



GENERAL CONDITIONS FOR
THE SALE OF GOODS AND
VALUE-ADDED SERVICES

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REVIEW AND APPROVAL

This document has been reviewed by the following persons:

Name	Charge	Approval
Martín Moreno	Managing Director	Electronically approved on May 3rd, 2022
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GENERAL CONDITIONS FOR THE SALE OF VALUE-ADDED GOODS AND SERVICES

These conditions and terms (hereinafter "General Conditions") regulate the commercial relationship between voestalpine High Performance Metals del Perú S.A. (hereinafter "vaHPM Peru") and the CLIENT. These General Conditions are an integral part of the sales agreements of goods and services that will be made with vaHPM Peru.

Unless otherwise agreed in writing by the parties, the following general terms and conditions shall apply exclusively to the sale of products and services. These General Conditions will also apply even if their application has not been expressly and explicitly agreed.

These General Conditions are available at

<https://www.voestalpine.com/highperformancemetals/peru/es/home/empresa/condiciones-generales-de-venta-y-compra/>

COMMERCIAL ASPECTS

1. Unless otherwise specified, the quotes will be valid for a period of 07 days from the day of delivery to the CLIENT, unless previously sold or updated. The quotation may include the total price, the unit price, the method of payment, the unit of sale, delivery time, place and method of collection and/or delivery.
2. It is the responsibility of the CLIENT to review the quotes issued by the company. The placement of the order based on a verbal or written quote constitutes the approval of the same by the CLIENT. Any error associated with quotes that have been approved by the CLIENT will be the sole responsibility of the CLIENT.
3. Purchase orders will be accepted in which the products and services are designated with different trade names, however, our quotes and payment vouchers will be issued designating the products with the trade name of vaHPM Peru.
4. It is necessary for the CLIENT to provide the following data: name of the contact person, email, telephone numbers, address, service required, material that delivers. Delays in delivery due to erroneous data provided by the CLIENT are not the responsibility of vaHPM Peru.

TECHNICAL ASPECTS AND TECHNICAL ADVICE

5. The technical characteristics of our products and related aspects to consider when purchasing them are available on our website: <https://www.voestalpine.com/highperformancemetals/peru/es/home/productos-marcas/>, product manuals and technical sheets.
6. The Technical Advice at vaHPM Peru is offered by qualified engineers and technicians with extensive experience, based on the information provided by the CLIENT. It is under the responsibility of the CLIENT to provide accurate and complete information on the subject of consultation, the proper use of the guidance provided and the review and mechanical engineering calculations that are necessary. Therefore, this technical advice only serves as guidance for the specific application expressed by the CLIENT and does not imply any responsibility for vaHPM Peru.
7. The material recommendations made by vaHPM Peru from the samples provided by the CLIENT are considered as mere references and the CLIENT assumes all responsibility for the suggestions provided and for the purchase of the suggested material.
8. vaHPM Peru reserves the right not to accept the service to any piece if the CLIENT does not follow the recommendations provided by our technical staff.
9. vaHPM Peru will not guarantee the suitability for a special purpose of the product.

PRICES AND PAYMENT METHOD

10. Unless vaHPM Peru specifies otherwise, the applicable prices will be those offered in the quotation. Any price change will be requested in writing from the CLIENT to vaHPM Peru. As long as vaHPM Peru does not approve in writing the

- price change, the price offered in the quotation will be valid and applicable for the confirmation of the order.
11. All prices of products and services are quoted for collection at our facilities and do not include packing and shipping costs, unless agreed in writing.
 12. Our invoices will be due from the time of delivery or when the CLIENT is notified of the availability to pick up. Payment will be made in cash or by free transfer.
 13. If the CLIENT does not make the payment within the due date a 1.5% monthly interest will be applied on the delayed amount of payment for each day.
 14. In case of breach of the payment obligation, the CLIENT agrees to reimburse all claim and collection costs and the cost of legal claiming including reasonable attorney's fees.
 15. In the case of quotes and orders issued in dollars (USD), if the CLIENT wishes to pay in soles (PEN), the sale exchange rate of the day of cancellation of the proof of payment will be taken into account that is on the website of Superintendencia de Banca, Seguros y AFP (www.sbs.gob.pe).

