



QUALITY SYSTEMS

QUICK HITCH

Production process control system



Raw Material Inspection

1. Material Inventories
2. Material reports

采购入库单

单据编号: 202308010001 单据日期: 2023-08-01

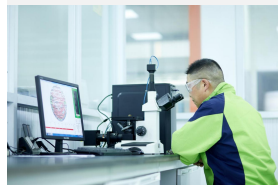
序号	材料名称	规格	数量	单位	备注
1	Q235B热轧卷板	3.0*1250*2500	1	张	
2	Q235B热轧卷板	3.0*1250*2500	1	张	
3	Q235B热轧卷板	3.0*1250*2500	1	张	
4	Q235B热轧卷板	3.0*1250*2500	1	张	
5	Q235B热轧卷板	3.0*1250*2500	1	张	
6	Q235B热轧卷板	3.0*1250*2500	1	张	
7	Q235B热轧卷板	3.0*1250*2500	1	张	
8	Q235B热轧卷板	3.0*1250*2500	1	张	
9	Q235B热轧卷板	3.0*1250*2500	1	张	
10	Q235B热轧卷板	3.0*1250*2500	1	张	



3. Inspect



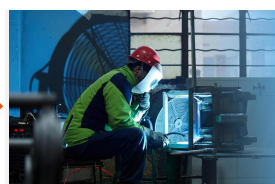
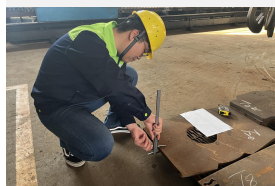
4. Inspect



Cutting

1. Cutting machines: flame & laser cutting machines for different parts of attachments.

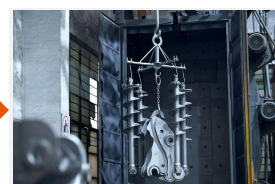
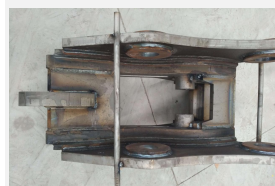
2. Inspect



Welding

1. The whole adopts oxygen-free welding, senior welder with licence, one-to-one welding, to create high-quality products.

2. Inspect



Shot-blasting

1. Remove welding oxidised iron slag, improve surface roughness, enhance anti-corrosion properties and surface strength, eliminate compressive stress, prevent cracks and prolong service life.

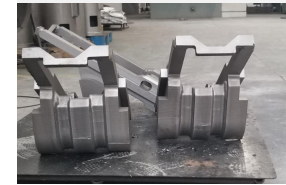
2. Inspect



Grinding

1. Clean surface burrs and irregularities to ensure surface finish.

2. Grinding Standards



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生产过程控制体系/Production process control system



CNC Machine

1. The finishing workshop is equipped with a number of CNC machines, integrating turning, milling and boring processes. This greatly improves the production efficiency and qualification rate of all our precision parts.



Boring

1. Adoption of biaxial boring equipment to ensure coaxiality.



Assembly

1. Assemble in accordance with process flow diagrams, using specialised tools and equipment to ensure tight fit of parts.



Painting

1. The factory is equipped with a semi-automatic paint spraying workshop, where most parts are sprayed with at least two coats of paint. Enhanced rust and corrosion resistance of the accessories



Finished product inspection

1. Appearance Inspection
2. Test that the cylinder works smoothly.
3. Check if the final data matches the excavator



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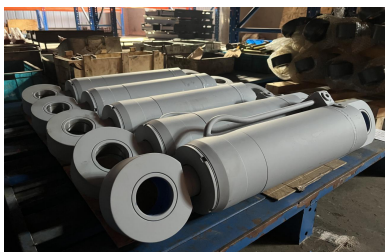
Warehousing System

Warehouse Layout and Setup Management

1. The warehouse covers an area of 800m², with shelves arranged in rows.



2. Finished parts are treated with oil to prevent rust.



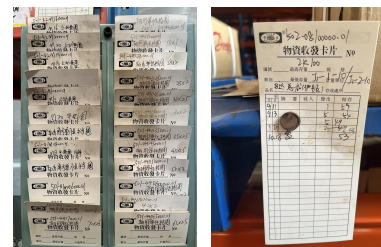
3. Warehouse set management
Kanban: visual display of the warehouse layout, marking the storage

