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Ns/Rif. HORSES AND CHARIOTS - ordine

Messrs.

**HORSES AND CHARIOTS Ltd.**  
**INBAR 17**  
**St. Barkan Industrial Zone**  
**4482000 (Israel)**

Codevilla, 15/08/2022

**ORDER CONFIRMATION N. C633/21** based on our offer n. 589/21/R2 dated 14/12/21 - technological flow-sheet n. 19961/1 - layout n. 19962/1

**COFFEE PROCESSING PLANT WITH 60 KG/BATCH ROASTER**

**Description**

The system has been designed with a process capacity of approximately 200 kg roasted net hour so roughly 2 tons per day, considering 10 hours shift, rate and size can be modified. The green coffee received in bags is unloaded manually in the hopper (1) and a pneumatic loading line (2) will feed either the distributor (3) above the silos (4) with a capacity of 1500 kg each, or load the roaster. Under the silos a scale (5) will prepare the right volume of batch. The roaster (6) with a capacity of 60 kg batch so 300 kg/hr (as green) works automatically, following the recipe requested by the operator. Afterburner (7) for smoke pollution control is included. A destoner (8) collecting the roasted coffee from the cooling tank raise the product to the destoner hopper. From destoner you have the flexibility to discharge the product into a local container with the diverter valve (9) or load a Z type buckets elevator (10) to feed the roasted coffee silos. The buckets elevator has a double function, so in addition to load the silos, it collects also the roasted coffee from mixer to transfer it to the packaging machine. The use of buckets elevator is to gently transport the product and reduce to the minimum the breakages. The roasted coffee silos (11) have a capacity of 500 kg each and have an internal device to smoothly load the coffee to avoid breakages. Number of silos and volume can be modified accordingly, with Customer request. The coffee from silos is loaded into a mixer (12) on scale for blending, if required, then again to buckets elevator to load the hopper (13) above the roasted beans packaging machine (out of our scope of supply). From green coffee hopper up to packaging machine, the completely automatic operation is managed and controlled by hardware and software contained in the control panel (14).

**Equipment**

Item 1

- 1 UNLOADING HOPPER**  
for green coffee sacks  
- level indicator and connections.

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Item 2

**1 PNEUMATIC CONVEYING LINE**

with the following characteristics:

- 1,5 Ton/h capacity
- n. 1 RBS 45 blower
- IEC standardized motor
- safety valve
- sound-proof cabin
- n. 2 VC 50 rotary valve with steel rotating star with gear motor
- n. 2 hoppers with level
- 50 mts. carbon steel pipe  $\varnothing$  80mm.

**1 "V2V" TWO-WAY DIVERTER VALVES**

comprising the following characteristics:

- cast iron construction
- electro-pneumatic control
- electronically controlled positioning

Item. 3

**1 AUTOMATIC DISTRIBUTOR**

with n. 9 ways

- controlled by closed moto-reducer
- cyclone

Pos. 4

**9 STORAGE SILOS**

for green coffee, ach one with following characteristic:

- carbon steel materials
- capacity 1,5 Tons each
- max level indicators
- min level indicators
- pneumatic unloading

Pos. 5

**1 SCALE**

with loading cells, with the following characteristics:

- capacity of 60 Kg

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- tank with carbon steel construction
- automatic unloading, controlled by pneumatic piston
- support frame

**NOTE:** the max error admitted from the supplier of the loading cells is of  $\pm 0,5\%$  on the bottom scale values of the mechanical scale

Pos. 6

## 1 ROASTER MOD. BR 60 BR18 ADVANCED SPECIALTY SW

- Coffee load capacity per batch : 60 Kg/batch
- Number of batch / h : 4/5 (according to the roasting profile)
- Hourly production (green coffee) : 240/300 Kg/h (according to the roasting profile)
- Fuel : Natural gas or LPG or Diesel
- Thermic Power : 200 kW
- Installed power : 13 kW
- Space requirement : 4000 x 2900 x 3600 mm c.ca.



### Description of the machine.

Today's technologies are the result of a long journey where the company has developed a growing know-how, built up over 40 years of research, testing, updating and verification. Every Brambati spa customer has a roasting process carried out according to its precise dictates.

In the Brambati roaster, processing is carried out with hot air by heat exchange of the coffee. The heat exchange takes place by convection with hot air in direct contact with



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the coffee and conduction between the metal of the drum and the coffee itself. It is possible to govern the roasting profile at each progressive stage by controlling the temperature, the amount of hot air as well as the efficiency of heat exchange between the air and the coffee by increasing or reducing the efficiency of heat exchange by convection between the hot air and the coffee; you can therefore choose to vary the percentage of roasting by conduction or convection at each stage of roasting. The central computerised system manages the programmed phases and their parameters, controlling, among other things, the system of modulating air control valves.

### The roasting profiles

For processing, roasting recipes are activated, which consist of a set of parameters concerning the quantities that control the process, defining for each type of coffee a final roasting temperature and cycle times. The temperature is measured by means of temperature probes suitably positioned on the machine. The recipes are memorised, recalled according to the type of coffee and even automatically based on the daily work programme. When the production of a certain sequence of blends is set and the command to bring the blends to the roaster is given, each blend is associated with a roasting profile, so the machine automatically retrieves from its database the exact recipe for the type of coffee being roasted.

The main stages of the roasting profile can be summarised as follows:

- Rapid dehumidification.
- Aroma and colour development
- Aroma and colour fixation.

The fundamental variables required to ensure complete and accurate control of the roasting profile :

- Modulation of burner heat output.
- Automatic variation of circulating air volumes.
- Timing of the implementation of the individual phases.
- Modulated regulation of room air inlet valves.

These four elements managed by targeted software ensure perfect control and repeatability of the production quality while retaining the possibility of the personal touch that each person can give to the roasting profile.

### Control panel and energy consumption

The machine is controlled by a PLC and 2 man-machine interface units: a PC and a Touch-PC on board the machine to allow greater visibility to the operator even close to the workstation itself. The roaster has a heat recovery system, whereby excess heat is partially recovered by a recirculation system and reintroduced into the roasting drum, allowing a reduction in energy consumption. The machine's unique feature is that the efficient heat exchange between air and coffee reduces roasting times, as well as saving energy by operating at lower temperatures.

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## Description of parts

### **Green Coffee loading cone**

where the *batch* of green coffee is loaded, awaiting subsequent transfer to the roasting drum.

### **Roasting drum**

it is the central part of the system, where the coffee roasting process takes place.

### **Cooling Tank**

which receives the coffee at the end of the roasting process and allows rapid cooling.

### **High Temperature Air Circuit**

comprising the combustion chamber (chamber where the main burner generates the thermal energy required for the roasting process), the modulating fan, the chaff box (cyclone collecting the chaffs expelled from the drum during the roasting process), the modulating valves and the insulated connecting ducts. The basic function of this circuit is to transport the thermal energy required for the roasting process.