DELIVERY TIMES

16. The delivery time is variable. vaHPM Peru will issue an order confirmation, an offer or other declarations or commitments and will assume the obligations of delivery and execution of the service resulting from it, subject to the reservation or express condition of our timely and sufficient supply by our manufacturers and suppliers with resources (in particular: equipment or means of transport, cutting equipment, alloys, graphite electrodes, supplies, refractories, gas, electricity, fuels, etc.) necessary for the fulfillment of the offer (hereinafter referred to collectively as "Resources Impairment").
17. If the reduction in the availability of resources causes a permanent or temporary impossibility, substantial difficulties or delays due to these circumstances beyond our control, we will not breach the contract nor will we be responsible for any breach or delay, provided that we have notified the CLIENT (sufficient email) of the circumstances as soon as reasonably possible and of the anticipated or possible duration of the effect on the fulfillment of our delivery and service obligations.
18. If the parties do not reach an agreement within a reasonable period of time, the corresponding vaHPM Peru obligations will be suspended and the delivery periods and/or dates for the fulfillment of our delivery and fulfillment obligations will be extended for the duration of the temporary impossibility, substantial impediment or delay. If the Resources Impairment prevents, hinders or delays the performance of our delivery and service obligations for more than two weeks after the aforementioned extension, either party shall be entitled to terminate the contract in whole or in part. In this case, the parties will reverse all services provided to date to the exclusion of other claims of any kind and, in particular, vaHPM Peru will immediately reimburse THE CLIENT for any consideration already paid in advance.
19. In case it is necessary to import exclusively to fulfill an order, the commitment for the delivery time will be variable, depending on the product requested, availability and production factory; therefore, each case will be dealt with in a particular way. Once the request has been formally made and a delivery time has been proposed, the CLIENT will be previously warned of any delays that may occur due to difficulties in importing the product, not assuming any type of penalty for this concept.
20. In case of not being able to make the delivery for any reason attributable to the CLIENT, the CLIENT will be responsible for making all the mandatory payments as if the delivery had been made. vaHPM Peru will guarantee the storage of the products with the risks and expenses associated with the delivery to be covered by the CLIENT. In this case, all costs will be borne by the CLIENT.
21. If the CLIENT does not accept the delivery of the goods or service until the agreed final acceptance date or the delivery date, for reasons attributable to the CLIENT, vaHPM Peru is entitled to charge a penalty in the amount of a certain % of the purchase price per week started from the breach of the acceptance.
22. The content and scope of our obligations are specified in vaHPM Peru's written order confirmation, to the extent that it has been issued. Otherwise, vaHPM Peru's delivery terms will be binding. vaHPM Peru reserves the right to make changes in the design and in the composition of the products, as well as other reasonable changes. Unless otherwise indicated, delivery dates are determined from the date of order confirmation. Otherwise, a standard commercial delivery time will apply. The delivery deadline is met if the goods are shipped or if the CLIENT has been notified that the goods are ready for collection before the expiration of the deadline. vaHPM Peru has the right to make partial deliveries and to issue separate invoices thereof.
23. vaHPM Peru will be responsible for maintaining and storing materials with the completed service process for a maximum period of 7 days.
24. The technical and/or service reports are delivered through email, unless a different delivery condition has been agreed with the CLIENT.

INSPECTION / QUALITY CONTROL

25. vaHPM Peru, upon request and in order to verify compliance with the contract, will inspect the products before dispatch. The costs and expenses associated with any testing, inspection or certification requested by the CLIENT will be covered by the CLIENT.

DISPATCH AND DISTRIBUTION

26. The responsibility of vaHPM Peru, when it is in charge of the distribution of the merchandise, is limited exclusively to the metropolitan Lima area. For deliveries to other regions, the CLIENT must choose the transport company in which he wants his merchandise to be transported. In this case, when vaHPM Peru is in charge the distribution, the responsibility reaches the terminal of the transport company chosen by the CLIENT.
27. When vaHPM Peru is in charge of the distribution of the goods, the CLIENT must provide all the necessary information such as name of the contact person and telephone numbers, person to receive the merchandise and phone numbers, dates and times of attention in the warehouses of the CLIENT.
28. When there are delays in delivery or this cannot occur for reasons attributable to the CLIENT, vaHPM Peru will not be responsible and may apply penalties for freight, storage and others.
29. In the case of collection of the goods in our warehouses, vaHPM Peru is responsible for the loading activities to the CLIENT's vehicle in the event that mechanical aids are required. If the CLIENT's vehicle is not suitable for the operation (load capacity, dimensions, etc.) we are not obliged to carry out the loading operations, committing the CLIENT to collect their goods in a suitable vehicle
30. In the case of the delivery or collection of goods at the CLIENT's premises, the CLIENT is responsible for all loading and unloading operations.

