

Heuft Thermo-Oel GmbH&Co.KG – Nippesstr. 15 – 56745 Bell

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Bell 14.10.2013
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**Project Sochi (Idem for Niva Volgograd)
Budget-offer 2 for Heuft Vulkan Thermo-Roll® oven**

Subject to the attached general terms of sale and delivery we would like to submit to the following offer:

HEUFT VULKAN THERMO-ROLL®



Pos.1.0 2 HEUFT Vulkan Thermo-Roll® ovens type VTR 08.13,5.10 with thermal oil circulation heat system.

Data per oven:

Number of baking chambers	1
Number of decks (hearths)	10
Baking surface dimensions	800 x 1350 mm
Total baking area	10,8 m ²
for 20 baking sheets size	645 x 800 cm
Required boiler output	65 kW
(each additional oven)	61 kW)

Delivery and positioning inside the property will be with each oven or boiler supplied as an assembled upright standing unit, complete with secondary heating circuit.

The side, front and rear panels are made of stainless steel.

SPS computer control, control column located either left or right of oven, language is English/Russian. The SPS Touch Screen control unit of the **HEUFT** Vulkan Thermo-Roll® offers the following functions using the current software release:



- Fully automated baking process with 199 baking programs consisting of 5 baking phases each.
- Linking to other ovens on site equipped with Heuft SPS to share/exchange baking programs.
- Linking of ovens and boiler system for an efficient and optimised boiler control.
- Constant monitoring of all sensor equipped oven components and safety features
- Displays upcoming maintenance work.
- Comprehensive text and help functions in case of system errors.
- Operating hours counter for all sensor equipped oven components
- Remote maintenance via analogue router (optional)
- Remote operation of the oven system from an external PC using optionally available software.

1

Steam Vent Accelerator

Every Vulkan-Thermo-Roll® oven is equipped as standard with an integrated steam vent accelerator in order to ensure optimal steam extraction even for difficult, building-related environments (poor ventilation). As a result e.g., steam cracks on bread no longer can occur.

High Performance Twin Steam Generator/Injection System

The steam system consists of **two** separate thermal oil heated **steam generators** with a built-in stainless steel injection tube each. Controlled by a solenoid valve, a specific amount of water is sprayed into the generator chambers. The resulting steam is fed through large ducts into the baking chamber.

Thermo Roll door with triple lock, door handle alternatively right or left

The triple lock ensures improved tightness of the baking oven door. A possible distortion of the chrome nickel steel oven door is therefore generally excluded.

Turbulence system for all decks

The "Turbo" is a circulation fan system which can be switched on and off as required to change a stationary (calm) baking atmosphere (radiation heat) to a circulating (agitated) one. The Turbulence blows away the insulating layer of air surrounding the baked goods, so that the full oven heat can get into direct even better crust formation and the best possible lateral stability of the baked goods.

- 1 **Steam Hood, Stainless Steel, 975 mm, illuminated,**
Mounted above the oven door, the steam hood operates like an extractor and catches and removes steam and vapours that escape during baking, or when the door is opened.
- 1 **Ventilator fan 27 cbm/m.**

Oven description:

Strictly speaking, the Vulkan Thermo Roll® oven is a multi-deck oven that is loaded like a rack oven. This means: You will achieve the same superior quality for your entire range of baked goods in the Vulkan Thermo Roll® oven as in the Vulkan thermo-oil multi-deck oven. The baking sheets are nested



between hearth plates just like in a multi-deck oven.

However, the oven is loaded as efficiently as a rack oven.

Two completely loaded rack trolleys can be pushed into the Vulkan Thermo Roll® oven one behind the other.

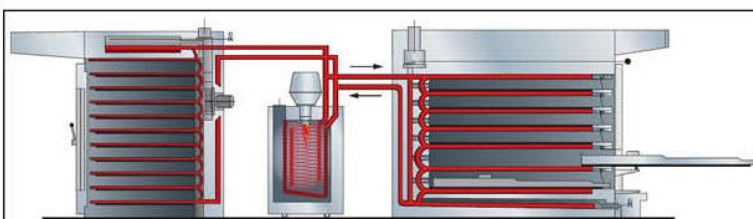
Vulkan Thermo Roll® is a complete modular unit consisting of baking chamber with 10 or more decks, steam generator, steaming unit, thermo-oil system, three-way valve and circulation pump, turbulence equipment, steam exhaust, steam hood (optionally), electrical control and all sensors and control required for safe operation.