### **Low Temperature Air Circuit**

comprising the modulating fan, cyclone separator, shut-off valves and insulated connecting ducts. The technical innovations with which the Brambati BR roasting machine is equipped make it an indispensable tool for obtaining high quality products. The main advantages include the repeatability of the results, thanks to the storage of the relevant roasting profile, the guarantee of total respect for the environment in terms of both atmospheric emissions and noise in the working environment and thermal insulation, which allows considerable energy savings.

## Construction of main components:

- Green coffee loading cone
- Roasting drum
- Heat generator
- Cooling tank with cleaning system
- Roasting cyclone with chaff extraction
- Cooling cyclone with dust suppression
- Hot and cold air flow control and management unit
- Safety systems
- Chimneys
- Command and control equipment

### **Green coffee loading cone**

made of carbon steel sheet with external noise insulation, cover plate and viewing window. The green coffee inlet is tangential to the hopper, the transport air outlet pipe is connected to the cooling air outlet stack.

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**Roasting drum**

made of high-strength hardened and tempered steel structure and consisting of an external fixed element and an internal rotating element. The outer element is made of sheet metal, while the rotating inner element or basket has a double wall in AISI 304. The bottom of the basket is fitted with a mesh to allow adequate hot air circulation. The entire unit is insulated with rock wool of variable thickness depending on the points and covered with AISI 304 sheet metal. The roasted coffee discharge door, in hardened and tempered steel, is mounted on bearings, with a rotating outer band integral with the inner basket to guarantee a perfect seal even with small products. The emergency opening of the door, even in the absence of electrical power, is guaranteed by an air lung automatically maintained in pressure and by a manual selector positioned in a suitable area to be operated by the operator. A series of crossed blades ensure perfect mixing of the coffee and between the coffee and the flow of hot roasting air.

The motorisation of the drum is achieved by directly mounting the gear motor unit on the shaft without the aid of belts or chains; the absorption of the starting tear is guaranteed by an inverter.

**Heat generator**

(combustion chamber), made entirely of stainless steel with differentiated heat resistance, insulated with Eco fibre and rock wool and lined with stainless steel sheet. The modulating burner unit complete with ramp and safety accessories is installed on the rear wall; the whole unit is manufactured according to international standards with certified elements

**Cooling tank**

Constructed in AISI 304, with a large perforated surface. The handling of the roasted coffee is carried out by a cruise of arms with adjustable cross-flow deflectors. The larger diameter shortens the cooling time by having a smaller layer of coffee. There are 2 coffee outlets, one automatic, linked to the coffee extractor, and one manually operated for emergency discharge. The tank is equipped with safety systems such as protection. Sample window with safety system. Large doors allow easy cleaning under the tank, where automatic cleaning brushes convey the dust for easier suction to the dust-removal cyclone.

**Cyclone for chaff extraction and Cyclone for dust removal**

Both made of carbon steel sheet. The chaff extractor cyclone is treated with fireproof paint, with an inspection door on the chaff cyclone. They are mounted on a support structure suitable for inspection and maintenance of the fans. The chaff extraction cyclone is insulated and lined with AISI 304 sheet metal, the chaff discharge is ensured by a rotating star valve which can be combined with a chaff compactor on request.

**Hot and cold air flow control and management unit**

Hot and cold air flows are managed by automatic modulating dampers, variable speed fans and a series of large section stainless steel insulated pipes. The modulation of the fan with coordinated action of opening/closing of the shut-off valves and of the burner heat output is determined by the choice of the roasting profiles that are set on the electrical control and management panel. These profiles are one of the special features

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of the BR Brambati roaster. The automatic heat recovery, recirculation and combustion chamber system is also controlled by the P.C. Each roasting profile can be varied, memorised and matched to each different coffee blend that the customer wants to roast. A graph of each individual profile can be printed and accompany each roasting batch if required

### Safety systems.

The standard safety equipment of the machine includes; automatic fire-fighting system on the drum, cooling tank, pellicle cyclone, automatic coffee unloading door opening unit even in the absence of electrical power by means of an air lung, rotation control on the drum, overflow level in the pellicle cyclone, normally open water inlet valves, pressure switch on the water line, proximity switch for checking the opening of the manual water inlet root valve, flow meter for checking water flow, remote electrically operated push button panel to switch off the roasting burners and the smoke burners on the roasting smoke expulsion chimney, water inlet on drum, cooling tank, pellet mill cyclone, roasting and cooling air movement fans, drum door opening and cooling tank discharge valve, roasting basket rotation gear motor, cooling tank mixing gear motor, each motor is equipped with circuit breaker units.

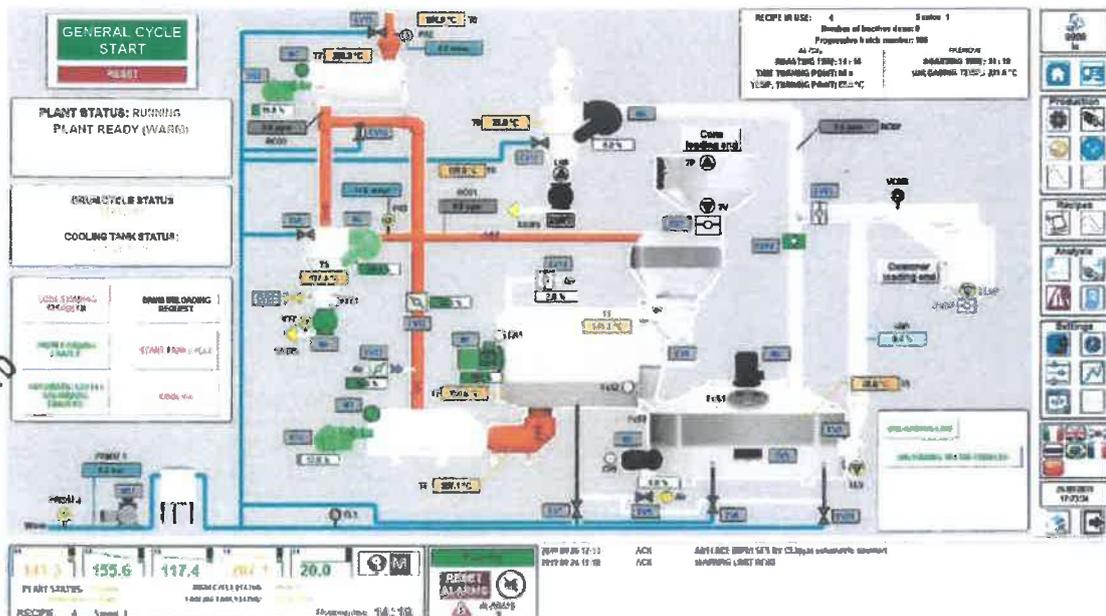
### Chimneys

Made of AISI 304 with insulation at the cyclone outlet for chaff extraction and cyclone dust removal. Standard length 5 metres each.