OWNERSHIP OF THE GOODS

31. vaHPM Peru will retain legal ownership of the goods delivered until the CLIENT has completely paid the purchase price including accrued late interest, claim fees, collection fees and litigation costs.

CERTIFICATES

32. At the request of the CLIENT, the Purchase Certificates or Quality Certificates of the materials are issued.
33. In the case of products classified as short-cuts only "Proofs of Purchase" will be delivered at the request of the CLIENT. A Chemical Analysis Certificate or Quality Certificate may not be delivered in the case of these materials.

CLAIMS AND WARRANTY

34. The CLIENT is responsible for making the respective inspection of the goods at the time of receipt of the same by him. In the event of detecting a defect a claim must be made to vaHPM Peru without delay along with the written report indicating the nature and impact of said defect.
35. Regarding the warranty for claim for goods, this must be made no later than six (6) months later and, in the case of machines / equipment have up to one (1) year warranty for manufacturing defects according to the manufacturer's declaration at the issuance of the invoice. In order to make a formal claim, the CLIENT must present the invoice accompanied by a technical report of support for the claim. Acceptance of the claim is subject to a commercial and technical evaluation. If the claim is founded, vaHPM Peru will return a sum no greater than the value of the good, not covering expenses such as machining, finishing or other applied.
36. Regarding the warranty for claims of services, it must be made no later than thirty (30) calendar days after the date of delivery of the service. In order to make a formal claim, the CLIENT must present the invoice accompanied by a technical report of support for the claim and make the pieces available for analysis. Acceptance of the claim is subject to a commercial and technical evaluation. The responsibility of vaHPM Peru will not be greater than the value of the service, not covering in any case other expenses such as machining, material, etc. If the claim is founded, vaHPM Peru will return a sum no greater than the value of the service provided.
37. vaHPM Peru is only responsible for any damages that the CLIENT may suffer in the event that they arise from a breach by vaHPM Peru of the contractual obligations, subject to the following limitations

- » vaHPM Peru will not be liable for any direct or indirect damages or losses arising as a result of the defect in the products.
 - » We will not be responsible for the damages caused to third parties arising from the use of any of our products in applications where engineering calculations have not been made as the responsibility of the CLIENT, nor has vaHPM Peru been informed about the use or application of our products in elements of greater responsibility.
 - » We will not be liable for any damages that may have been caused due to the improper use of any of our products. It is the responsibility of the CLIENT to inform the specific use that will give to the material to be acquired in order to be able to provide the appropriate technical advice.
38. For the resolution or interpretation of any dispute or question relating to the sale, products, advice and/or services provided by vaHPM Peru, the parties shall submit to an arbitration of law in accordance with the provisions of Legislative Decree No. 1071 to be conducted in accordance with the rules relating to the process contained in the Code of Civil Procedure. For such purposes, both parties agree that the arbitral tribunal shall be composed of a sole arbitrator who shall be appointed by the Arbitration Center of the Chamber of Commerce of Lima. Both parties expressly agree that the arbitrator's fees will be fixed according to the scale of the Arbitration Center of the Chamber of Commerce of Lima and will be settled by both parties in a proportional manner and the award that is issued will be final and unappealable.
39. In case of any default notice delivered by the CLIENT in accordance with Article 23, vaHPM Peru will carry out the required inspections. With respect to the claim for defects, the parties agree to submit to the result of the technical report issued by the Materials Control Laboratory of vaHPM Peru or, unless agreed between the parties, by the Materials Control Laboratory of the Pontifical Catholic University of Peru in order to identify the cause of the defect that generated said claim. Deviations in quality, shape, dimensional accuracy, colour, weight or equipment that are habitual or of a lesser degree or technically unavoidable cannot be considered a defect and cannot be disputed. This also applies to delivery according to sample and specimen.

