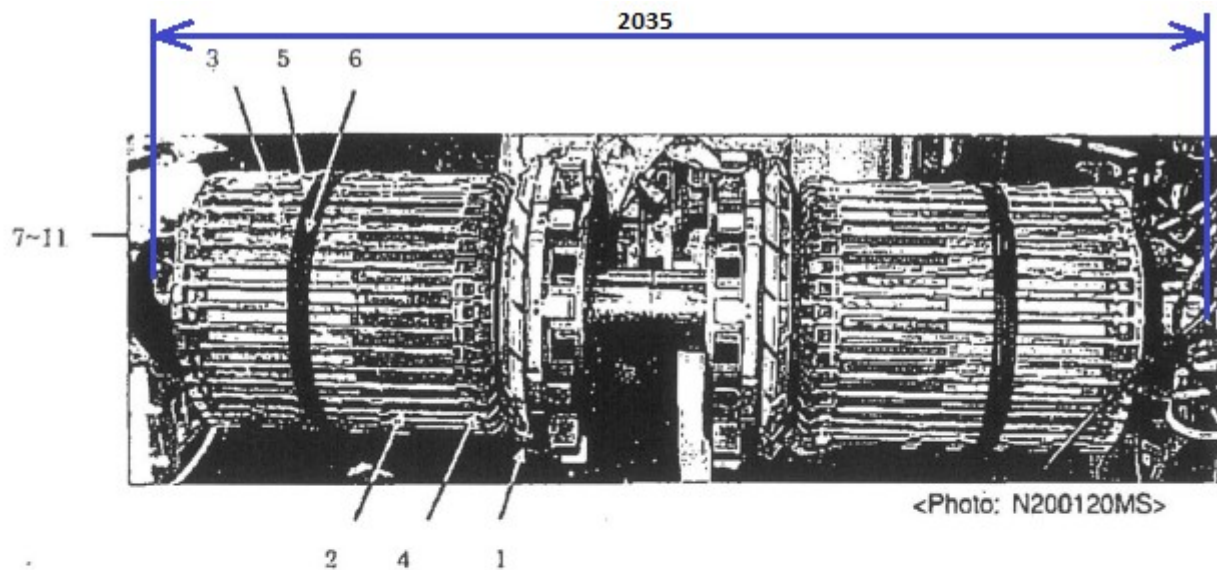


Picture 2 – photo of shaping drum without bladder

Main parts of shaping drum:



No.	Name	Function
1	Bead lock segments	Hold green tire bead area
2	Turn-up fingers / arms	Turn-up materials
3	Turn-up finger cylinders	Open and close fingers
4	Turn-up rollers	Touch and turn-up materials
5	Gum band position hooks	Keep gum bands in place when fingers are opening or closing
6	Gum bands	Keep fingers together (prevent them coming apart)
7	Finger fulcrums	Connection between fingers and drum unit
8	Fulcrum guide rings	Maintain fingers in position around circumference
9	Fulcrum holders	Keep fingers in position and prevent them from slipping out along axis
10	Fulcrum holder fixing ring	Support finger fulcrums.
11	Finger stopper ring	Stop fingers from opening while drum is rotating

Due to absent of drum's drawings, supplier must visit Customer's site and check drum's design and building process.

If necessary, Customer can send existing shaping drum to Supplier for drum design preparation.

The supplier's quotation must contain the following:

- 1) Cost of design development (in case of necessity)
- 2) Cost of equipment manufacturing according to current specification, including the cost of delivery to customer
- 3) Calculation of project time.

The supplier must provide a detailed work schedule indicating all stages of the project and the technological process for manufacturing the drums and approve it with customer. It is necessary to inform customer on progress periodically in the form of a short report by email about the work done during the week and the % of work completed to date.

Drum should be manufactured not later than October, 2025.

4) Warranty obligations for equipment and work performed.

5) Acceptance procedure at the customer's site.

6) Cost of business trip for Supplier's representative to participate in acceptance works and perform operator's trainings (if necessary).

If necessary, the quotation should include drawings, schemes, specifications and other necessary information.

The supplier must include specification number in the contract and indicate that the contract complies with the requirements of this specification. If there are discrepancies with the customer's specification, the supplier must explain it clearly.

2. Equipment acceptance

After drums delivery it will be checked according Appendix 1, including:

1) Before equipment delivery to customer, the supplier must approve by customer the following documentation:

- a set of approved drum drawings (if exist);
- list of spare parts.

2) By request – supplier's site visit by representative of customer to check appearance, dimensions, quantity, operability of the drums, compliance with the requirements of the drawings and this specification.

Anyway, after drum manufacturing and before delivery should be filled "Manufacturing" column on Appendix 1.

3) Final acceptance of work will be at the customer's site and consists of the following stages:

3.1) drum inspection in accordance with check-list on Appendix 1, "Acceptance" column (Dry-test).

3.2) drum installation to Tire Assembly Machine and perform trial building process according table below (wet-test):

Quantity of tires	Explanation of trial	Expected time
3 lots x 3 GT	Build 3 lots of 3 GT without vulcanization on a new drum with measurements after each lot. Measurements are carried out according to the TireBuilding machine qualification program.	7 days
20 tires on Customer's drum and 20 tires on new drum	Build 20 GT on the original drum of the Customer, and then 20 GT are build on a new drum without any changes in the assembly machine. After that, comparative acceptance tests are carried out (uniformity, appearance deviations, cross-sectional analysis of the tire sample, overall dimensions, tire load/speed capacity, etc.).	14 days
1 shift x ~200 tires	Build at least 200 GT per 1 working shift, then they are vulcanized on a curing press. After that, an analysis of uniformity and appearance deviations is carried out.	7 days
~1000 tires	Build at least 1000 GT, then they are vulcanized on a curing press. This stage includes at least 1 changeover. After that, an analysis of uniformity and appearance deviations is carried out.	14 days