### Electrical equipment

for control and monitoring of roaster, power supply 400 V. - Hz. 50 consisting of:

- no. 1 metal cabinet RAL 7035 for floor mounting
- tetra polar two-pole and single-pole circuit breakers, safety relays, emergency stop and control buttons (Siemens)
- ABB motor control inverters, motor control inverters if any (Siemens)
- phase failure and overload relays, motor protection (thermal protection) for motors, control relays (Siemens)
- 24 Vdc power supply with UPS unit for auxiliaries (Siemens)



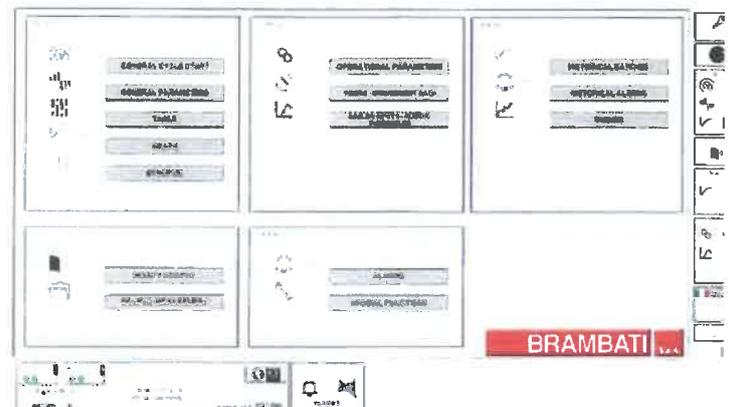
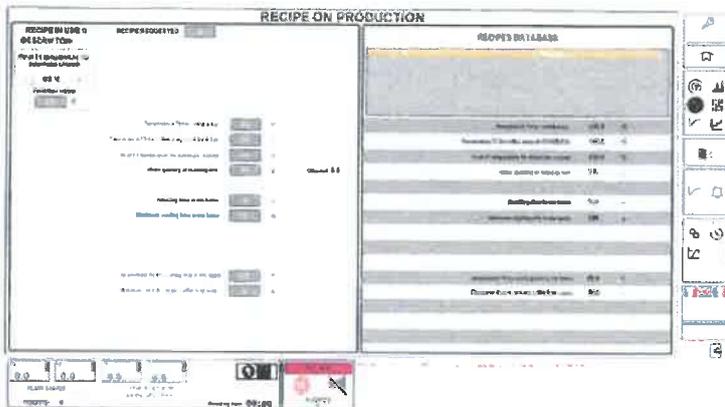
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## Automation system architecture

The system will be based on a Siemens Simatic S7 1500 PLC connected in an Ethernet network via a Hub to a Personal Computer (located in the control room) and to an operator panel installed on the machine (touch panel) with supervision and diagnostic functions.

The system provides for the possibility of dual management:

- automatic or manual through the above-mentioned supervision systems
- new enhanced programme for controlling the roasting cycle, which guarantees perfect homogeneity of the roasting process
- roasting control in 2 modes: set-point or roasting profile slope control
- alarm archive, recipe archive (maximum number of 100)
- remote control panel for emergency water supply, motor movement and burner immediate stop buttons



## Operator (Supervisor) interface configuration

- n. 1 Personal Computer complete with
  - windows operating system
  - 18.5" wide video
  - keyboard
  - colour inkjet printer
  - INTOUCH supervision system complete with documentation
  - 100Mbit/s Ethernet network card
- n. 1 Touch-PC Asem 18.5" Wide complete with:
  - windows operating system
  - INTOUCH supervision system complete with documentation
  - 100Mbit/s Ethernet network card

## Features and performance of the new BR 18 BR18 Advanced Specialty software

### ❖ Roasting step

- Possibility of superimposing roasting profiles during roasting

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- Inserting comments and characteristic points (Yellow point, crack1, crack2, cinnamon point etc.)
- Real-time comparison of variations, drifts or changes with previous batches

❖ **Analysis phase**

- Comparison of all batches run
- Display of all process values (temperatures, valve status, etc.)
- Report roasting profiles, green usage, KPIs (production, maintenance, consumption, etc.), tasting session
- Alarm and operator intervention history

❖ **Tasting phase**

- Creation of customised evaluation sheets.
- Multi-user
- Comparison of results (roasting profile vs. in-cup tasting)

Item 7

**1 ECO 60 AFTERBURNER**

The afterburners are made according to innovative criteria compared to the classic tangential burners of current application.

They exploit a modulating burner specifically designed to thermally oxidize dust, V.O.C., CO and odors.

A flame viewer allows to verify the calibration and the combustion control.

The internal structure in thermal steel and the external aluminum mantle create a cavity for the passage and pre-heating of combustion air.

The gas supply ramp to the burner will comply with the standards of the country of destination.

The minimum reference standard is, however, the Italian standard that requires:

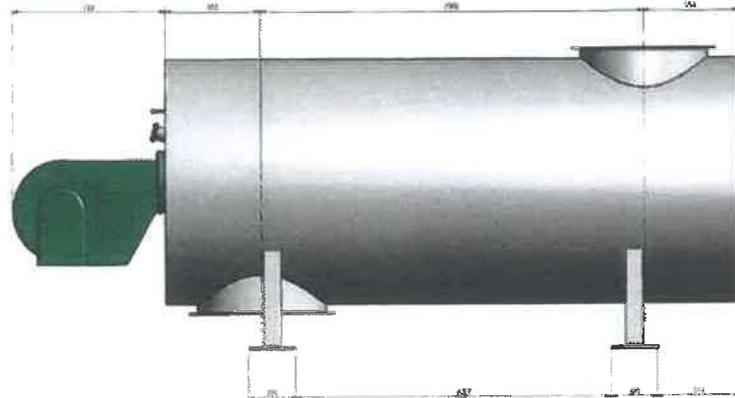
- 1 anti-vibration joint;
- 1 manual interception valve;
- 1 stabilizing filter;
- 2 solenoid valves of gas interception in class A;
- 1 electromagnetic vent valve in class B;
- 1 air pressure switch in addition to the flame control equipment.

The solenoid valves and the equipment present in our smoke burners are CE marked.

The operation of the device is managed by the control panel positioned in the most suitable place for the operator or integrated in the existing electrical panel in case of application on Brambati production machines.

Both solutions allow the visualization of the working temperature, of the signals of functioning anomalies in addition to the commands of manual or automatic functioning for a better economy of exercise.

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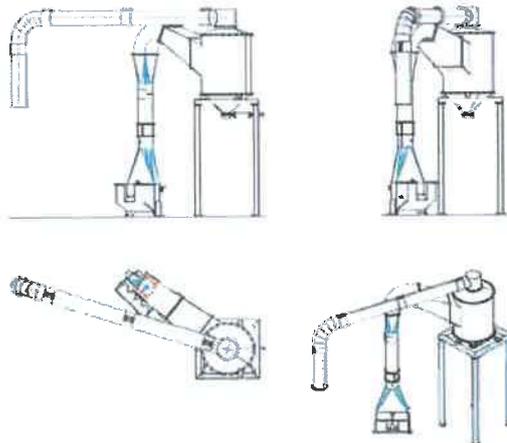
Afterburner suitable for the abatement of dusts, V.O.C., CO and odors from the process air, coming from a coffee roaster of 60 Kg/batch

Technical specifications:

- AISI 304 outer body with circular section.
- Heat generator for methane /LPG gas complete with valve train or diesel fuel complete with accessories.
- Electric control panel or integration in the existing one (if supplied by Brambati) equipped with temperature display and all that is necessary for proper operation.