EXCHANGES AND RETURNS

40. The reasons for an exchange or return are:
- a) When the provisions of article 37 of this document are complied with.
 - b) When differences are identified between what is delivered and what is quoted
41. All exchanges or returns must be channelled through our sales team. Exchanges are subject to stock availability and our sales team will verify availability at the time of request.
42. Exchanges or returns of products will proceed only if:
- a) Delivery of the original product is made
 - b) It is in its original packaging (drawer, box, plastic, etc.)
 - c) The products have not been used or processed
 - d) The products are not damaged

SAMPLES AND PARTS OWNED BY THE CLIENT

43. In case of any wear and tear for reasons that cannot be attributed to vaHPM Peru, the process of repairing the samples and parts owned by the CLIENT and under the responsibility of vaHPM Peru will be carried out by the CLIENT. vaHPM Peru will be responsible for the protection of these samples and parts during the agreed delivery time. In the event that these samples and parts remain in vaHPM Peru after the delivery deadline, unless otherwise agreed, vaHPM Peru will store and retain those on behalf of the CLIENT subject to the restrictions set forth in these General Conditions. The protection and safeguarding of all these samples and parts will be at the risk of the CLIENT. vaHPM Peru, reserves the right to discard or return these samples and parts three years after delivery of the products. The transportation of these tools and models is within the scope of the CLIENT's risk and costs. The term "samples and parts", in this context, will include all equipment owned by the CLIENT that the CLIENT delivers for the perform of the agreed services.
44. After 7 days of the service and not having been removed the merchandise from our plant, the CLIENT will be charged an amount of S / . 1.00 per kg per day for deposit in accordance with article 1851 of the Civil Code. According to article 1852 of the Civil Code, vaHPM Peru will retain the goods until they are paid what they are owed, for the service

and deposit. In the event that three months have elapsed without the CLIENT complying with collecting the goods and making the aforementioned payment, the CLIENT hereby expressly declares that he delivers the goods in payment to voestalpine High Performance Metals del Perú S.A. in accordance with the provisions of article 1265 of the Civil Code.

RESPONSIBILITY OF THE CLIENT

45. The CLIENT is aware of and will fully comply with all national and international export and re-export control laws and regulations, sanctions and embargoes, and their modifications, including, without limitation, restrictions on domestic transactions, brokerage services and anti-circumvention prohibitions that apply directly or indirectly to its activities (including the resale of our products), as well as the internal resolutions of the voestalpine Group (to the extent that they are available to the CLIENT) in relation to the supply of products or services to specified countries, specified end-users or for specified end-uses.
46. In the event that our products are delivered the military or nuclear industry, vaHPM Peru must be informed in a timely manner to manage the necessary permits within the voestalpine group.
47. In the event that the products are delivered in accordance with the plans, models or other tools delivered by the CLIENT or the description or instructions provided by the CLIENT, the CLIENT will exempt vaHPM Peru from the breach and infringement of third party rights such as patent, tool or trademark.

CANCELLATION

48. The CLIENT has no right to cancel any delivery without the approval of vaHPM Peru for any reason.
49. If the CLIENT refuses to receive the products he will bear all shipping and storage costs. The purchase price expires immediately when receipt of the products is refused. Optionally, vaHPM Peru reserves the right to demand compensation due to this breach.

MAJOR FORCE EVENTS

50. Any of the following are called "Force Majeure Events" any of the following incidental and unpredictable, including, but not not exceeding, fires, floods, earthquakes, windstorms or other natural disasters; war, threat or preparation for war, armed conflict, imposition of sanctions, embargo, breakdown of diplomatic relations or similar actions; terrorist attack, civil war, civil commotion or riots; nuclear, chemical or biological contamination or supersonic stampede; explosion or accidental damage; collapse of building structures, failure of plant machinery, machinery, computers or vehicles; any labour dispute, including, but not not not so against, strikes, industrial actions or blockades.
51. Any Party that is subject to a Force Majeure Event will not breach these General Conditions provided that:
 - a) It immediately notifies the other Party in writing of the nature and extent of the Force Majeure Event causing its failure or delay in performance,
 - b) It could not have avoided the effect of the Force Majeure Event by taking precautions that , taking into account all known matters prior to the Force Majeure Event, it should have taken reasonably, but did not; and,
 - c) It has used all reasonable efforts to mitigate the effect of the Event of Force Majeure to perform your obligations under these General Conditions in any manner that is reasonably practicable and to resume performance of your obligations as reasonably as possible.
52. If the Event of Force Majeure prevails for a continuous period of more than two months, either Party may terminate the order by giving fourteen (14) days written notice to the other Party. Upon expiry of this notification period, the order will end. In the event that Buyer terminates the order or purchase order, vaHPM Peru reserves the right to claim any rights and accounts receivable accrued during the period up to the date of cancellation of the order or purchase order.
53. If an "Event of Force Majeure" occurs, the client is not exonerated from his obligation to pay for the goods and / or services received.

