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#### Revisions:

Compared to VN 1576-1 (2018-04), the following changes have been made:

- a) Kap. 7: Addition of the new characteristic letter D in the column „Storage“.
- b) Kap. 9: Revision and inclusion of the characteristic letter D: „Outdoor storage with paved ground (only permissible if damage to the packing and the component can be excluded due to influence of weather)“.

The characteristic letter D „Outdoor storage with paved ground (only permissible if damage to the packing and the component can be excluded due to influence of weather)“ was added at the request of the Shipping and Site Planning HDH department and in consultation with VPLB.

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	Name	Date	Signature
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**1 Scope**

This standard applies across the group to the entire scope of Voith and its subcontractors.

**2 Area of application**

This standard is applicable in all areas in which components are preserved and stored.

**3 Purpose**

This standard defines the general preservation and storage procedures to be applied at Voith and its subcontractors. The anti-corrosion agents to be used are described solely through their properties and are classified into two groups. The preservation method to be applied for particular goods can be found in the preservation matrix. In addition, the necessary storage condition is identified by a single-digit characteristic letter. The preservation and storage of rolls is defined in VN 1576-2.

**4 Normative references**

VN 1576-2 Preservation and Storage  
Part 2: Preservation and storage of rolls

**5 General**

All parts made of stainless materials (e.g. stainless steel, aluminum, bronze, plastic, etc.) are not preserved. For all preserved parts, a waterproof barrier layer must be used as separating layer from the wooden support. Uncoated paper or board must **not** be used because of possible moisture.

**6 Anti-corrosion agents**

The anti-corrosion agents to be used are classified into two groups based on properties and use.

**6.1 Group 1 anti-corrosion agent**

The anti-corrosion agent must be a dewatering fluid. The agent is applied mainly in an immersion bath or by spraying. During the process, a waxy/greasy protective film forms on the component. The anti-corrosion agent is resistant to alkali carry-over and is used on metal parts. It is normally suitable for preservation during transport and storage. However, the anti-corrosion agent is rather unsuitable for outdoor storage.

**6.2 Group 2 anti-corrosion agent**

The wax-based anti-corrosion agent is applied by means of a low-pressure spray gun or a brush. During the application process, the temperature of the substrate must be 10 – 35 °C. A waxy, transparent and solid film forms. Adequate ventilation must be provided for the hardening process and in order to inhibit the formation of flammable liquids. The partially-hardened film must not be allowed to come into contact with an ignition source under any circumstances. Moreover, no other product should be applied above or below this coating due to the potential incompatibility between the various materials. It is suitable for preservation during transport and storage indoor and outdoor.

**7 Preservation matrix**

The preservation method to be applied for particular goods can be found in the preservation matrix below.

Goods	Transport type		Storage
	Land/Air	Sea	
Corrosion-resistant materials	K 0	K 0	B, C, D
Corrosion-sensitive materials	K 1, K 2	K 1, K 2, K 3	B
Electrical and electronic devices	K 4, K 5	K 4, K 5	A

**8 Preservation methods**

There are five different preservation methods.

**8.1 Preservation method K 0: No preservation**

The part does not require any preservation.

**8.2 Preservation method K 1: VCI method (volatile corrosion inhibitor)**

Preservation in corrosion-inhibiting atmosphere (e.g. VCI method).  
Recommended for e. g. small single parts, bulk goods, etc.

**8.3 Preservation method K 2: Thin-layer preservation**

Preservation for all bright and unpainted outer surfaces:

- Coating with a group 1 anti-corrosion agent.
- Covering or wrapping the parts preserved in this way in oil-impregnated paper.

**8.4 Preservation method K 3: Thick-layer preservation**

Preservation for all bright and unpainted outer surfaces:

- The use of a group 2 anti-corrosion agent is preferred. A group 1 anti-corrosion agent should be used only following consultation with Voith. It should be noted, however, that boreholes and tapped holes are preserved with a group 1 anti-corrosion agent. If components are not packed further, the boreholes and tapped holes must be closed with, for example, plastic plugs (also on parts clad with stainless steel).

**8.5 Preservation method K 4: Plastic sack open at bottom**

In the as-delivered condition, electrical and electronic devices must be in a plastic sack that is open at bottom.

**8.6 Preservation method K 5: Closed plastic sack**

In the as-delivered condition, electrical and electronic devices must be in a sealed plastic sack. Care must be taken to ensure that an adequate quantity of drying agent (silica gel or diatomaceous earth) is added.

**9 Storage**

If storage conditions are not specified for the order, Table 1 shall apply. The necessary storage conditions are identified by a single-digit characteristic letter.

Table 1: Storage conditions

Charateristic letter	Storage
A	Indoor storage tempered building (+10 °C to +35 °C)
B	Indoor storage unheated, dry building
C	Outdoor storage roofed or protected with a tarpaulin and paved ground
D	Outdoor storage with paved ground (only permissible if damage to the packing and the component can be excluded due to influence of weather)