Item 8

## 1 DE-STONER for roasted coffee



- the machine is assembled to the roaster with a capacity 60 kg/batch
- carbon steel construction
- loading tube with striking plate and dumper to control the flow
- expansion chamber with inside chute
- discharge branch with pneumatic dumper
- adjustable speed dumper by handle

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Item 9

**1 2WAYS-VALVE**

in sheet construction, automatic model  
- connections

Item 10

**1 "Z" BUCKETS ELEVATOR**

with double operation to load roasted silos and as well loads the hopper above packaging machine:

- foot length 5 mt.
- height 6 mt.
- head length 13 mt.
- capacity 1 Ton/h.
- carbon steel construction
- head with convex pulley in tap to the reduction group
- control motor
- foot with pulley assembled on travelling stands adjustable for the strap tension
- chain with buckets
- loading points 2
- unloading points 4

**3 2WAYS-VALVE**

in sheet construction, automatic model  
- connections

Item 11

**6 STORAGE SILOS**

for roasted coffee, each one with following characteristics:

- capacity 2 c.m., approximately 500 kg
- silo with feet on the floor
- hopper and cylindrical part in composed elements
- control window
- maximum and minimum level indicator
- n. 6 pneumatic unloading
- n. 6 inner unloading devices
- sailor staircase and protection railings

Item 12

**1 MIXER**

horizontal type, with a capacity of 400 kg, on loading cells, composed by:

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- stainless steel body
- driving shaft assembled on supports
- arm cross with cross flows adjustable baffles
- closed control motor
- unloading outlet

**NOTE:** the max error admitted from the supplier of the loading cells is of  $\pm 0,5\%$  on the bottom scale values of the mechanical scale

Item 13

## 1 HOLDING TANK

with carbon steel construction

- capacity of 200 kg
- top and bottom level indicators
- inner unloading device
- automatic unloading
- support frame

Item 14

## 1 CONTROL PANEL

for the control and automation of the above described equipment; feeding 380V Hz. 50, composed by:

- n. 1 metallic box for the floor fixing, filled and painted
- three-pole automatic switch, micro switches for safety doors, voltmeter, volts metric commuter, mono phase utility tap, emergency mushroom push button, ampere meter, current reducer
- 3 and 2 ways selectors for motors control
- signaling lamps, stop/start push-buttons controls
- transformers, protection valves, stabilized feeder, set of RC groups for assembling on the contactors, general terminal board

### Automation Architecture

The system is based on 1 PLC SIEMENS S7/1500. The supply will include a personal computer with the scope to interface between Operator and Supervisor

#### Software characteristics:

- Supervision in automatic of the plant
- Alarm diagnosis on Supervisor
- On the video will appear the plant pages or input in Mandarin language

#### Operator Interface Configuration (Supervisor):

- n. 1 PC Configuration will be done during the panel execution
- n. 1 Video color 26" SVGA Power Saving
- n. 1 Printer A4

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- supervision system, documentation and hardware key

/// **General criteria to design the software:**

Il software will be designed to obtain, compatibly to the possibility of the machine available, the maximum level of automation, minimizing the request of operator intervention, production down time and reduce times to look for the problem. The system will be capable to handle and manage the data and information for the raw material (warehouse) and were scale are available the production performances

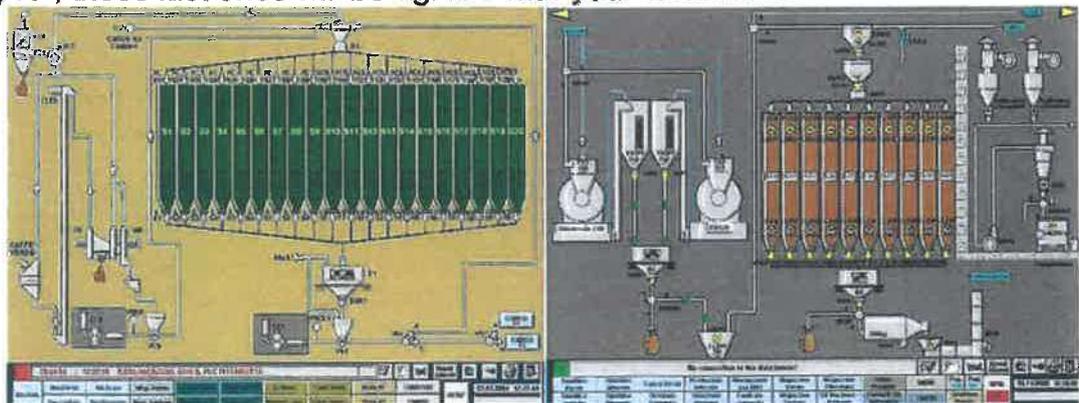


/// **Operator Interface:**

The operator will run the plant working on a terminal station with key board, video and printer. On the unit a color graphic of the synoptic will be show. By the terminal station you can program any parameter of the process (recipe, working time, set point, etc.), start production cycles and collect the main plant data (raw material storage, daily consumption, production loss, etc.) and to receive and handle any eventual alarm. All information collected can be print including terminal table.

/// **Video synoptic:**

general synoptic pages of the plant and pages for single parts of the plant itself will be displayed , these last ones will be agreed with your technicians



/// **Plant management:**

Program controls all motors and electro valves of the production cycle, by assuring the correct starting sequences and by controlling all the eventual safety performances to avoid machinery damaging. Control sequences are made to divide the plant in 2 interpedently functional blocks by optimizing plant resources and by supervising the max control flexibility

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/// **Storage**

for each component supplied:

- stock and working, shift or day beginning.
- total discharged quantity (this value is automatically updated if the plant is equipped with electronic control of the arrival goods, on the contrary it must be updated by the operator).
- total discharged quantity (sent to the working process)
- real stock of the component. These data can be displayed in each moment and automatically prompted at the end of the working cycle, shift or day or if required by the operator

/// **Alarms managing (diagnostics)**

The program is studied to signal to the operator any failure (that could create problem to the correct working process) as alarm with its description and the cause of the alarm itself, in this way the operator will be informed in every moment about the cause of any eventual process stop. Following are alarm type for each single component of the plant:

/// **motors :**

- thermic protection
- contact breaker failure (if needed)
- disconnecting switch opening (if needed)

/// **pneumatic transports:**

- safety pressure-gauge intervention
- max time for transport

/// **resting tanks:**

- max level intervention (if foreseen)
- level failure during the emptying phase.

