



BST GmbH // Remusweg 1 // 33729 Bielefeld, Germany

SA UGEPA
Z.I. ROUTE DE THENNES
80110 MOREUIL
France

BST GmbH
Remusweg 1
33729 Bielefeld, Germany
☎ +49 (0) 521 400 70-0
info@bst.group
www.bst.group



Bankverbindungen / Bank Details
Deutsche Bank Siegen:
IBAN: DE 72 4607 0090 0505 1651 00
BIC: DEUT DE DK 460
Commerzbank Bielefeld
IBAN: DE 14 4804 0035 0776 5514 00
BIC: COBA DE FF 480
UID: DE 811 122 306, HRB Nr. 30830
Amtsgericht/District Court: Bielefeld
Geschäftsführer/Managing Directors:
Dr. Rolf Merte (Vorsitzender),
Ingo Koesfeld



Invoice No. 400 / 20007029
(Original)

Date: 25.03.2022

Page: 1 of 4

Customer-No.: ACU231044	Service	Sales
Contact: Aurelien Baillet	Order No.: ASR006214	Contact: Tondou, David
Order Number: signed quotation ASQ901393	Contact: Walter, Stephan	
Your Tax Number: FR04741720262	fieldservice@bst.group	David.Tondou@bst.group; Magali.Zito@bst.group

For Service Intervention

Service Technician:

Andreas Pfeiffenberger Dated: 18.10. - 22.10.2021

Julian Klaus + Cedrik Sikora Dated: 21.02. - 25.02.2022

WA Number: 21406

The signed service report is enclosed.

We calculate as follows:

Service Order

Place of installation : SA UGEPA
Z.I. ROUTE DE THENNES
80110 MOREUIL
France

Art.-No. / Description	Quantity	Unit	Price	Amount In	EUR
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service feature

Commissioning regi_star 20

Serial No.: 5SYKA981210-21004343-AVE600000

Working / Travel time:

Pfeiffenberger, Andreas	Arbeitszeit		22,50h	99,00	2.227,50
	standard working hour				
Pfeiffenberger, Andreas	Arbeitszeit	Extra amount 50 %	4,25h	148,50	631,13
	standard working hour				
Pfeiffenberger, Andreas	Reisezeit	Extra amount 50 %	4,00h	121,50	486,00
	standard travelling hour				
Pfeiffenberger, Andreas	Reisezeit		12,75h	81,00	1.032,75
	standard travelling hour				

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Art.-No. / Description	Quantity	Unit	Price	Amount In	EUR
Further costs:					
2SVGN079210 travelling costs km	1.212,00	km	0,70		848,40
2SVGN079220 hotel accomodation	1,00	pcs	433,76		433,76
2SVGN079260 rental car	1,00	pcs	479,16		479,16
2SVGN079290 toll	1,00	pcs	16,17		16,17
2SVGN079300 daily expenses	1,00	pcs	29,00		29,00
2SVGN079300 daily expenses	3,00	pcs	44,00		132,00
2SVGN079300 daily expenses	1,00	pcs	28,00		28,00



service feature

Finalization of commissioning regi_star 20

Serial No.: 5SYKA981210-21004343-AVE600000

Working / Travel time:

Klaus, Julian-Benedikt	Arbeitszeit standard working hour		22,50h	99,00	2.227,50
Klaus, Julian-Benedikt	Arbeitszeit standard working hour	Extra amount 50 %	7,00h	148,50	1.039,50
Klaus, Julian-Benedikt	Reisezeit standard travelling hour	Extra amount 50 %	1,50h	121,50	182,25
Klaus, Julian-Benedikt	Reisezeit standard travelling hour		15,75h	81,00	1.275,75

Further costs:

2SVGN079210 travelling costs km	220,00	km	0,70		154,00
2SVGN079220 hotel accomodation	1,00	pcs	387,03		387,03
2SVGN079230 flight	1,00	pcs	484,88		484,88
2SVGN079260 rental car	1,00	pcs	512,94		512,94