The turbo-motor, which can be turned on and off at any time, provides for circulation of air inside the baking chamber.

Vulkan Thermo Roll® oven is heated with thermo-oil. Thermo-oil heated in the boiler is circulated through the heating plates of the oven by pumps. A three-way valve is controlling the precise flow of hot thermo-oil.

The high heat storage capacity of the thermo-oil ensures stable and uniform heat transfer. The temperature is kept at a constant level without scorching heat effects.

Vulkan Thermo Roll® oven is one of the most economic oven types after all because of the very high energy utilization coefficient, high technical standard and sturdy construction.



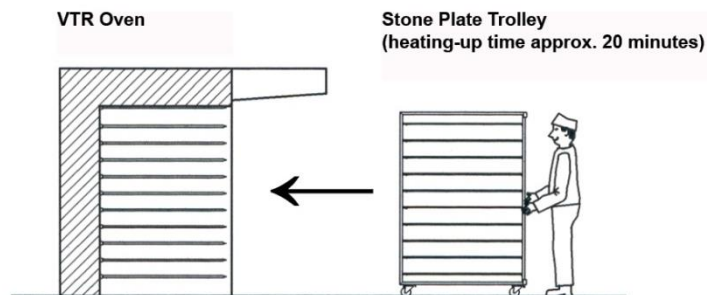
THERMAL OIL – HOW DOES IT WORK?

Baking with THERMAL OIL is based on a principle similar to that of central heating systems. The actual heating

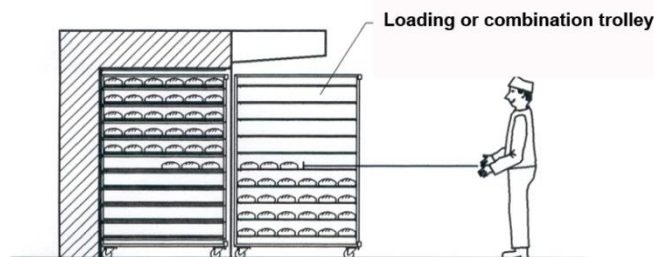
system of the HEUFT boiler is separated from the oven. The HEUFT boiler is fuelled with heating oil, gas, electricity or biomass and heats the synthetic THERMAL OIL, a perfectly safe heating medium. The hot THERMAL OIL is transferred through a pipeline system to the convection heaters in the oven. The THERMAL OIL is rapidly pumped through the open, non-pressurised system.

Baking Trolleys for Heuft Vulkan Thermo Roll® Ovens Stone Plate System

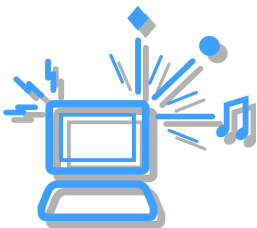
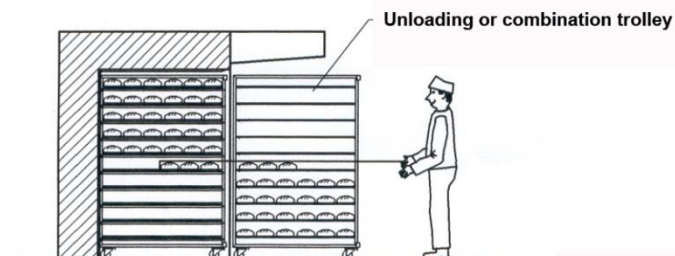
HEUFT VULKAN Thermo-Roll® oven type VTR
with a "Stone Plate Trolley"



Loading the unbaked goods onto the
stone plate trolley inside the oven



Removing the baked goods from the
stone plate trolley



Tip: there are several video clips on Youtube showing Heuft ovens in use with stone trolleys and combination trolleys.

Go to **Youtube.com** and search for "**Baking on Stone Part1**"

Pos. 2.1 2 Thermo Roll Trolley with stone plates

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Stone plate trolleys

A special baking trolley (hearth module trolley) with stone plates, stainless steel construction, suitable for VULKAN Thermo-Roll® ovens.

The stone plate trolley stays positioned inside the oven for the duration of the baking period (or stays inside the oven all the time). Loading and unloading of the products from the stone plate trolley is by use of special loading/unloading trolleys.

Flexible and versatile: The stone plate trolley can be quickly rolled out of the oven, and regular VTR trolleys can be used for baking on trays.

Heating-up of the stone plate trolley from cold takes approx. 20 minutes, after the initial heating and during regular baking the stones do not need any extraordinary re-heating periods.

