



# Factory acceptance test according to KRONES spe- cification

FAT (Factory Acceptance Test)  
KRONES stretch blow moulders



## Table of Contents

---

1	Definition of factory acceptance test	3
2	Requirements and basic conditions	4
3	Procedure of the standard KRONES factory acceptance test	5
4	Alternatives and options available at an extra charge	6

---

# 1 Definition of factory acceptance test

A factory acceptance test is the acceptance of a product at the manufacturer's location. The factory acceptance test is conducted jointly by the purchaser and contractor, or their authorised representatives.

The acceptance test includes the following procedures:

- The machine or line is checked to ensure all its components are complete. The inspection is based on the machine's order document.
- A functional test is also conducted. The functional test determines if all of the agreed functions are provided and conform to the specified requirements.
- The aim is to verify that the machine has been assembled correctly and works properly.
- The machine's factory acceptance test is conducted at the Krones Neutraubling plant. However, Krones reserves the right to conduct the factory acceptance test at another production site if necessary.

## 2 Requirements and basic conditions

### Requirements

- When the order is placed, the purchaser defines the container that is to be accepted during the factory acceptance test. If no selection has been made by the customer, the selection is made by KRONES and can possibly also be carried out with a so-called house set of moulds.
- The customer must have released the series production of the blow moulds for the customer object to be accepted on schedule on the basis of the laboratory report provided.
- The purchaser is responsible for assuring the timely delivery of the material to the contractor. If the test material is not delivered on schedule, there is the risk of the scope of supply being reduced and/or the factory acceptance test being postponed as a result and, in some cases, this may even lead to a delay in delivery.

### Basic conditions

- If a Krones preform feed system (Contifeed) is included in the scope of supply (no third-party preform feed system), it is usually used for the factory acceptance test. Under certain circumstances, however, a comparable Krones-owned in-house system can also be used.
- An original arrangement of all components, (e.g. cooler, high-pressure compressor, etc.) in accordance with the customer layout is not possible or not intended. Krones also reserves the right to install a process-related container base post-cooling system (air and/or water).
- The OEM transport and conveyor systems (e.g. tipper, conveyor belt/air conveyor, preform feed system, etc.) included in the scope of supply are not installed. OEM machinery cannot be inspected or assessed.
- Depending on the hall capacity, Krones reserves the right to perform the factory acceptance test of block-synchronised machine designs without block synchronisation if necessary.

### 3 Procedure of the standard KRONES factory acceptance test

- There is a visual inspection of the machine and all of the components provided/available according to the scope of supply. The most important components and customer-specific designs are described and explained.
- A short production of containers at nominal output (with the agreed customer object and with the test material provided by the customer) incl. presentation of the general control of the machine takes place.
- Afterwards, the produced containers can be submitted to visual inspection and to inspection for haptics. A renewed verification of the achieved container specifications is not carried out.
- Furthermore, containers are produced for a duration of a minimum of 15 minutes and a maximum of 60 minutes.
- A type change-over can only be shown by way of example. This includes the installation and removal of a mould at a blowing station and the installation and removal of a heating mandrel and a protective plate on the heating module of the machine.
- Re-verification of the achieved container specifications cannot be carried out during the machine acceptance test. However, visual samples can be produced and provided to take them along on request.
- The factory acceptance test is concluded with a final review meeting with the customer during which the customer's further questions and remarks are discussed.
- The total duration of the machine acceptance test is usually max. 4 hours within the period from 8 am to 4 pm.

## 4 Alternatives and options available at an extra charge

- If it is not possible for the customer to attend the machine acceptance in person, the alternative is to conduct a “remote FAT”. This allows the customer to take part in the machine acceptance via Microsoft Teams. Where technically possible, the scope of the remote FAT is similar to the customer acceptance performed in person.
- If the customer cannot take part in the scheduled machine acceptance, it is optionally possible to make a video (with a length of 2-3 minutes) of the machine acceptance. The video shows images of the machine taken from different angles during container production.