

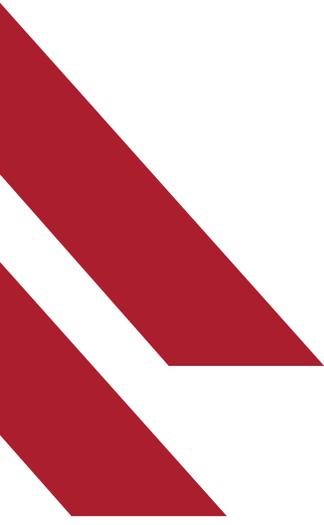
Thinking About Buying A Volumetric Mobile Mixer?



12 Things You Need To Know

Volume 2 | Summer 2019

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Who Are Volumetric Concrete Mixers For?

Because volumetric mixers have a wealth of application abilities, it's easy to understand how some tend to believe these units are for niche users. Yet, being able to design, produce, and pour concrete individually gives you control on the final product from start to finish.

Concrete Delivery

Concrete delivery companies rarely have downtime and if it happens, the situation affects everyone involved. But a mobile volumetric mixer eliminates the stresses of hot loads and overages and/or shortages while streamlining your ability to move quickly between deliveries. The ability to change design mixes at a moment's notice gives you the flexibility to accommodate a last-second change or new customer.

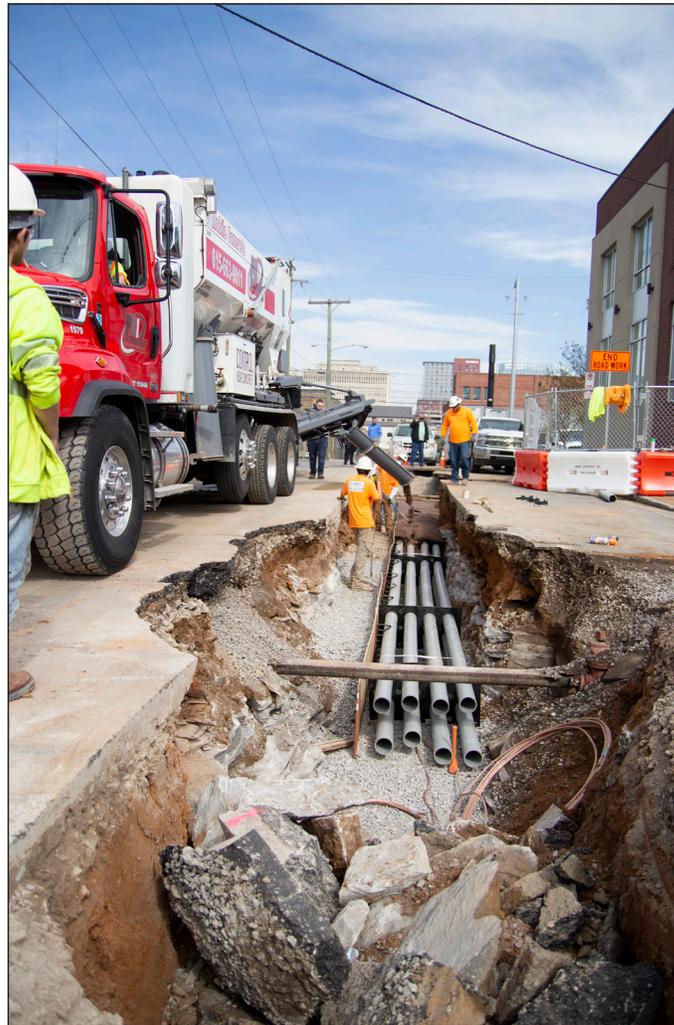
Curbs & Gutters

Attention to detail and precise application is expected regarding curb and gutter installations and/or repairs. Then, most projects follow an unforgiving timeline and any excess time means less revenue at the end.

If the slump changes halfway through the project, work stops only long enough to adjust the design mix on the unit. What formerly took more than one day is complete in several hours.

Gunite & Shotcrete

A mobile concrete mixer can seamlessly switch between wet and dry processes with precise material measurements along the way. Because this type of work frequently requires adapting the slump of the mix throughout the pour. A simple adjustment of the water flow allows for



fresh concrete.