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Art.-No. / Description	Quantity	Unit	Price	Amount In	EUR
2SVGN079280 petrol	1,00	pcs	42,00		42,00
2SVGN079290 toll	1,00	pcs	19,53		19,53
2SVGN079300 daily expenses	2,00	pcs	29,00		58,00
2SVGN079300 daily expenses	3,00	pcs	44,00		132,00
2SVGN079310 travelling costs	1,00	pcs	7,35		7,35

service feature

Finalization of commissioning regi_star 20

Serial No.: 5SYKA981210-21004343-AVE600000

Working / Travel time:



Sikora, Cedrik	Kulanz Arbeitszeit		22,50h	0,00	0,00
	working time gesture of goodwill				
Sikora, Cedrik	Kulanz Arbeitszeit	Extra amount 50 %	7,00h	0,00	0,00
	working time gesture of goodwill				
Sikora, Cedrik	Kulanz Reisezeit		16,25h	0,00	0,00
	travel time gesture of goodwill				
Sikora, Cedrik	Kulanz Reisezeit	Extra amount 50 %	1,50h	0,00	0,00
	travel time gesture of goodwill				

Further costs:

2SVGN079210 travelling costs km	130,00	km	0,00		0,00
2SVGN079220 hotel accomodation	1,00	pcs	0,00		0,00
2SVGN079230 flight	1,00	pcs	0,00		0,00
2SVGN079300 daily expenses	2,00	pcs	0,00		0,00
2SVGN079300 daily expenses	3,00	pcs	0,00		0,00
2SVGN079310 travelling costs	1,00	pcs	0,00		0,00

Value of Goods	0,00
Costs	12.866,60
Net Amount	12.866,60
0,0 % Tax Amount	0,00

Invoice No.
(Original)

400 / 20007029

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Art.-No. / Description	Quantity	Unit	Price	Amount In	EUR
Total Amount					12.866,60

Terms of Payment 30 days invoice date, net
Due on 24.04.2022

Please mention with your invoice no. 400 / 20007029
as well as your customer code no. ACU231044. Thank you.

Terms of Delivery
Carrier

*The tax liability is shifted to the recipient of the supply.
"reverse charge"*

NOTE:

OUR DELIVERIES AND SERVICES ARE BASED ON OUR GENERAL SALES CONDITIONS IN PARTICULAR.
WE REFER TO THE RESERVATION OF PROPERTY IN ALL ITS FORMS.
OUR GENERAL SALES CONDITIONS WILL BE SUBMITTED ON REQUEST.

BST GmbH



i. A. G. Wille

i. A. B. f



Englisch

Customer: SA UGEPA Z.I. ROUTE DE THENNES 80110 MOREUIL France		Nr. ACU231044 place of installation: SA UGEPA Z.I. ROUTE DE THENNES 80110 MOREUIL France		purchaser: Aurelien Baillet purchase no.: signed quotation ASQ901393 telephone: contact person: technician:		comm. BST: WA 21406 / ASO073259 comm. customer: IG8 Emerson & Renwik 8units machine: ASR006214 service order: 0		BST equipment: regl_star 20		Internal driven distance 1212		plate km fellow passenger rent car	
additions/ comments:													

[illegible]

short report

[illegible]

The system was installed and switched on. Check the signal from encoder and motor commands to machine. Encoder haven't a zero impulse at the moment. This will be realized from LENZE Technician Mr Werner Siemer until next intervention. Also for the embossing the encoder ratio is 37128/11875 (enc/cyl), after restart always a new gate position have to fin out without zero impulse.

The machine profaned interface was tested only with signal "web-run", "acc" and "start auto seq.", all other functionalities will later realized on machine side.

Web guide is running and controlled from RC8 in offset para with EKR "automatic" mode. RSH signal from RC9 embossing is supported RC8 with same gate position. Other mark selection for 8 must defined in preparation selected "mark reference". The embossing analogue terminal is 16bit +-10V, on machine side is at the moment 14bit only positive anlage input. This terminal will replace if part available.