/// **storage silos:**

- max level intervention (during the cycle)

/// **safety micro switch:**

- inspection doors opening during the working of the machinery (if foreseen)
- limit-switch intervention during the automatic positioning of machinery parts (if foreseen)

/// **controls on electric panel and PLC**

- auxiliary tensions lacking
- failure on IN/OUT modules or on their connection to the central unit
- failure on "intelligent" modules or on their connection

**EX-WORKS TOTAL AMOUNT € 652.470,00**

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**EX-WORKS DISCOUNTED TOTAL AMOUNT € 575.000,00.=**



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## REMOTE-ASSISTANCE - HOT LINE

composed eWon device to be connected to an ADSL line (ADSL line is Customer scope of supply)

PRICE € 2.590,00.=

## MECHANICAL ASSEMBLY

supervision of n. 1 technician for 68 days at € 620,00/day

## ELECTRICAL FIELD TESTING

n. 1 Brambati electrician for 22 days including assistance to testing at € 680,00/day

## TESTING, START-UP AND TRAINING

n. 1 Brambati SW technician for 15 days at € 880,00/day

**NOTE** during the testing phase Customer will have to provide an ADSL line (or fast internet connection) which must be available for our technician; if not available an ADSL line, it is required a traditional phone line

## EXCLUSIONS/AT YOUR EXPENSE

- for each of our technicians: air tickets (round-trip), shuttle from/to airport, days of travel, lodging and board, local transport during the entire stay
- transport and unloading of goods upon arrival on site and storage in a safe place
  - manual-labor for the mechanical assembly (3 skilled technicians), lifting and handling devices, for the entire period
  - electro/pneumatic installation at the site (including all materials and wiring) with obligation of the Supplier to send the appropriate documentation for the fulfillment of Brambati issuance of documents required by law
  - compressed air, motive power
  - 1<sup>st</sup> testing and starting of the heat generators (burners) of roaster and afterburner
  - water feeding
  - anything not specifically mentioned in the offer

## GUARANTEE

1 year. Guarantee material repairs are at our factory; at your expense the costs of trips, lodging and boarding, tools helpers (electrical parts not included)

**Note:** General supply conditions are intended as accepted, also if not signed, with the reception of the 1<sup>st</sup> payment agreed on the basis of the offer/order confirmation issued.

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GENERAL SUPPLY CONDITIONS

General rules

1. These general supply conditions, unless exceptions are expressly made in writing by the parties and accepted in writing as well, govern any supply contract for machinery finalised with Brambati S.p.A. (*hereinafter referred to also as Brambati*).
2. Any oral agreements, statements or commitments made by agents, employees and executives of Brambati occurring before, at the same time or after signing these conditions shall not be binding for Brambati, unless confirmed by Brambati in writing.
3. Orders, in any form sent by the customer, shall not be binding in any way for Brambati, without its express acceptance. In the event of a contrast between the customer's purchase order and these supply conditions, these conditions shall have precedence, unless otherwise desired by Brambati and expressed in writing. Likewise, in the event of a discrepancy between the order and Brambati's confirmation, the confirmation shall have precedence.
4. Unless otherwise indicated in the offer, the prices indicated by Brambati shall be considered ex-works net of taxes, shipping costs, customs and other charges, including fiscal.
5. **Delivery date: about 5 months ex-works, after lay-out confirmation and down payment receipt ex-works**

The delivery dates for products, if established, refer to the date the sold goods are picked up by the shipper and shall start from the customer's performance of the charges and obligations it is liable for, for example submission of documents and/or designs and/or technical specifications or payment of any advances agreed upon between the parties. The delivery dates shall be considered solely as a guideline and not essential and any delays – as long as not over 60 days compared to the established date – shall not result in any liability for Brambati and/or any request for compensation for damages advanced by the customer to Brambati. Any delays in delivery attributable to the customer shall not result in any variation in the payment due dates for the consideration due to Brambati, which shall remain as contractually established.

6. Force majeure, accidents and all exceptional events which may prejudice the regular dispatch of the order, for example delays in delivery by Brambati's suppliers, trade union disputes, lack of material and energy, provisions from government Authorities as well as restrictions on imports and exports, shall give Brambati the right to extend the delivery date as necessary or, if dispatch of the order is compromised or made impossible, to completely or partly withdraw from the contract, without giving the customer the right to any claims for damages. Brambati shall also have the right not to dispatch the order – even if confirmed – and/or suspend its execution, if the customer is subject to bankruptcy proceedings and/or failed to pay the amounts established as an advance and/or balance of the price within the established due date, including in relation to other and different contracts with Brambati.

7. If no technical specification is supplied by the customer and accepted by Brambati, if such specification is necessary for dispatching the order, the specifications adopted shall be those indicated by Brambati and cannot be disputed by the customer and/or used as a reason for suspension and/or failure to make payments for the sums due to Brambati.

8. The specifications that are shown in all of the commercial documents, (catalogues, etc.), are for use as a guideline and are not binding on Brambati, which may up to its discretion change them without necessarily having to give prior warning. The design, technical, dimensional and protective quality of the goods supplied, is within Brambati's quality standards. The buyer has the obligation to become familiar with such standards before ordering the supply.

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In the absence of specific requests from the buyer, the machinery sold by Brambati shall have the following specifications:

- (i) voltage: 415V;
- (ii) frequency: 50 Hz;
- (iii) colour: standard.

**Customer obligations**

9. The customer is responsible for:

- a) purchase, laying and hook up necessary for making the connections from the electricity system to the machinery;
- b) purchase, laying and hook up of pneumatic cables, as well as related fitting;
- c) purchase of a compressor with a 6 bar capacity, equipped with purification filter and distribution line;
- d) set up of water systems and masonry work, for example but not limited to, the pits for the machinery to put underground, which should be prepared before the supply, including the covers for the pits;
- e) supply of electricity, work instruments, crane and anything else which may be needed to unload and assemble the machinery, upon request of the shippers, assemblers and technicians;
- f) supports for the tanks, support shelves, support U bolts, pipes, intermediate floors and all other instruments not expressly specified in the offer;
- g) costs of machinery packaging;
- h) shipping charges for the machinery;
- i) stamp duty for promissory notes and/or drafts;
- j) the charges for assembly and testing are not included in the offer. To this end Brambati points out that the payment of the technicians assigned with assembly of the machinery is calculated at an hourly rate, with reference to the current rates at the time of delivery, plus travel expenses, room and board and any overtime. The hours of work shall be charged to the customer even if the technicians are unable to work due to causes not attributable to them.

**Shipment: not included – ex-works**

10. Shipment of the machinery will occur, unless otherwise established, completely at the customer's expense who, in this regard, cannot object in any manner to the possibility of using shipping prices and vehicles which are less expensive than those used by Brambati.

**Disputes and complaints for defects**

11. Any disputes for recognisable and clear defects related the subject of the order shall be communicated to Brambati in writing within eight days from their discovery. The above deadline is considered mandatory and the customer shall forfeit its right to the warranty for failure to comply with such deadline.

12. Any disputes due to incomplete or incorrect deliveries shall be immediately submitted to Brambati in writing and shall appear on the shipping document or other documents at the time the goods are received. In any case they shall be reported to Brambati within eight days from delivery, or any right shall be forfeited.

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**Warranties and liabilities**

13. Brambati declares and guarantees that the machinery which is the subject matter of the supply have been built in complete compliance with current national and international laws. Brambati also guarantees that the supply meets its own quality standards. If the buyer is not up to date with payments, such circumstance shall result in termination of the effectiveness of any warranty.