Municipalities

The sooner roadways and sidewalks reopen, the happier motorists and residents tend to be. Except, a range of challenges and issues can stand in the way of any installation or repair being completed on time. A volumetric mixer enables the work to be accurate,

efficient and completed on schedule as you are pouring fresh concrete as needed rather than waiting for ready mix.

Plus, concrete produced with a mobile mixer consistently has higher break points than traditional concrete, meaning motorists and residents can enjoy a long-lasting surface.

Road & Bridge Repair

No matter the daily traffic volume flowing over a bridge or road, when repairs are needed, you want them to be the highest quality without giving up too much time. Volumetric mixers give you control over finite concrete details, such as moisture content, that have a macro effect if improperly handled. Because all aggregates are mixed on-site, the stress of a hot load or having to schedule work in the middle of the night is eliminated.

Utility Work

With the weight of the world above, ensuring any utility work will be durable is key.

The breaks in concrete fabricated with a volumetric mixer occur at a higher point on a regular basis which means the durability begins as soon as the concrete cures. Pre-installed design mixes let you account for changing conditions on the fly rather than stopping work, adjusting, then returning to work.



What Is A Mobile Concrete Mixer?

A mobile concrete mixer, or mobile concrete dispenser as it is sometimes also called, is an on-demand concrete production solution. A mobile concrete mixer is a batch plant mounted on a chassis—usually a truck or trailer—and carries unmixed material (sand, cement, coarse aggregates, water and any other materials or chemicals needed for more specialty applications) to a job site and mixed on a continuous or intermittent basis as required for fresh maximum strength concrete.

Any amount of concrete can be

produced from a yard to 400 yards or greater per day for continuous pouring as long as the unit is re-loaded with materials at the job site. Volumetric proportioning is based on volume not weight so through an easy calibration process, it is possible to produce concrete that will consistently meet or exceed the tolerances set in ASTM C685 and AASHTO M-241 standards as well as DOT requirements. You will have the exact amount needed every time.

The blending of materials is a continuous process, mixing the

aggregates, sand, cement, water and admixtures for the exact mixture every time. The operator can stop the mixing and delivery, and start again at any time, allowing production to balance the demands of the finishing and placing crews.

Mix designs can be changed or altered without moving the machine; the operator can make adjustments at any time as required for the job site. When the job is finished, cleanup is an easy process by only washing out the mixer at the rear of the machine.

Mobile Mixers Have Separate Material Compartments

Mobile mixers carry materials such as sand, cement, and coarse aggregates in divided bins mounted on the unit; all the bins are loaded from the top. Water is also carried on the mixer in tanks; the size of the tank may vary based on the model. Sand and stone are carried in a side-by-side divided, open bin with the sand holding 45 percent of the bin's volume and stone side holding 55 percent.

Aggregates can be carried separately or mixed as needed according to the design

mix; the versatility of mobile mixers allows for virtually unlimited concrete mixes. Cement is carried in a watertight bin with automatic vibrators to assure accurate cement proportioning and constant cement flow to the mixer. Water is pumped into the mixer with flowmeters accurately monitoring the flow.

For other concrete output requirements or specialty jobs, liquid admixtures such as accelerators, retarders, air entraining agents and modified latex can be carried in a separate system which introduces



Sand and stone bins carry the material ready to be mixed on site.

the ingredient as needed via precise flow controls.



What Kind Of Proportioning System Do Mobile Concrete Mixers Use?

Measuring, or proportioning, by volume – not weight – is at the heart of the volumetric mobile mixer and the final product is capable of accuracies better than plus or minus one percent.

Materials are stored in separate bins and based on the mix design are proportioned into the mix. This enables the operator to mix on-site exactly

what is needed, eliminating overages and shortages. Proportioning gives the operator control over the mix design and how much is mixed.

Mixing

A differentiation of mobile concrete mixers is that materials are mixed on site so the mix is fresh and has not begun the hydration process of concrete