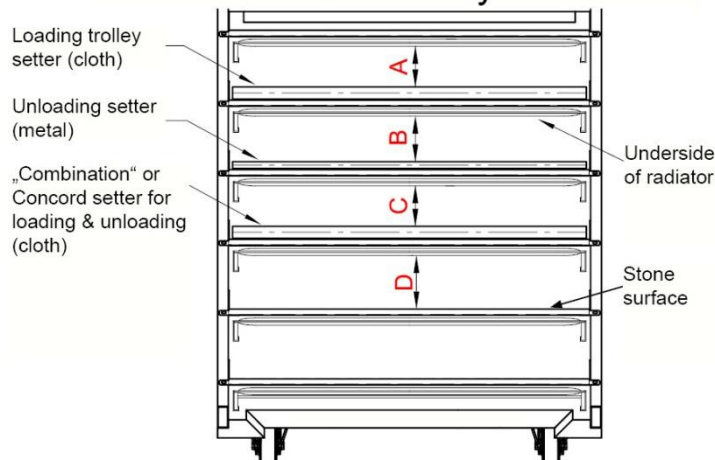


Clearances with stone plate trolley (subject to process tolerance +/- 5 mm):

Between stone surface and underside of radiator ("D"): 116.5 mm

Between Concord setter and radiator underside ("C"): 71.5 mm

VTR Stone Plate Trolley Clearances



Pos. 2.2 2 Thermo Roll Loading/unloading trolleys “Combination Trolley”, including cloth racking units

2 Thermo-Roll Loading/unloading Trolley

To load and unload your products direct onto the stone plates you need a special trolley equipped with as many setters as there are decks. The dough pieces are placed on these setters and -after proofing- the setters will deposit the products onto the stone plates. The loading will be done by pushing the setters manually into the oven, deck by deck. This handling is very easy and can easily be done by a single person.



After the products are baked they need to be picked up from the stone plates inside the oven. The setters have a sharp front edge that slides under the baked products and together with the movement of the cloth the products are quickly picked up from the stone plates.

Loading or unloading a complete oven takes usually less than a minute!

Cloth racking unit (setters)

Ball-bearing guide cloth racking unit with racking rod. Load width designed for hearth module trolley, can be pulled out from the loading trolley for drawer-like loading.



Image of similar “Combination Trolley” with setters pulled out to remove baked products.

Pos. 3.0 1 Heating boiler system consisting of

1 heating boiler type HK 140 (140 kW), suitable for heating the 2 Thermo Roll® ovens described in Pos. 1),

Delivery and assembly inside the property will be with boiler supplied as an assembled upright standing unit.

Incl. SPS touch screen control unit

1 **Weishaupt Gas burner,**

incl. drain-off tank,

incl. expansion vessel, **without** insulation,

15 double metre (flow/return) closed circular pipeline DN50 **without** insulation, **without** hanging.



The sides, front and back panels are made of stainless steel.

Description of boiler

The thermo-oil is pumped by forced circulation through the thermo-oil heated boiler, the closed circular pipeline and the connected consumers.

When the thermo-oil flows through the boiler, the heat set free by combustion is transferred to the oil and transported to the consumer. Here a heat exchange with the medium to be heated takes place.

The required flow temperature is set at the boiler control located at the baking oven. When the target temperature has been reached, the boiler control turns the burner off or the burner's output is reduced in case of infinitely variable or two-step control. If the flow temperature falls below the target value, the burner starts again or the output is increased, respectively.

The complete thermo-oil filling with fully synthetic heat transfer oil is included in the price.

In general, all our thermo-oil ovens are designed for a thermo-oil temperature of max. 320 °C. With constant further developments over the past years we achieve now a reduction of the flow temperature by additional 15-20 °C and a limitation of the thermo-oil temperature to 300 °C.

This clearly reduces energy costs and stress on the oven while increasing significantly the stability of the thermo-oil at the same time.

1 Remote monitoring system with industrial router Type ZR-200A (only in connection with HEUFTSPS computer control unit)

Remote monitoring of the complete Heuft oven system via telephone line and modem.