14. Without prejudice to the time limits of the warranty for defects provided by pro tempore current laws, the following shall not be covered by warranty by Brambati, even if they occur during the warranty period:

- any damage occurring during transportation, unless such transportation is performed directly by Brambati;
- damage and malfunctions due and originating from insufficiency or inadequacy of the electrical, water or supply system of the customer, or from environmental, weather or other types of conditions;
- damage due to normal wear and tear from use of the product;
- damage and malfunctioning due to improper and incorrect use of the product not in compliance and in contrast with the indications for use shown in the instructions provided by Brambati;

15. Intervention of Brambati's technicians, pick up of the product, its repairs and any replacement shall occur within deadlines compatible with Brambati's organisational needs and be performed by authorised and qualified technicians, upon the customer's request. In any case, Brambati agrees to perform them as quickly as possible.

16. If the customer directly performs or has performed any repair and/or maintenance and/or any other type of work on the system and/or goods which are the subject matter of the contract with Brambati by personnel not from and/or not indicated by Brambati, the customer shall forfeit its right to the warranty with Brambati, and such warranty will no longer be valid and lose all effectiveness. The customer shall also forfeit the right to the warranty if it uses accessories and/or spare parts not supplied by Brambati on the system and/or goods which are the subject matter of the contract.

17. If the machinery which is the subject matter of the supply manifests a flaw or defect included in the warranty provided by Brambati, Brambati shall, up to its sole discretion, repair or replace it, all or in part, limited to the flawed or defective parts. The machinery parts which are replaced shall become the property of Brambati and not be returned. In the cases cited in this article the shipping, packing, assembly and reassembly expenses as well as any travel expenses connected with interventions under warranty shall be fully borne by the customer. The duration of the warranty shall not be extended nor shall the warranty itself be renewed due to repairs or replacements.

**Liability**

18. Brambati's liability for any damages sustained by the buyer due to flaws and/or defects in machinery supplied by Brambati is limited to damages which amount to an immediate and direct consequence of such flaws and/or defects; compensation for any indirect damages, of any type, is excluded.

**Retention of title**

19. The title of the system and/or the goods which are the subject matter of this contract shall remain Brambati's until complete payment of the price, including after delivery to the customer.

20. In the event of initiatives by third parties on products covered by retention of title, and in particular attachment or confiscation, Brambati shall be immediately informed of such fact.

21. If the customer fails to pay, all or in part, for the supplies by the due dates, Brambati may repossess the delivered products, by making a simple request. Notwithstanding the above, the customer shall be liable for any damages and loss which occur after the delivery including due to accidents, force majeure or other events not attributable to the customer.

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**Payments: 30% at the PO (see annex 1)**  
**60% at the advice of goods ready for dispatching**  
**10% at positive testing**

**22.** In the event of late payment for what is due to Brambati, interest in arrears as per Italian Legislative Decree 231/2000 shall start automatically and be owed by the customer from the day after the due date until payment of the balance. In such case, Brambati shall also have the right to suspend performance of the order.

**Confidentiality**

**23.** The parties agree to keep all confidential information they learn of during the course of this contract confidential for its entire duration.

**Technical specifications and industrial property**

**24.** The specifications, drawings, statements of work, samples, models, equipment and documents which Brambati communicates for any reason to the customer shall remain the property of Brambati and the customer agree to keep such confidential and only use it for performance of this contract.

**Express termination clause**

**25.** Brambati shall have the right to terminate the supply contract should at least one of the following cases occur:

- failure to pay or late payments of the sums due to Brambati for an amount greater than 10%;
- violation of the provisions contained in articles 23 ("*Confidentiality*") and 24 ("*Technical and industrial specifications*") of these "*General conditions*";
- submission of customer to bankruptcy proceedings, lodging of debt claims against the customer,
- worsening of the customer's equity and/or financial situation after finalisation of the contract and/or decrease of assets, such as to make it impossible to pay the sums due to Brambati;
- failure of the customer to issue the personal guarantee and/or collateral to Brambati which is contractually established by the parties.

**Processing of personal data**

**26.** Pursuant to Italian Legislative Decree 679/16 regarding the protection of personal data, we inform that for the administrative management of the contract in progress, Brambati uses and treats some personal data like general data (surname, name, address, telephone number, email address) of the legal representative/corporate referent.

Personal data are always treated in full compliance with the principle of proportionality of treatment, according to which all personal data and the various methods of their processing must be relevant and not excessive in relation to the purposes pursued.

The purposes of the treatment are:

- For administrative and operative management of the activity covered by the contract;
- For tax compliance and communications to the financial administration;
- For the fulfillment of legal and contractual obligations connected to the contract.

The lawfulness of the treatment based on:

- Execution of obligations arising from a contract (pursuant to art. 6.1, let. b) of GDPR);
- Fulfillment of the obligations provided by law (ex art. 6.1, let c) del GDPR).

The provision of personal data is mandatory for all that is required by legal and contractual obligations and, therefore, any refusal to supply them in whole or in part may give rise to the impossibility of executing the contract or performing correctly all the obligations related to the contractual relationship.

The customer has the faculty to exercise his own rights indicated by the Capo I) of the Italian Legislative Decree UE 678/16 within the limits and conditions foreseen by the articles art. 15-23.

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15-23  
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The extended information is available at the address [www.brambati.it/](http://www.brambati.it/)

**Governing law and jurisdiction**

27. Machinery sales contracts finalised by Brambati are governed by Italian laws, unless otherwise established in writing.

28. Any dispute regarding, related to and/or connected with the validity, interpretation, performance and/or termination of a machinery sales contract finalised by Brambati shall be referred to the Italian court system and specifically the Court of Milan, unless otherwise established in writing.

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Messrs.  
HORSES AND Chariots LTD  
INBAR 17 – St. Barkan Industrial Zone  
4482000 – Israel

Codevilla, 16.08.2022

No. INV. P.0816/22	DATA/DATE 16.08.22	N. PAGE 1	COD. CLIENTE	
RIF. ORDINE/ORDER		SPEDIZIONE A MEZZO/SHIPMENT BY: =ex-works		
CONSEGNA/ DELIVERY: 5 months ex- works from after confirmation and down payment receipt				
CONDIZIONI DI PAGAMENTO//TERMS OF PAYMENT : 30% at the order – 60% ad the advise of goods ready for shipment – 10% at positive testing – bank details : Popolare di Sondrio – city of Voghera – IBAN code : IT26 V056 9656 4000 0000 3600 X 33 – BIC code POSOIT22				
<p>Order confirmation n. C633/21 – coffee processing plant with 60kg/batch roaster equipped with :</p> <ul style="list-style-type: none"> <li>n. 1 unloading hopper for green coffee</li> <li>n. 1 pneumatic line with cap. of 1,5ton/h</li> <li>n. 1 – 2ways diverter valve</li> <li>n. 1 automatic distributor with 9 ways</li> <li>n. 9 silos for green coffee with cap. 1,5ton and accessories</li> <li>n. 1 scale with cap. of 60kg</li> <li>n. 1 roaster mod. BR 60 –BR18 advanced specialty sw</li> <li>n. 1 eco 60 afterburner</li> <li>n. 1 destoner</li> <li>n. 1 -2was valve in sheet</li> <li>n. 1 bucket elevator</li> <li>n. 2 – 2ways valves</li> <li>n. 6 storage silos with cap. 2 c.m. and accessories</li> <li>n. 1 mixer on loading cells with cap. of 400kg</li> <li>n. 1 holding tank with cap. of 200kg and accessories</li> <li>n. 1 control panel</li> </ul> <p>TOTAL AMLOUNT AGREED EURO 575.000,00=</p> <p style="text-align: right;"><b>30% advance payment Euro 172.500,00=</b></p> <p>Mechanical assembly ; n. 1 supervisor at Euro 620,00/day Electrical field testing ; n. 1 electrician at Euro 680,00/day Testing, start up and training : n. 1 sw technician at Euro 880,00/day</p> <p>EXLUSIONS : air tickets, shuttle from/to airport, travel days, lodging and board, local transport, transport and unloading of the goods, man labor for the mechanical assembling, lifting devices, electro pneumatic installation, compressed air, 1<sup>st</sup> test and starring of the burners, water and utilities, all what specified</p>		Unit price	Quantity	Total amount