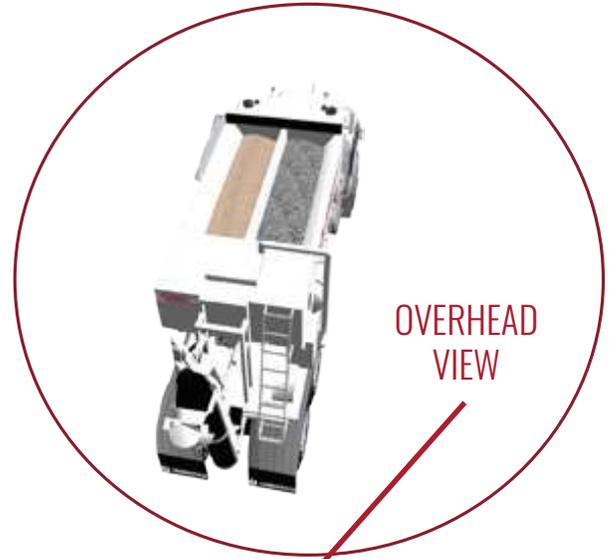
thus starting the clock before it goes bad. Materials are thoroughly mixed through the volumetric process to produce quality concrete in the exact amount needed.

Concrete produced by mobile concrete mixers meets standards established by ASTM 685 and AASHTO M-241 standards as well as DOT requirements.

What Are The Benefits Of Using Mobile Concrete Mixers?

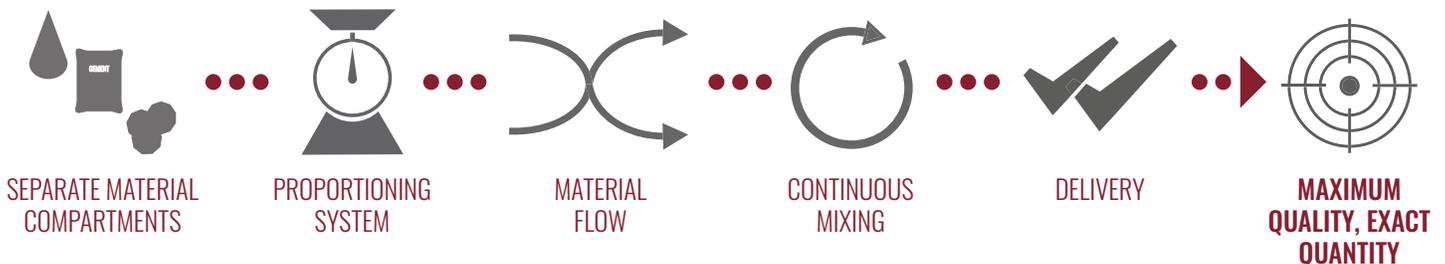
Benefits For Your Business

- Increase profits by paying less for materials and have better control over your schedule and employee time.
- Expand the type of concrete applications you can offer as part of your business or do multiple jobs without having to wait for ready mix.



Benefits For Your Customer

- Eliminate complaints about shortages and overages by mixing fresh concrete on-site in the amount required.
- Handle short loads, emergencies or weekend jobs with a mixer that is flexible and can be used for any size job on short notice.



Learn To Operate A Volumetric Concrete Mixer

Operating a volumetric mixer is not hard once you learn the basics and there are several ways to get up to speed.

- You can have on-site training.
- You can watch a training video.
- You can attend a training class to learn how to operate the mixer.

All these are great tools to help an operator learn the system. Let's break it down in more detail.

On-Site Training

A factory service technician will come to your location and train you in the proper way to do a calibration, maintenance, and operation. With hands-on training, you will start learning the basics and your service technician will also show you how to wash out the mixer which is a critical area of daily operations. The more time you run the unit, the easier it becomes and more natural it feels.

Video Training

Watching videos of calibration, maintenance and operations will demonstrate the steps to run a unit. You will need to do a hands-on operation to get the feel of the unit and how it works. Videos can also be a great way to go back and review steps if you have questions after a service technician has left or bring another operator on board.

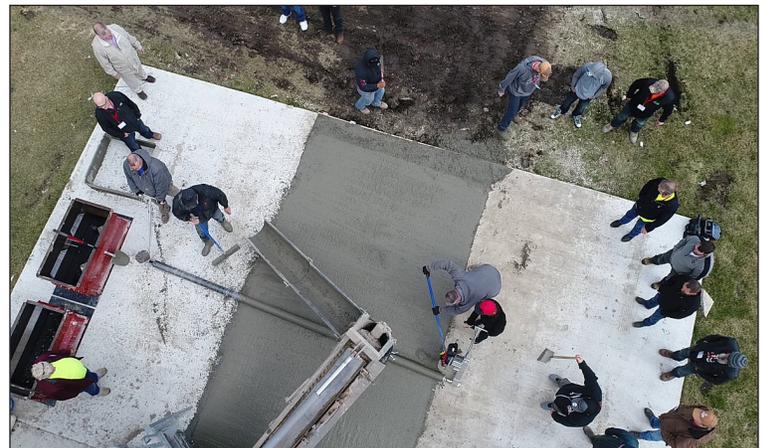
Training Class

Our factory offers a spring and fall class on operation,



calibration, and maintenance; with these classes, you will learn the steps to run your unit. You can get some hands-on experience with a unit and these classes are good to use with on-site training for "Operator Training Certification."