PROTECTION OF PERSONAL DATA

54. In accordance with the provisions of Law No. 29733, Law on the Protection of Personal Data, and its Regulations, the CLIENT is informed and gives his free, prior, unequivocal and informed consent for the treatment, that is, for the collection, recording, storage, conservation, use, national and international transfer or any other form of processing of his personal data of which he is the owner. vaHPM Peru and the Client agree that such data will be included in the personal data bank owned by voestalpine High Performance Metals del Perú S.A. (vaHPM Peru), which is located at Calle Luis Castro Ronceros 777, Cercado de Lima, Lima. The data will be processed in order to generate quotes, orders, proof of payment, referral guides, marketing campaigns, among others associated with the sale of our products and services requested by the CLIENT. Likewise, the user may contact the offices of vaHPM Peru located at Calle Luis Castro Ronceros, 777, Cercado de Lima, Lima, in the event that it is necessary to revoke the consent provided through this clause, as well as to exercise the rights of information, access, updating, inclusion, rectification, deletion and opposition provided for in Law No. 29733, Law on the Protection of Personal Data, and its Regulations.

VOESTALPINE AG CODE OF CONDUCT

55. The CLIENT declares that, at the time of any commercial transaction with vaHPM Peru, he knows and accepts our documents: Code of conduct of voestalpine AG available at: <https://www.voestalpine.com/highperformancemetals/peru/es/home/empresa/codigo-de-conducta/>.

SPECIFIC CONDITIONS APPLICABLE TO THE HEAT TREATMENT SERVICE

In addition to the "General Conditions for the Sale of Goods and Value Added Services", these "Specific Conditions applicable to the Heat Treatment Service" apply to services contracted with vaHPM Peru.

COMMERCIAL ASPECTS

1. When the CLIENT sends or leaves its parts for service, it is understood that the CLIENT has previously accepted the price of the services, the characteristics of the treatment and the other considerations contained in this document. At the request of the CLIENT, a prior quote may be issued.
2. The departure of the goods from the plant will be against delivery of invoice or paid receipt or with a dispatch note when a different payment condition has been agreed with the CLIENT.
3. The service is subject to the SPOT (deductions) as the manufacture of goods on request, according to the current indications of Superintendencia Nacional de Aduanas y Tributos (SUNAT).

PLACE OF SERVICE

4. The physical place for the provision of services is located at the address of vaHPM Peru in Calle Luis Castro Ronceros 765, Lima.

ENTRY OF PARTS FOR SERVICE

5. vaHPM Peru does not verify the origin of the material of the parts or the technical data provided by the CLIENT and does not perform analysis for potential hidden errors. Hidden errors include those not detectable to the naked eye. Any questions should be consulted with the technical area.
6. The parts must have the appropriate tolerance for heat treatment in order to be able to perform the subsequent grinding correctly. The CLIENT will consult with the technical area for more information.
7. When it comes to delicate parts with complicated geometries, exposed edges, or of a greater degree of slenderness, the CLIENT must provide suitable devices for the thermal process, which must be consulted with the technical area. In addition, in the case of delicate parts, the CLIENT must indicate the area where to perform the service verification tests or if it is necessary to attach a specimen.
8. The CLIENT is obliged to report earlier or intended subsequent heat treatment and mechanical processes, as well as the use of the part, if their knowledge is relevant to the treatment to be carried out. Parts must not have any application, falsehood or coating of non-ferrous materials for heat treatment. It is also essential to indicate whether it is a foundry or there are welded areas to take the necessary precautions of the case. It is important to note that these parts will only be processed at the CLIENT's risk.
9. The CLIENT must clearly specify the type of steel, heat treatment and the characteristics required for the latter. Example: tempering and tempering, hardness; cementation, depth and hardness; nitriding, depth (coordinated with the technical area). Incomplete or erroneous data can lead to the rejection of the service or to an inadequate treatment, assuming the CLIENT all the risk. If the CLIENT does not specify the heat treatment characteristics, vaHPM Peru will apply the heat treatment deemed appropriate under the responsibility of the CLIENT. vaHPM Peru is not responsible for the problems that could arise due to this.
10. In the parts that have been melted it should be taken into account that the structure does not have exactly the same chemical and physical characteristics in all its volume (which implies a different behavior to the heat treatment); on the other hand it is not possible to guarantee that the foundry does not have pores, non-metallic inclusions, thick segregations or internal fissures that could cause the failure during the thermal process. It is important to note that these parts will only be processed at the risk of the CLIENT.
11. The CLIENT must cover the costs that could be generated due to incorrect, incomplete or untimely information that he has provided about his parts.

