

AREA		MINIMUM REQUIREMENTS	PREFERRED APPROACH
WELDING		Welders have to be qualified on the basis of a minimum experience in performing this function, also on the basis of a quality assurance/reliability evaluation of the welds performed during their validation tests	<p>Compliance of UNE-EN-ISO standards: *15614-1:2018 Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys *9606-1:2017 Qualification testing of welders - Fusion welding *5817-1:2009 Welding - Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) - Quality levels for imperfections</p> <p>Certification of EA, ILAC, IAF or from any member of these accreditation bodies is preferred rather than self assessments</p> <p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
PAINTING		<p>Shotblasted steel SA 2½ and coated with protective painting: Minimum thickness primer (μ): 75 Minimum thickness top coat (μ): 60 Amount of Gloss (%): ≥ 90 Corrosivity category C4 and HIGH Durability according UNE-EN ISO 12944-1: 2018 Paints and varnishes - Corrosion protection of steel structures by protective paint systems, ensuring ≥ 720hrs salt spray UNE-EN ISO 9227:2017 Corrosion tests in artificial atmospheres - Salt spray tests and ≥ 480 hrs water condensation UNE-EN ISO 6270-1: 2006 Paints and varnishes - Determination of resistance to humidity</p>	<p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
CHASSIS PREPARATION		Availability and compliance of truck manufacturer's body building requirements	<p>No action is taken on the chassis. If it is necessary to perform one, it will be done by the local distributor of the chassis brand or by a representative of the brand</p> <p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
BODY BUILDING	ELECTRICAL	Additional wiring harnesses populated/routed added by body builder have to be compliant with Terberg Ros Roca 1020408_1. Wiring Harness, Manufacturing & Process Specs v1.03	<p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
	HYDRAULICS	Ensure that all hydraulic units, reservoirs, pipes, hoses, valves, etc.. are protected with plugs on fittings (since shipment from suppliers till these units are assembled into the equipment including their storage at warehouse). Cleanliness of fresh oil has to be certificated by oil supplier (minimum ISO code is 18/16/13)..	<p>Filtration process in place to meet code 18/16/13 UNE-EN ISO 4406:1987 Hydraulic fluid power -- Fluids -- Method for coding level of contamination by solid particles</p> <p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
	ASSEMBLY	Tightening/assy torques of the mechanical and hydraulic fixations are all defined and fulfilled	<p>Keeps a log file with traceability of the tightening torques of critical fixations</p> <p>Work and Quality instruction sheets are available and check/test results are recorded Availability in the work areas of the workers' skills matrix</p>
PDI		Exhaustive control protocol of all the functionalities of the equipment, included test of cycle times and verification of the safety system of the equipment	<p>Test and verification results are recorded and shared with terberg Ros Roca Availability in the work areas of the workers' skills matrix</p>
REPAIR / REWORK		All repairs/rework have to be completed using original spare parts from Terberg Ros Roca Spare Parts Manuals Olympus NM and Olympus CE v3.2	Availability in the work areas of the workers' skills matrix'