On-site training is the really best tool you can use to get up to speed the fastest because the service technician will work with you one-on-one. They will watch to make sure you understand the equipment and its capability to do the job. Running the unit is really the best teacher. Go out and do some pours. Get that experience and every day you will get better at what it takes to operate the mixer and to provide the best quality of concrete.



There are other resources you should consider when learning how to operate a volumetric mixer. All these training tools will make you a great operator and enable you to deliver the best concrete!

Attend an ACI (American Concrete Institute) Field Technician Grade 1 class. You will learn how to test concrete, understand slump, the importance of controlling the water-cement ratio, and the proper way to take cylinders and how to handle them. Using a concrete testing lab is another way to get proper cylinders and test data. This class will help you better understand what concrete

is and what high-quality concrete looks like. Check out what ACI offers for guides.

Use the VMMB (Volumetric Mixer Manufacturers Bureau) for basic resources.

Click here to view VMMB white papers. Look for the VMMB registration plate on your volumetric mixer, only volumetric mixers that are built to meet these VMMB Standards, and pass all of the required tests, are

eligible to receive and display the VMMB registered rating plate. Each of these is numbered, and cannot be transferred to another unit. This plate is a guarantee that the unit will meet all of the requirements for capacity, accuracy, and consistency that have been established for the industry at the time of manufacture.

Understand ASTM C-685. This is the specification for

Concrete Made by Volumetric Batching and Continuous Mixing.

Get the PCA (Portland Cement Association) Design & Control of Concrete Mixtures handbook.

This handbook goes through all the fundamentals of concrete, aggregates, cement, admixtures, testing, weather cold and hot, curing methods, and special types of concrete.

Cemen Tech offers Spring and Fall training courses annually at our headquarters in Indianola, IA.



Classes are led by the Cemen Tech service team and include classroom work, plant tour, and hands-on training.

How Much Does A Mobile Concrete Mixer Cost?

Two of the first questions customers ask before purchasing a new piece of equipment are how much does it cost and how to measure the return on investment. Customers need to consider a few factors that can affect not only the purchase price of your Cemen Tech mixer but also your overall satisfaction with the equipment and how it performs:

- In what applications will you use the mixer?
- Will a truck or trailer-mounted unit work best?
- What volume of concrete will be poured monthly, annually?

- What mix design(s) will you need to produce?
- How quickly do you need to produce your concrete?
- For truck-mounted mixer, what brand of chassis do you prefer?

These factors affect the price of your mixer. Before a manufacturer quotes you a price, they need to understand your specific needs. Many times customers believe Cemen Tech equipment is priced higher than the competition until they discover



Buy for what your needs are, not by price.

the mixer they have been quoted at a lesser price will not meet their needs.

Initial Purchase Price Comparison

To get the right equipment in your hands, the equipment manufacturer or dealer needs to understand how you will use the mixer. Mobile mixers come in various sizes, generally 2 cubic yard to 12 cubic yard capacities, and speeds, generally 15 cubic yards to 90 cubic yards an hour.

The capacity, speed and how the mixer is equipped determines the cost of the mixer. A smaller, slower mixer will cost less than a large, quick mixer.

Technology has come a long way in mobile mixers, and most manufacturers offer cordless remotes, electronic ticket printers, fiber feeders or choppers, and roll and pour options to help place concrete and provide your customers a record of their purchase, including the mix design. Some mixers are even equipped with technology such as touchscreen PLCs, which:

- Store an unlimited number of mix designs;
- Alert when maintenance tasks are required;
- Report the amount of concrete poured and the time of the pour; and
- Offer auto washout functions and an auto stow feature.



While these mixers are new to the market, the level of automation they feature is quickly growing in popularity. So what does a mobile mixer cost? A broad range is \$65,000 to \$135,000, depending on options, but you also need to consider your return on investment and factors such as parts availability, how long the company has been in business and their industry reputation.

