



ZOLLERN GmbH & Co. KG
plant Laucherthal

Regulation for the delivery of Metall Cuttings



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1. Purpose

The machining of components for ZOLLERN produces cuttings and residual pieces. These cuttings and residues represent recyclable materials and thus an important source of raw materials. In the interests of sustainability, these secondary raw materials are returned to the product cycle by ZOLLERN. The recycling of these materials serves to close cycles, resource efficiency and securing raw materials as well as to avoid negative environmental influences, such as CO2 emissions. In general, cuttings and remnants resulting from machining remain the property of ZOLLERN.

2. Area of application

External subcontractors of ZOLLERN GmbH & Co. KG.

3. Definitions

IBC = Industrial Bulk Container

AVV = List of Waste Ordinance

4. Process

4.1. Pure Separation

In order to enable the most efficient reuse of these secondary raw materials, careful handling of them is required. The most important measure in the handling of secondary raw materials in the form of cuttings is the unmixed separation of the resulting cuttings. In order to be able to return the collected cuttings to the melting of suitable alloys, ZOLLERN maintains the stocks of secondary raw materials under the following material numbers and designations:

Grade-No.	description	AVV-No.	chip group color
9820-9	pure copper cuttings		RED
9823-9	copper mixture, min. 95% copper	10 08 04	BROWN
9822-9	brass cuttings	10 08 04	BLACK
9838-9	NB chips without Cr		GRAY
9863-9	AMB chips		YELLOW
9862-9	AlBz2 chips		BLUE
9861-9	AlBz1 chips		GREEN
9825-9	Cu abrasive	10 08 04	
9850-9	steel cuttings with Cu adherences	12 01 02	

Already on the purchase order, the planned cutting grade can be recognized as a "minus item" from the list of components to be used:

Verwenden Sie hierzu folgende Komponenten (I B-Bestand/Beistellung)	
25 ST	1138056 RD_UB_0110_RM_190_320
	Voraussichtlicher Anliefertermin: 31.03.2022
	Teilgewicht: 84,800 KG
	Werkstoff: 0110-0
1.702,45-KG	9820-9 1000 REIN-CU-SPÄNE

For further processing, in addition to the homogeneous separation, care must be taken to ensure that no foreign substances are introduced into the containers. Waste materials such as coffee cups, cigarette butts, plastic films, or similar items are not permitted.

4.2. Collecting vessel

If cuttings are produced on a larger scale as a result of current ZOLLERN orders, these must be collected primarily in ZOLLERN's own containers. The following container types and sizes are available:

Material-No.	Type/Description	Volume	appx. holding capacity	Dimensions in cm L x W x H	Tara
1614827	Steel container, blue	0,5 m ³	400 kg	125 x 100 x 85	200 kg
1614829	IBC container	1,0 m ³	800 kg	120 x 100 x 115	55 kg
1614830	Steel container, gray	3,3 m ³	2.600 kg	160 x 160 x 145	600 kg

figure:

		
Steel container, blue	IBC container	Steel container, gray

In principle, the containers provided remain the property of ZOLLERN and must be treated with due care. Storage of the containers outdoors is not permitted. This is to prevent additional moisture from being introduced into the containers and thus into the cuttings.

A high proportion of liquids/moisture impairs the reuse of secondary raw materials. Therefore, before filling the containers, care must be taken to ensure that the cuttings for the separation of liquids are fed to a first gravity separation at the point of origin.

If, in exceptional cases, the processor's own containers are used, they must be designed in such a way that they can be emptied by means of a forklift turning device without being damaged. That means, for example, a 200-liter metal drum or, ideally, a steel container with forklift entry pockets.

Under no circumstances may cartons, garbage bags, big bags or lattice boxes with cardboard lining or the like be used for cuttings delivery. In case of re-action, acceptance will be refused.

If the delivered containers do not comply with the specifications, they must be repacked at our premises, as otherwise this will lead to disruptions in the process at ZOLLERN. Repackaging will be invoiced at the hourly rate valid at the time of the complaint.

4.3. Inventory management and delivery

Ideally, the cuttings and remaining pieces are delivered to ZOLLERN together with the finished parts. This enables an unambiguous assignment of the material type and the original alloy.

If, for logistical reasons, a collection of cuttings over several orders makes sense, the inbound delivery can also be made at a later date (i.e. after delivery of the processed components). In this case, the weights of the expected return delivery are posted in the "Supplier Provided Stock" (as physically available to the processor). The transfer from the "Supplier Provided Stock" to the ZOLLERN inventory is then made after delivery and receipt by ZOLLERN. Nevertheless, the downstream delivery should also take place as soon as possible to the delivery of parts. The cuttings must be delivered by the turn of the month at the latest.

A delivery of cuttings before the delivery of processed components is not permitted in any case. Due to the fiduciary storage of secondary raw materials by the processor for ZOLLERN, appropriate precautions must be taken to protect against mixing and access by third parties (including theft protection).

4.4. Shipping document

For the delivery of cuttings and remaining pieces, a delivery note must generally be issued as a goods accompanying document.

In the case of delivery together with processed parts, this can be listed on the overall delivery note.

Basically, it must be listed:

- ***Grade-no., designation and net weight, original purchase order(s)***

In the case of separate, subsequent delivery, a separate delivery note must be drawn up and made available as a goods accompanying document. In principle, the following must also be listed here:

- ***Grade-no., designation and net weight, original purchase order(s)***

The chip containers must be marked in accordance with the new color concept. Signs for labeling are provided by Zollern.

Example image for the magnetic signs:



Under no circumstances does the processor receive a right of retention for the secondary material produced during machining.

4.5. Transport / container exchange

The dispatch of the filled cuttings containers must be notified by the processor in good time to the named carriers and their contact persons in accordance with the agreed routing order.

If the collection or re-delivery is made by ZOLLERN's own truck, please register the collection with Mr. Knapp using the following contact details.

Contact person in logistics

For all questions about container provision and transport, you will be available as a contact person:

Mr Thorsten Knapp

Phone: +49 (7571) 70-326

E-mail: ZSB.Logistik@zollern.com

4.6. Inventory reconciliation and inventory

At regular intervals, a comparison of the "supplier provided stocks" located at the processor must be carried out. Ideally, all finished parts and all resulting secondary raw materials are delivered to ZOLLERN before inventory adjustment. As a result, any stock differences can be prevented in good time. At least once a year, this inventory comparison must be carried out under inventory conditions.

5. Links

For the dispatch of the goods, please use the forwarding agents according to the ZOLLERN routing order.



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