system.

Each employee is responsible for ensuring that the product is carried out in accordance with the specifications stated on the drawings, including dimensions, wall thickness, material type, welds, pressure testing, etc.

The production staff must notify the foreman of any errors or deficiencies found. The foreman then decides which actions to perform.

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## 7. Final inspection

**7.1 Responsible:** Service

**7.2 Procedure and scope**


The final inspection is carried out immediately before transfer to the warehouse or before shipment. The final inspection is carried out 100% for all plants and machines.

The following items are covered by the final inspection of the products, the final inspection help form is kept in a technical dossier for each individual product (entered in help form no. 7.1):

1. Names of the inspectors, machine type, order number, serial number, date.
2. The surface of the products is neither scratched nor dented.
3. Products are leak tested and provided with the correct type plate.
4. Pumps, taps and valves are fitted and operate as intended.
5. Documentation and EU declaration.
6. Safety equipment.
7. Joints and welds are estimated to be performed satisfactorily.
8. Supplied accessories (installation and operating instructions).
9. Function test.
  - 9.1 Electrical test.
  - 9.2 Manual test.

In addition, an order check form is prepared, which is also archived in the technical dossier for each individual unit.



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## 8. Procedure for handling complaints

Inquiries regarding complaints and grievances from customers, dealers, authorities, etc. registered in form 8.1.


The following information must be registered by the recipient of the complaint:

1. Date of inquiry.
2. Customer or company name.
3. Address, telephone no. and e-mail
4. Machine type, model and machines.
5. Type of error / defect and possibly cause of the error.

All registrations of complaints must be kept for a minimum of two years.

Complaint cases are processed as far as possible immediately, possibly by telephone.

If a visit to the customer is required, an appointment is agreed as soon as possible. The agreement must normally be made no later than 1 week after receipt of the complaint.


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### 9. Applicable standards/norms internal and for subcontractors

Risk analyse	EN-ISO 13849-1
Safety of Machinery - Electrical Equipment	EN 60204-1:2006
Emergency stop, January 29th 2007	EN ISO 13850
Safety related parts of control systems	EN ISO 13849-1
CE marking system	ISO 1090 exc 2
Welding control system	ISO 3834 exc 2
Painting: Alkaline degreaser with primer and top coating, RAL: 3001 red Non corrosive environment, water and oil resistant -15/60 C	ISO 12944-5 Cat. C2

  
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 Jens J. Hansen

Dato: 25.01.2024

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#### Appendix 1: Welding of AISI 316 acid and stainless steel

Procedure	Thread	Gas
AISI 316 – AISI 316	316 LSI Welding center south or similar	Inomax 2
AISI 316 – normal black Iron		

#### Finishing 304 and 316 in painting cabin:

Application	Processing
Internal plate cover on MTX mixers, for maize and grass silage or the like. similar. AISI 304 og 316	<p><b>Weldings:</b> 100 % of all welding is cleaned with AISI 316 rotor brush until no black colour appears, and welding's are shiny</p> <p><b>Exterior of machine:</b> - Normal surface cleaning, priming and cleaning and varnishing</p> <p><b>Inside where the acidic material comes into contact with the material:</b> - The iron acids away and the chrome remains and protects, therefore cleans and primers, nothing else. The primer protects where the acid takes longer to work.</p>
Salt and chlorine-like material Only AISI 316 can be used for this	<p><b>Weldings:</b> 100 % of all welding is cleaned with AISI 316 rotor brush until no black colour appears, and welding's are shiny</p> <p><b>Exterior of machine:</b> - If it is not in contact with the material, then it is enough to clean, primer and varnish it</p> <p><b>Inside:</b> - All welds must be sanded clean, - DO NOT GRIND! The welding must remain. Special sanding discs are used, which "polish" welding and on the sides of welding until there is no discoloration / tarnishing. - After this, the surface is cleaned and primed. - Ensures good cleaning where the bending machine has pressed into the material. If sheets of plastic wrap are used on the outside, this is not necessary.</p>