We run test job with units 1-6 and units 1-4 with embossing in register. The register can controlled until 80m/min with constant speed. Over 80 m/min the mark print wasn't stable the error range increase.

Also after acceleration the print units need a while until reaction on the print register

The register control is commissioning with basic function. Screen print isn't tested unit 7 not commissioning and embossing machine an one input is limited by wrong input error. A additional visit is necessary, if the embossing machine isn't working. The printer is not working. The printer register is not working. The printer register is not working.

if all units/barts are ready for commissioning and testing

[illegible]

☐	Material required as per attached list!	☐	work completed	☒	additional visit necessary
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France 08.11.2021	signature technician	signature customer
	Pfeiffenberger, Andreas	Aurelien Baillet

English

additions/ comments:

short report

☐ Male ☐ Female
 Date of birth: _____
 Date of interview: _____
 Interviewer ID: 1000020000

☒ additional visit necessary/

 Aurélien Baillet

service report/ time report

Englisch

Customer: SA UGPA Z.I. ROUTE DE THENNES 80110 MOREUIL France	Nr. ACU231044	place of installation: SA UGPA Z.I. ROUTE DE THENNES 80110 MOREUIL France	purchaser: purchase no.: telephone: contact person: technician:	Aurelien Baillet signed quotation ASQ901393 Aurelien Baillet Klaus, Julian-Benedikt	comm. BST: comm. customer: machine: service order: Internal	WA 21406 / ASO073259 0	
BST equipment: regi_star 20					driven distance	plate	fellow passenger
<i>additions/ comments:</i>					.	km	.

day	date	travel time		break h	working time		break h	comment	total	working time				travelling time					
		from	to		from	to				N	50	100	150	N	50	100	150		
Mon	21.02.2022	8:30	16:30	0,75					7,25										
Tue	22.02.2022	7:30	8:00		8:00	17:00	0,75		9,25	7,50	0,75								
Wed	23.02.2022	7:30	8:00		8:00	19:45	0,75		12,00	7,50	3,50								
Thu	24.02.2022	7:30	8:00		8:00	19:00	0,75		10,75	7,50	2,75								
Fri	25.02.2022																		
Sat	26.02.2022																		
Sun	27.02.2022																		
Mon	28.02.2022																		
Tue	01.03.2022																		
Wed	02.03.2022																		
Thu	03.03.2022																		
Fri	04.03.2022																		
Sat	05.03.2022																		
Sun	06.03.2022																		
short report									Σ	39,25	22,50	7,00						8,75	1,00

Mon: Travel

Tue: First check of the system. Optimization of control parameters and printing tests. Waiting time 3h.

Wed: Waiting time 3h. Printing tests with embossing unit. Test of the embossing unit and adjustment of the control

parameter. The inseting process is very slow and the control parameter have to be very defensive due to long web path between pull station and embossing. The web paths in general are long between every unit. Web tension is not stable. During acceleration the web tension is oscillating. The position of the edge guide sensor is to far away from the motorised cylinder. BST France found another position for the sensor.

Thu: The correction speed is only 0,5mm/s and the control itself has to be very slow due to big web tension changes after every control command. Synchronization of the the drives is not complete, especially during acceleration. The machine is equipped with big chill rollers, but most of them are undriven. Waiting time 4h. Additional training given by BST France.

☐ Material required as per attached list!	☐ work completed	☒ additional visit necessary
France 24.02.2022	signature technician <u></u> Klaus, Julian-Benedikt	signature customer <u></u> Florent KICKA