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Ns/Rif. HORSES AND CHARIOTS1 - ordine

**Messrs.**

**HORSES AND CHARIOTS Ltd.  
INBAR 17  
St. Barkan Industrial Zone  
4482000 (Israel)**

**Codevilla, 15/08/2022**

**Subject : Order confirmation related to offer n. 281/22**

**1 CHAFF PRESSING SYSTEM**

composed by:

- n. 1 chaff extraction line from the roaster, equipped with:
  - n. 1 electrofan
  - n. 1 connection to the pipe
  - transport pipe
- n. 1 cyclone with star valve
- n. 1 expansion tube
- n. 1 outlet pipe
- n. 1 diverter valve
- n. 1 support frame
- n. 1 chaff pressing machine for roasted coffee chaff, complete with:
  - tank with inspection door and level; construction in painted carbon steel
  - base with rotating radial extractor for pre-compression room feeding
  - closed circuit oleodynamic gearcase controlled by electrovalves
  - carbon steel support frame with adjustable height
  - extruder for compacted chaff (briquette)
  - electric control panel for machine ON/OFF
  - water spraying system
  - the machine is suitable to work the product arriving from n. 1 roaster

**PRICE EX-WORKS € 46.000,00.=**

**DISCOUNTED PRICE EX WORKS € 43.500,00=**

**MECHANICAL ASSEMBLY**

supervision of n. 1 technician at € 620,00/day

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**ELECTRICAL FIELD TESTING**

n. 1 Brambati electrician including assistance to testing at € 680,00/day

**TESTING, START-UP AND TRAINING**

n. 1 Brambati SW technician at € 880,00/day

**EXCLUSIONS/AT YOUR EXPENSE**

- for each of our technicians: air tickets (round-trip), shuttle from/to airport, days of travel, lodging and board, local transport during the entire stay
- transport and unloading of goods upon arrival on site and storage in a safe place
  - manual-labor for the mechanical assembly (3 skilled technicians), lifting and handling devices, for the entire period
  - electro/pneumatic installation at the site (including all materials and wiring) with obligation of the Supplier to send the appropriate documentation for the fulfillment of Brambati issuance of documents required by law
  - compressed air, motive power
  - 1<sup>st</sup> testing and starting of the heat generators (burners) of roaster and afterburner
  - water feeding
  - anything not specifically mentioned in the offer

**GUARANTEE**

1 year. Guarantee material repairs are at our factory; at your expense the costs of trips, lodging and boarding, tools helpers (electrical parts not included)

**Note:** General supply conditions are intended as accepted, also if not signed, with the reception of the 1<sup>st</sup> payment agreed on the basis of the offer/order confirmation issued.

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GENERAL SUPPLY CONDITIONS

General rules

1. These general supply conditions, unless exceptions are expressly made in writing by the parties and accepted in writing as well, govern any supply contract for machinery finalised with Brambati S.p.A. (*hereinafter referred to also as Brambati*).
2. Any oral agreements, statements or commitments made by agents, employees and executives of Brambati occurring before, at the same time or after signing these conditions shall not be binding for Brambati, unless confirmed by Brambati in writing.
3. Orders, in any form sent by the customer, shall not be binding in any way for Brambati, without its express acceptance. In the event of a contrast between the customer's purchase order and these supply conditions, these conditions shall have precedence, unless otherwise desired by Brambati and expressed in writing. Likewise, in the event of a discrepancy between the order and Brambati's confirmation, the confirmation shall have precedence.
4. Unless otherwise indicated in the offer, the prices indicated by Brambati shall be considered ex-works net of taxes, shipping costs, customs and other charges, including fiscal.

**5. Delivery date: October 2022**

The delivery dates for products, if established, refer to the date the sold goods are picked up by the shipper and shall start from the customer's performance of the charges and obligations it is liable for, for example submission of documents and/or designs and/or technical specifications or payment of any advances agreed upon between the parties. The delivery dates shall be considered solely as a guideline and not essential and any delays – as long as not over 60 days compared to the established date – shall not result in any liability for Brambati and/or any request for compensation for damages advanced by the customer to Brambati. Any delays in delivery attributable to the customer shall not result in any variation in the payment due dates for the consideration due to Brambati, which shall remain as contractually established.

6. Force majeure, accidents and all exceptional events which may prejudice the regular dispatch of the order, for example delays in delivery by Brambati's suppliers, trade union disputes, lack of material and energy, provisions from government Authorities as well as restrictions on imports and exports, shall give Brambati the right to extend the delivery date as necessary or, if dispatch of the order is compromised or made impossible, to completely or partly withdraw from the contract, without giving the customer the right to any claims for damages. Brambati shall also have the right not to dispatch the order – even if confirmed – and/or suspend its execution, if the customer is subject to bankruptcy proceedings and/or failed to pay the amounts established as an advance and/or balance of the price within the established due date, including in relation to other and different contracts with Brambati.

7. If no technical specification is supplied by the customer and accepted by Brambati, if such specification is necessary for dispatching the order, the specifications adopted shall be those indicated by Brambati and cannot be disputed by the customer and/or used as a reason for suspension and/or failure to make payments for the sums due to Brambati.

8. The specifications that are shown in all of the commercial documents, (catalogues, etc.), are for use as a guideline and are not binding on Brambati, which may up to its discretion change

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Fax Comm 0383/373078 / Fax Tech. 0383/373114 – e-mail. info@brambati.it – www.brambati.it P.I.V.A. e C.F. 00516930187- Cod SDI: M5UXCR1  
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them without necessarily having to give prior warning. The design, technical, dimensional and protective quality of the goods supplied, is within Brambati's quality standards. The buyer has the obligation to become familiar with such standards before ordering the supply.

In the absence of specific requests from the buyer, the machinery sold by Brambati shall have the following specifications:

- (i) voltage: 415V;
- (ii) frequency: 50 Hz;
- (iii) colour: standard.