HEAT TREATMENT

12. It is the responsibility of the CLIENT to design the part considering the geometric tolerance required to perform the heat treatment. All types of deformations that occur in the pieces are not subject to claim.
13. vaHPM Peru is only obliged to provide the hardness of the parts and the depth of the cemented layer in surface treatments. If the agreed hardness is not achieved, vaHPM Peru will have the sole responsibility of repeating the heat treatment on the batch of parts at no cost. When the CLIENT removes the part, he is accepting the results obtained. The inconveniences caused by the unreachd characteristics are not the responsibility of vaHPM Peru.
14. vaHPM Peru does not perform destructive testing as part of the heat treatment service. If the CLIENT requires it, he must make the respective coordinations, payments and provide samples, otherwise, vaHPM Peru will not accept any responsibility.
15. The CLIENT declares to know that it is advisable to apply optimal rounding in section changes. Geometric features such as live angles, blind holes, perforations very close to each other or other similar characteristics constitute a hazard to the formation of fissures. vaHPM Peru does not accept any direct or indirect responsibility in this consideration.

COLLECTION, DISPATCH AND DISTRIBUTION

16. The CLIENT will record the status and relevant characteristics of the parts that are left for heat treatment, as well as vaHPM Peru will provide the CLIENT with a certificate of the condition of the piece at the time of its dispatch, when it is requested. vaHPM Peru is not responsible for those situations that have not been notified by the CLIENT.
17. vaHPM Peru will deliver the parts to the CLIENT after heat treatment in the same way and with the same packaging method under which they were received. The CLIENT must provide adequate packaging for their parts delivered for heat treatment. The CLIENT will be responsible for any damage that could occur in the parts before or after the heat treatment due to problems with or lack of packaging at the CLIENT's expense.
18. The CLIENT must specify the characteristics that will facilitate the identification by both parties, such as the description of parts, number of pieces, etc., both in the dispatch note or transfer document and in the packaging.

CLAIMS AND WARRANTY

19. On the guarantee offered in the provision of the heat treatment service, vaHPM Peru will act with the required diligence. CLIENTS declare to know the risks of the service and assume them when delivering their parts. Thus, the responsibility of vaHPM Peru in the heat treatment service is limited and is governed by what is stated in the "General conditions for the sale of goods and value-added services".
20. The responsibility for the problems that could appear in the parts during additional processes (repairs, coatings and other similar) to be applied on the parts by the CLIENT or a third party after the heat treatment corresponds to the CLIENT.

SPECIFIC CONDITIONS APPLICABLE TO THE SALE OF WATER JET CUTTING SERVICES

In addition to the "General Conditions for the Sale of Goods and Value Added Services", these "Specific Conditions applicable to the Sale for Water Jet Cutting Services" apply to services contracted with vaHPM Peru.

COMMERCIAL ASPECTS

1. The price of the water jet cutting service does not include the provision of the material and any material to be cut must enter with its respective referral guide or other declaration of ownership document.

DRAWING

2. Cutting instructions must be sent in AutoCAD plane, which must be in version 2013 or earlier.
3. The drawing should contain only the cutlines (avoid plugging, bounding, and drawing fill). Clearly indicate the required parts on the drawing. The scale of the drawing should be in millimeters (mm).

TOLERANCE AND ALLOWANCES

4. The tolerance in linear or circular cuts is +/- 0.2 mm for thicknesses less than 4 mm, increasing as the thickness increases and the shape changes, in which case you should consult with the technical department.
5. For thicknesses greater than 25 mm, rounding greater than 3 mm in the radii should be provided and sharp angles should be avoided. Subsequently the CLIENT can give the final necessary radius, with conventional machining procedures.
6. When the CLIENT supplies the material, it should consider the following material allowances overmeasures:

Cold cut material	Hot cut material	
Allowance in width and length	Allowances in width and length if thickness < 35 mm	Allowances in width and length if thickness ≥ 35 mm
20 mm	40 mm	50 mm

Table of allowances of material supplied by the CLIENT for water cutting

LIMITATIONS OF THE CUTTING

7. Consider that only holes with dimensions greater than 2.5 mm (depending on the thickness) can be made. Consult with Technical Advice for thicknesses greater than 12 mm and requirements of small diameters.
8. For cutting dimensions greater than 3000 mm, consult with Technical Advice.