庫位號	產品名稱	庫位號	產品名稱	庫位號
G1-1	...	G1-1
G1-2	...	G1-2
G1-3	...	G1-3
G1-4	...	G1-4
G1-5	...	G1-5
G1-6	...	G1-6
G2-1	...	G2-1
G2-2	...	G2-2
G2-3	...	G2-3
G2-4	...	G2-4
G2-5	...	G2-5
G2-6	...	G2-6

4. Zone management: Divide storage areas such as the area to be processed and the area where each item is placed to improve the efficiency of item



Material Receipt and Distribution Management

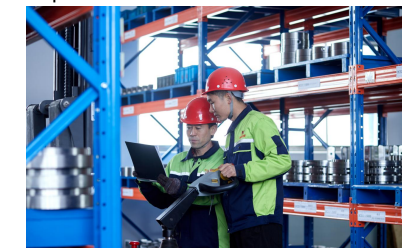


2. Inventory management: parts and components are marked and batched for inventory.



1. Material Receipt and Dispatch Card: Record the inbound and outbound information of materials to ensure the transparency of logistics information.

3. Out of the warehouse management: warehousing staff one-to-one management, according to the single shipment.



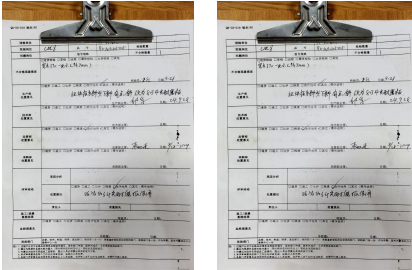
Quality Management System

● Professional team



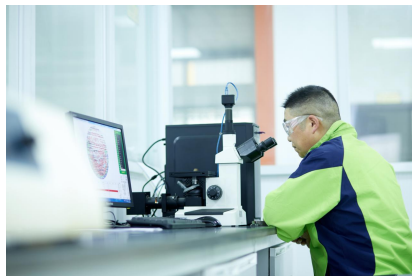
A professional team of 8 quality inspectors and 12 technicians.

● Tough process checks and problem solving



Each process is rigorously inspected to identify and actively resolve problems at the source.

● Material selection and design optimisation



Strictly control the material selection and product design, and optimise the design scheme.

● Technical support



Provide technical support according to customer needs and independently design personalised solutions.

● One-on-one quality check



One-to-one inspection of each assembled product to ensure product quality.

● Process Improvement and Durability Enhancement



Improving the quality of our products through better processing ensures that our customers buy more durable products.

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◀ Inspection system before shipment

● Appearance Inspection



Dimensional inspection: check the dimensions of the products against the drawings to see if they are in accordance with the design requirements and to ensure the consistency of the precision and specifications.



Surface treatment inspection:

Paint spraying inspection: to confirm that the uniformity, adhesion and colour of the paint spraying meet the standard.



Welding Inspection: Check the firmness and aesthetics of the welded parts to ensure that there are no defects.

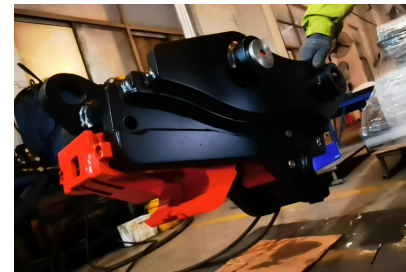


Marking and labelling check: Check whether the labels and markings on the products are correct and whether the contents are clear and complete, including the product model and batch number.

● Performance testing



Cylinder inspection: Ensure that the cylinder works smoothly.



Functionality check: Tests to ensure that it is in good working order.

◀ Packaging system

● Package handling and protective measures



Key parts are coated with anti-rust oil and wrapped with film to prevent oxidation and rust.



The exterior is packaged in wooden crates and secured with ties.