**Customer obligations**

9. The customer is responsible for:

- a) purchase, laying and hook up necessary for making the connections from the electricity system to the machinery;
- b) purchase, laying and hook up of pneumatic cables, as well as related fitting;
- c) purchase of a compressor with a 6 bar capacity, equipped with purification filter and distribution line;
- d) set up of water systems and masonry work, for example but not limited to, the pits for the machinery to put underground, which should be prepared before the supply, including the covers for the pits;
- e) supply of electricity, work instruments, crane and anything else which may be needed to unload and assemble the machinery, upon request of the shippers, assemblers and technicians;
- f) supports for the tanks, support shelves, support U bolts, pipes, intermediate floors and all other instruments not expressly specified in the offer;
- g) costs of machinery packaging;
- h) shipping charges for the machinery;
- i) the charges for assembly and testing are not included in the offer. To this end Brambati points out that the payment of the technicians assigned with assembly of the machinery is calculated at an hourly rate, with reference to the current rates at the time of delivery, plus travel expenses, room and board and any overtime. The hours of work shall be charged to the customer even if the technicians are unable to work due to causes not attributable to them.

**Shipment: not included – ex-works**

10. Shipment of the machinery will occur, unless otherwise established, completely at the customer's expense who, in this regard, cannot object in any manner to the possibility of using shipping prices and vehicles which are less expensive than those used by Brambati.

**Disputes and complaints for defects**

11. Any disputes for recognisable and clear defects related the subject of the order shall be communicated to Brambati in writing within eight days from their discovery. The above deadline

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is considered mandatory and the customer shall forfeit its right to the warranty for failure to comply with such deadline.

12. Any disputes due to incomplete or incorrect deliveries shall be immediately submitted to Brambati in writing and shall appear on the shipping document or other documents at the time the goods are received. In any case they shall be reported to Brambati within eight days from delivery, or any right shall be forfeited.

**Warranties and liabilities**

13. Brambati declares and guarantees that the machinery which is the subject matter of the supply have been built in complete compliance with current national and international laws. Brambati also guarantees that the supply meets its own quality standards. If the buyer is not up to date with payments, such circumstance shall result in termination of the effectiveness of any warranty.

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- any damage occurring during transportation, unless such transportation is performed directly by Brambati;
- damage and malfunctions due and originating from insufficiency or inadequacy of the electrical, water or supply system of the customer, or from environmental, weather or other types of conditions;
- damage due to normal wear and tear from use of the product;
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**Liability**

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18. Brambati's liability for any damages sustained by the buyer due to flaws and/or defects in machinery supplied by Brambati is limited to damages which amount to an immediate and direct consequence of such flaws and/or defects; compensation for any indirect damages, of any type, is excluded.

**Retention of title**

19. The title of the system and/or the goods which are the subject matter of this contract shall remain Brambati's until complete payment of the price, including after delivery to the customer.

20. In the event of initiatives by third parties on products covered by retention of title, and in particular attachment or confiscation, Brambati shall be immediately informed of such fact.

21. If the customer fails to pay, all or in part, for the supplies by the due dates, Brambati may repossess the delivered products, by making a simple request. Notwithstanding the above, the customer shall be liable for any damages and loss which occur after the delivery including due to accidents, force majeure or other events not attributable to the customer.

**Payments: 30% at the PO**

**60% at the advice of goods ready for dispatching**  
**10% at positive testing**

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- violation of the provisions contained in articles 23 ("*Confidentiality*") and 24 ("*Technical and industrial specifications*") of these "*General conditions*";
- submission of customer to bankruptcy proceedings, lodging of debt claims against the customer,
- worsening of the customer's equity and/or financial situation after finalisation of the contract and/or decrease of assets, such as to make it impossible to pay the sums due to Brambati;

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- failure of the customer to issue the personal guarantee and/or collateral to Brambati which is contractually established by the parties.

**Processing of personal data**

26. Pursuant to Italian Legislative Decree 679/16 regarding the protection of personal data, we inform that for the administrative management of the contract in progress, Brambati uses and treats some personal data like general data (surname, name, address, telephone number, email address) of the legal representative/corporate referent.

Personal data are always treated in full compliance with the principle of proportionality of treatment, according to which all personal data and the various methods of their processing must be relevant and not excessive in relation to the purposes pursued.

The purposes of the treatment are:

- For administrative and operative management of the activity covered by the contract;
- For tax compliance and communications to the financial administration;
- For the fulfillment of legal and contractual obligations connected to the contract.

The lawfulness of the treatment based on:

- Execution of obligations arising from a contract (pursuant to art. 6.1, let. b) of GDPR);
- Fulfillment of the obligations provided by law (ex art. 6.1, let c) del GDPR).

The provision of personal data is mandatory for all that is required by legal and contractual obligations and, therefore, any refusal to supply them in whole or in part may give rise to the impossibility of executing the contract or performing correctly all the obligations related to the contractual relationship.

The customer has the faculty to exercise his own rights indicated by the Capo III of the Italian Legislative Decree UE 678/16 within the limits and conditions foreseen by the articles art. 15 – 23.

The extended information is available at the address [www.brambati.it/](http://www.brambati.it/)

**Governing law and jurisdiction**

27. Machinery sales contracts finalised by Brambati are governed by Italian laws, unless otherwise established in writing.

28. Any dispute regarding, related to and/or connected with the validity, interpretation, performance and/or termination of a machinery sales contract finalised by Brambati shall be referred to the Italian court system and specifically the Court of Milan, unless otherwise established in writing.

**Offer Validity:**

~~20. 6 months.~~

סוסים ומרכבות בע"מ  
HORSES AND CHARIOTS LTD  
516681543 .פ.ח



Certified Company  
Certificate n°9115.SCIE

Messrs.  
HORSES AND Chariots LTD  
INBAR 17 – St. Barkan Industrial Zone  
4482000 – Israel

Codevilla, 16.08.2022

No. INV. P.0817/22	DATA/DATE 16.08.22	N. PAGE 1	COD. CLIENTE	
RIF. ORDINE/ORDER		SPEDIZIONE A MEZZO/SHIPMENT BY: =ex-works		
CONSEGNA/ DELIVERY: October 2022 ex- works from after confirmation and down payment receipt				
CONDIZIONI DI PAGAMENTO//TERMS OF PAYMENT : 30% at the order – 60% ad the advise of goods ready for shipment – 10% at positive testing – bank details : Popolare di Sondrio – city of Voghera – IBAN code : IT26 V056 9656 4000 0000 3600 X 33 – BIC code POSOIT22				
Order confirmation related to offer n. 281/22		Unit price	Quantity	Total amount
n. 1 chaff pressing system				
TOTAL AMLOUNT AGREED EURO 43.500,00=				
30% advance payment Euro 13.050,00=				
Mechanical assembly ; n. 1 supervisor at Euro 620,00/day				
Electrical field testing : n. 1 electrician at Euro 680,00/day				
Testing, start up and training : n. 1 sw technician at Euro 880,00/day				
EXLUSIONS : air tickets, shuttle from/to airport, travel days, lodging and board, local transport, transport and unloading of the goods, man labor for the mechanical assembling, lifting devices, electro pneumatic installation, compressed air, 1 <sup>st</sup> test and starring of the burners, water and utilities, all what specified				

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