- Remote diagnostics and monitoring.
- Error detection and correction.
- Adjustment of set point values and system parameters.
- Remote switching of all system components.
- Software updates.
- Retrieval of upcoming maintenance work data.
- Connection module of the HEUFT oven system to a telephone system.
- Specially tested industrial quality, which conforms to industry norms for operational safety and functionality in interference-affected environments.
- Connection cable: Connection between router and oven.
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Installation requirements (provided by customer) for remote monitoring:

Analogue Connection

- Telephone socket for RJ-11 connector in direct proximity of oven or boiler.
- Separate phone number, to be dialled up externally.

VPN Connection

- VPN connection to the Heuft network with socket RJ 45
- The preferred VPN clients are ShrewSoft, OpenVPN, SonicWall oder Standard Windows

All prices given are ex-works Bell/Eifel, Germany and subject to technical changes.

Price **includes**: Assembly

Price **does not** include:

- Freight, packaging
- travel expenses, travel hours and hotel accommodation for the technicians,
- travel expenses, travel hours and hotel accommodation for the Master Baker, if requested
- VAT, other possible extra costs

For assembling of the system, we provide trained and experienced baking oven mechanics on-site.

Terms of warranty for our ovens is 1 year, according to our General sales Conditions of Business (with the exception of the burners). The basis for this warranty is annual maintenance of our ovens in one shift operation. Consumable parts such as seals, illuminates, etc are excluded from this warranty.

For our thermo-oil systems, we use large dimensioned pumps with magnetic clutch and without shaft seal!

Terms of warranty for these pumps is 1 year (according to our General Terms and Conditions of Business).

Delivery Time: To be agreed.

Price fixing: This offer is valid 3 month. We reserve the right to make technical changes.

Terms of payment: 30% on placement of the order
 60% 2 weeks before delivery
 10% four weeks after commissioning, net.

Services to be provided by the customer /not included in the price:

- technical clarification with Heuft (e.g. type, scope, date of the service)
- clarification with authorities and energy suppliers
- Fulfilment of official requirements, obtaining of all required permits needed for the installation.
- Transport and transport insurance
- forklifts or mobile cranes, scaffolding
- temporary workers for transporting the large parts at the construction site
- adaptation of the sub-floor
- connections to and from the oven/proofer/boiler/ in case of installation with Heat Recovery System
- installations for water, electricity and oil or gas supply
- the pipes for ventilation and steam removal
- raw materials / energy required for test operation

- for safety reasons, the burner is delivered, installed and maintained by a burner company which is either contracted by you directly or by us in your name; thus we cannot accept any warranty for the services of the burner company. The costs for the services provided by the burner installation engineer are therefore not included in our sales price.

For preparation of the installation site we support you with help and advice. Our site supervisor will contact you and discuss the necessary details with you.

Electrical supply

It must meet the following conditions at full load as well as at no-load operation:

Rated operational voltage, Ue	3 Ph ~ 230V/400V N/PE max. +/-10%
Measuring point	between two phases 400 V
	Phase and Neutral 230 V
	Phase and Potential Earth 230 V
Rated operational current, Ie	according to our specifications
Frequency	50 Hz, max. +/- 1%
Ambient temperature	0-35°C
Air humidity	max. 95% at 25 °C no condensation
Site altitude	0-1000 m above sea level
Rated conditional short-circuit current, Iep	10 kA
Rated impulse withstand current, Ipk	14 kA

Surge-proof boiler fuse protection.

Further operation of the system is not guaranteed in case of voltage cut-off.

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You will not only receive all required plans from us in sufficient time, but your workers can also contact us at any time. This all saves time and money. Unfortunately we must charge you for any delays in installation caused by inadequate preparation of the installation site.

We look forward to the delivery from this oven, specially made on your request, and we want to thank you for your trust in our company

Sincerely yours,
Heuft Thermo-Oel GmbH&Co.KG



i.A. Tzur Gannot

Not covered by warranty:

1. Technical Support work, that can be attributed to improper operation (non-observance of Operating Instructions), deficient of improper servicing and maintenance/ cleaning and operational sources (e.g. water damage to controls panels and systems).
2. Technical Support work, that can be traced to cleaning and maintenance work.
3. Components subject to wear (including technical support costs incurred)
 - Drainage, spray device, magnetic valves attributed to clarification (lime formation)
 - Lighting system, control and message devices
 - Door seals
 - running rail at trolley drive
 - Hearth plates of artificial stone, in the event of hair-line cracks (deck ovens)
 - Textile and chain conveyors (on the loading device Concord)
 - Fuses, relays, protective devices, etc. in electric cabinets and in the control panel.....and similar components.....
4. Burner (furnace)
In the event of power failure, the burner supplier must be informed