Englisch

Customer: SA UGEPA Z.I. ROUTE DE THIENNES 80110 MOREUIL France	Nr. ACU231044 SA UGEPA Z.I. ROUTE DE THIENNES 80110 MOREUIL France	place of installation: SA UGEPA Z.I. ROUTE DE THIENNES 80110 MOREUIL France	purchaser: Aurelien Baillet signed quotation ASQ901393 telephone: Aurelien Baillet contact person: Klaus, Julian-Benedikt technician:	comm. BST: WA 21406 / ASO073259 comm. customer: machine: service order: ASR006214 Internal
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BST equipment:	regi_star 20
additions/ comments:	

day	date	travel time		break h	working time		break h	comment	total	working time				travelling time				
		from	to		from	to				N	50	100	150	N	50	100	150	
Mon	21.02.2022	8:30	16:30	0,75					7,25						7,25			
Tue	22.02.2022	7:30	8:00		8:00	17:00	0,75		9,25	7,50	0,75				0,50	0,50		
Wed	23.02.2022	7:30	8:00		8:00	19:45	0,75		12,00	7,50	3,50				0,50	0,50		
Thu	24.02.2022	7:30	8:00		8:00	19:00	0,75		11,25	7,50	2,75				0,50	0,50		
Fri	25.02.2022	5:00	12:30	0,50					7,00						7,00			
Sat	26.02.2022																	
Sun	27.02.2022																	
Mon	28.02.2022																	
Tue	01.03.2022																	
Wed	02.03.2022																	
Thu	03.03.2022																	
Fri	04.03.2022																	
Sat	05.03.2022																	
Sun	06.03.2022																	
short report									Σ	46,75	22,50	7,00			15,75	1,50		

Mon: Travel

Tue: First check of the system. Optimization of control parameters and printing tests. Waiting time 3h.

Wed: Waiting time 3h. Printing tests with embossing unit. Test of the embossing unit and adjustment of the control parameter. The inseting process is very slow and the control parameter have to be very defensive due to long web path between pull station and embossing. The web paths in general are long between every unit. Web tension is not stable. During acceleration the web tension is oscillating. The position of the edge guide sensor is to far away from the motorised cylinder. BST France found another position for the sensor.

Thu: The correction speed is only 0,5mm/s and the control itself has to be very slow due to big web tension changes after every control command. Synchronization of the the drives is not complete, especially during acceleration. The machine is equipped with big chill rollers, but most of them are undriven. Wating time 4h. Additional traning given by BST France.

☐ Material required as per attached list!		☐ work completed	☒ additional visit necessary
France 28.02.2022	signature technician Klaus, Julian-Benedikt	signature customer	Florent KICKA

Englisch

Customer: SA UGEPA Z.I. ROUTE DE THENNES 80110 MOREUIL France	N°. ACU231044 place of installation: SA UGEPA Z.I. ROUTE DE THENNES 80110 MOREUIL France	purchaser: Aurelien Baillet	signed quotation ASQ901393	comm. BST: WA 21406 / ASO073259
		purchase no.: Z.I. ROUTE DE THENNES		
		telephone: 80110 MOREUIL	Aurelien Baillet	comm. customer: machine:
		contact person: France	Aurelien Baillet	service order: ASR006214
BST equipment:		technician: France	Sikora, Cedrik	Internal 0
regl_star 20		driven distance 130	plate km Sixt	fellow passenger
additions/ comments:				

additions/ comments:

day	date	travel time		break h	working time		break h	comment	total	working time				travelling time				
		from	to		from	to				N	50	100	150	N	50	100	150	
Mon	21.02.2022	8:30	16:30	0,75					7,25									
Tue	22.02.2022	7:30	8:00		8:00	17:00	0,75		9,25	7,50	0,75							
Wed	23.02.2022	7:30	8:00		8:00	19:45	0,75		12,00	7,50	3,50							
Thu	24.02.2022	7:30	8:00		8:00	19:00	0,75		11,25	7,50	2,75							
Fri	25.02.2022								7,50									
Sat	26.02.2022																	
Sun	27.02.2022																	
Mon	28.02.2022																	
Tue	01.03.2022																	
Wed	02.03.2022																	
Thu	03.03.2022																	
Fri	04.03.2022																	
Sat	05.03.2022																	
Sun	06.03.2022																	
short report									Σ	47,25	22,50	7,00			16,25	1,50		

Training with Julian Klaus

☐ Material required as per attached list!	☐ work completed	☐ additional visit necessary
France 10.03.2022	signature technician	signature customer
	Sikora, Cedrik	Julian Klaus