

Damen Dredging Equipment B.V. ISO 9001:2015

16. Installation

15. Customs

14. Transport

13. Quality control



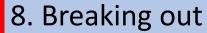
9. Fettling

10. Heat treatment

11. Machining

12. Balancing



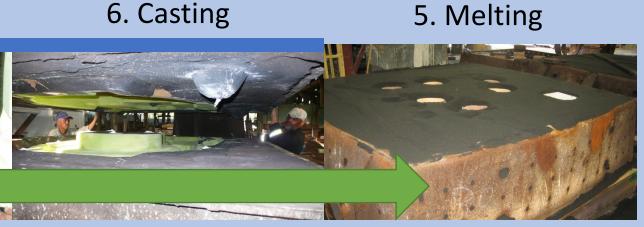




Cooling



6. Casting



1. Pattern preparation

2. Moulding

3. Stacking

4. Casting systems

- Each pattern is used multiple times and wears down, itself. Also, some patterns have to be configured for the specific application, 9. execution or material of the wear part.
- Moulding: the pattern is placed in a casting box and filled with sand
- Sometimes there are more casting boxes needed and they have to be stacked carefully. Depending on the configuration, this step might be very short. Then you go directly from 2 to 4.
- Part of the casting system is already in the sand box with the pattern, but it has to be finished as the last part of the preparation.

- But the cooling in the casting box takes weeks. Wait one turn.
- Sometimes the casting has not gone properly and the cast have to be done again. Back to square one.

- Satisfied with the cast, then it has to be touched up at the fettling station.
- A special heat treatment brings the final hardness and toughness to the product.
- The fitting surfaces of the wear parts have to be machined
- Rotating parts have to be balanced. For non-rotating parts, this can be skipped.
- Then there is the bottle neck: quality control. If there is a deviation that can n ot be mitigated, you have to go back to square one.
- Don't start me about customs handling. Your anticipated spares are in bonded storage and customs is missing a document, wait some weeks or skip a turn
- 16. Finally, you've made it! Installation on the dredge

and for every player one token. and Ladders' according to 'Snakes dice one Rules