Measure Your Return On Investment

Before you purchase any equipment, you need to consider how long it will take to see a return on your investment. Do you spend less upfront and risk facing issues such as breakdowns, tracking down hard-to-find or expensive parts, or purchasing a non-operator machine? Or do you spend more to purchase a machine that fits your needs and will earn you more profit in the long run? Look at what you spend on concrete and how much that costs your operation.

Waste, waste and more waste. Many in the concrete industry think waste is a normal part of the job, but it doesn't have to be. Wasted concrete means



A Cemen Tech Concrete Solutions Specialist can help you determine an ROI.

lost money for any operation, whether you're a concrete delivery business, a contractor or a municipality. You will mix the exact amount of concrete needed — no more, no less — to spend the exact amount of money necessary.

When employees stand around waiting for concrete, your business loses profits. With mobile mixers, you pour fresh concrete at the job site when it's needed. These mobile mixers are mobile batch plants that produce maximum strength concrete for

a variety of applications.

Volumetric technology allows you to track exactly when the mixer was operated, how much concrete was poured and what the mix was to determine how much you pay for concrete. Adding a GPS option allows you to track the mixer's location and mixer run time, giving you the ability to determine productivity and cost.

Startup time and maintenance are other factors to consider when determining the return on investment. If you purchase equipment that is difficult to start, maintain and service, your operation could lose money.

Are Volumetric Mixers Mobile Batch Plants?

Volumetric mixers are mobile concrete plants — flexible, versatile and ready to go whenever needed on a job site. Quickly and easily set up concrete production on job site and start pouring within an hour. No waste, no wait, and the exact design mix every time.

Easy Set Up

Drive to the location and you are ready to go!

Change Mix Design On Site As Needed

No need to wait or waste material.



No Mobilization

Replace your "transportable batch plant" and start

pouring within an hour.

Move The Batch Plant Around On Site

Take the batch plant directly to the pour area.

Fast Clean Out

Auto-wash out in minutes.

No Space Limitations

Use on any size job, even remote or hard to reach sites.

Economical Solution

No wasted materials or employee downtime — saves you money on every pour.

Size Of Job Does Not Matter

Produce 20, 100, or 400 yards a day with the same mixer.

Easy To Operate

The driver and mixer operator can be the same person.

No Foundation Or Frame Of Infrastructure Set Up Required

Move whenever needed.

Quickly Fill Drum Trucks

Fill your barrel trucks fast and efficiently with fresh concrete on a job site.



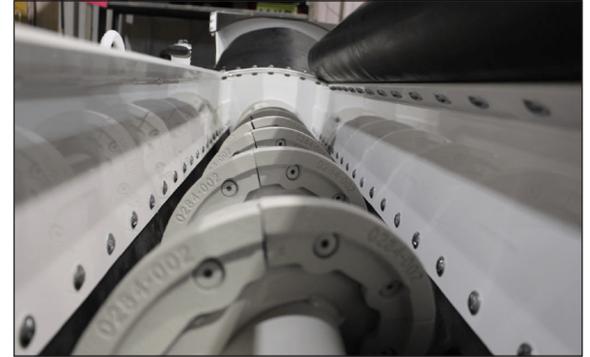
First Year Maintenance For The Mixer

Various things can affect the wear and life of wear parts during your first year of maintenance on your mobile mixer. Materials, the slump of concrete, and the total amount of material put through the unit affect the wear parts and how often you need to change them.

The first year schedule is one that the operator should watch with the daily and monthly inspections. You will start to get a feel on how soon you will need to schedule maintenance and if that includes any downtime.

Daily Inspection

The operator should be inspecting and noting items that are showing wear or that need to be replaced as they are doing clean up on the unit. Inspect the wear blades, belt wiper, mixer motor for leaks, lower and upper mixer bearings, and for concrete build up.



Monthly Inspection

The monthly inspection needs to be more detailed. Besides the mixer daily inspection, the operator needs to have the unit empty and inspect the rest of the unit.

clean if needed.

With these inspections, you will start to see a wear pattern and can determine a maintenance schedule. Depending on the materials and series of unit, you can figure that the mixer will be the first component that will require repairs.



Top: Check to see how quickly a manufacturer can get you parts.

Above: Regular maintenance decreases unit downtime.