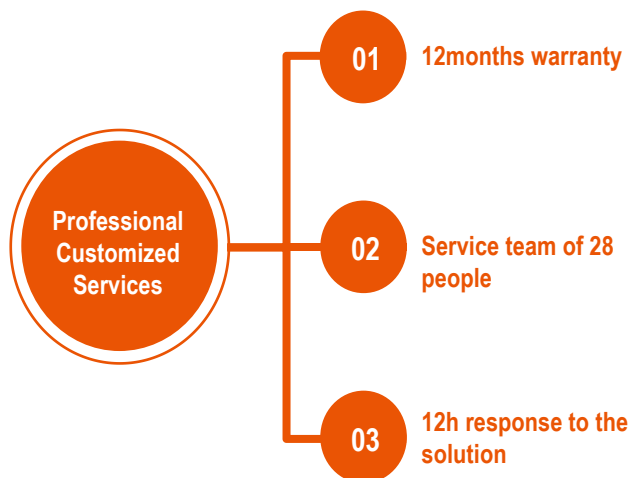
The surface of wooden crate is labelled with mark, company logo, safety logo, etc. according to customer's demand.



Send to shipping area and waiting to be dispatched.

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After-sales service system



• Warranty Policy terms

RAY Attachments DURABILITY IS THE BEST!

WARRANTY REGULATION:

RAY Attachments provides an extended guarantee according to its sales and delivery

conditions, up to twelve months from delivery.

The extended guarantee assumes proper operation and use as intended, but will be

nullified as a result of:

- Repairs or other intervention undertaken by persons not authorised by RAY Attachments.

- With use of accessories or replacement parts not approved by RAY Attachments

or which are not original replacement parts supplied by RAY Attachments.

After the warranty period has expired, we further recommend use of original replacement parts and manufacturer's replacement parts approved by RAY

Attachments.

PLEASE COMPLETE THE CUSTOMER ACCEPTANCE AND WARRANTY REGISTRATION FORM LOCATED IN THIS MANUAL - FAILURE TO REGISTER

MAY INVALIDATE YOUR WARRANTY CLAIM.

Website: www.rayattachments.com TEL: +86-85585188
ADD: No.5 Chuangshang Road Luyang Industrial Zone Wujin District Changzhou City Jiangsu Province China

RAY Attachments DURABILITY IS THE BEST!

1. Terms of Warranty

1. The scope and duration of the warranty

The Company produced sales of excavator attachments and related accessories, if in accordance with the instructions of the company use (including maintenance), from each of the parts constituting the product overall performance and manufacturers its own considerations, the warranty period to the end consumer installation from the date within 12 months, or in work time as a standard, free warranty 2000 hours. Both in the first period, whichever expires. (Range of export products warranty period is starting from the date of shipment, regardless of any circumstances not more than 18 months, both the time period less than 12 months after installation, or has been in the custody of the state unused all, it will be seen as a warranty period expires.)

2. Beyond the warranty issues

Warranty does not cover following situations even during the warranty period.

A. Caused by any alien contamination in the connector hose.

B. Caused by operating hydraulic oil contaminated.

C. Caused by using other parts from not provided by RAYMOND.

D. Caused by any alternation without approval of RAYMOND.

E. Caused by any workmanship not in accordance with Operator's manual.

F. Operating, maintenance, inspection does not under the Operator's manual.

G. With the growth of time, the products appear to fade or partial slight deformation, but does not affect the routine use

H. Malfunction caused by heavy fell, collision and other irregular operation.

I. Other durable accessories as below, not caused by material or the manufacturer itself.

a. All kinds of hydraulic seals.

b. All kinds of any mounting parts.

Website: www.rayattachments.com TEL: +86-85585188
ADD: No.5 Chuangshang Road Luyang Industrial Zone Wujin District Changzhou City Jiangsu Province China

Product Warranty: The whole machine is guaranteed for one year.

After-sales service: service team of 28 people, customer feedback after the use of abnormalities in 12 hours will be given to the solution, record every after-sales problems, and to improve, we never avoid after-sales, every after-sales will help us better perfect the product, make more durable genera.

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