Inspect the conveyor belt and tension, check side and center guide material and the gap between guide and belt, and adjust if needed, along with the conveyor belt wiper. It must be tight on the belting so it will clean the belt and stop material from slipping. They need to flush the admix system with water and clean out the tanks. Inspect the water tank for any algae growth and

Normally you should expect 3,000 yards to 5,000 yards through a unit before you need to replace wear blades. You may need to replace the lower boot, and bearings. Again with the daily and monthly inspections you will be able to evaluate the components and make sure you have

all parts needed.

For the conveyor belt, with proper maintenance and care through the life of the assembly, you can expect to get 20,000 yards to 25,000 yards of life. It's recommended to rotate the conveyor belt annually.

maintenance and life of the parts all depends on the work done up front through the year. Inspect regularly and you can plan maintenance around your schedule.

Remember that all



10 Reasons To Add Volumetric Mixers To A Concrete Delivery Business

Adding volumetric mixers to your concrete delivery business delivers several benefits to your operations.

1. Say Goodbye To Hot Loads

If the finishing crew hasn't arrived, or more forming needs to be done, don't panic. Mobile mixers produce fresh concrete on site when you need it, so you never waste a batch.

2. Deliver The Exact Amount

Customers receive exactly what they ordered.

3. Eliminate Short-Load Fees

Because mobile mixers are versatile, they can be used for a variety of applications: set up a mobile batch plant for large jobs, pour a quarter

yard for a fence post at one job, and then travel to another job to pour three yards for a sidewalk repair.

4. Stop Waiting On Drum Trucks

When workers consistently have to wait around for ready mix trucks to arrive, lost profits quickly add up.

5. Easily Change Mix Designs

Mobile mixers are more versatile than ever. They can mix and pour one batch of concrete and easily switch mix designs to support any client need.

6. Clean Up Is Easy

Have you heard of someone chipping out cured concrete in a barrel truck? Add a mobile mixer to your fleet

to avoid that nightmare with quick clean up.

7. Weekend Deliveries

Using drum trucks ties you to the plant's schedule. But owning a mobile mixer lets you create your own schedule, with no batch plant operator needed, allowing you to schedule weekend deliveries without hassle.

8. Deliver Concrete To Rural & Remote Areas

Once water hits the cement powder, a chemical reaction starts and the small window in which the concrete can be used. This causes limitations if drum trucks need to travel long distances to job sites. Mobile mixers allow you to provide quality concrete to

clients in rural and remote areas.

9. Go Green

Barrel trucks must constantly run to keep the drum running and the concrete moving. With mobile mixers, you simply shut off the truck until concrete is needed. They also require less water during cleanup, as you only wash out the mixing auger assembly rather than the whole barrel of a drum truck.

10. Mix Specialty Concrete

Specialty concrete and technologies such as latex-modified concrete, fast-setting cements, and other specialty concrete demand mobile mixers for best placement and quality.

5 Myths About Volumetric Concrete Mixers

1. Volumetric Mixers Use New & Unproven Technology.

The patent for concrete mobile mixers was granted more than a half century ago in 1965. By 1980, more than 2,500 units had been produced and the number surpassed 10,000 by 2000. Volumetric mixers can be found in use throughout the United States in every state, along with more than 60 countries around the world.

2. Volumetric Mixers Cannot Match The Accuracy & Consistency Of A Batch Plant.

False. Concrete mobile mixers are designed and calibrated to meet ASTM C685; ACI 304.6R;

and AASHTO M241 specifications. All materials have the same tolerances while there are more restrictions placed on ready mix since water-cement contact occurs at the plant and not at the job site as is the case with volumetric mixers.

3. Volumetric Mixers Cannot Produce A Good Or High-Quality Concrete.

Different mix designs of concrete need a design-specific amount of time to adequately mix. Volumetric mixers produce a wide range of designs, many of which are used in many everyday projects, such as:

- Airport runways including repairs;

- Bridge deck overlays;
 - Soil retention;
 - Structural elements; and
 - Swimming pools.
- These units are also capable of creating specialized types of concrete, such as lightweight concrete with foam.

4. Volumetric Mixers Are Undersized For Large Pours And/Or Projects.

The edge that helps volumetric mixers stand out from traditional barrel mixers is the ability to be reloaded at a job site without wasted fuel and production time. Projects finish on, if not ahead of schedule, plus, the production rates of volumetric equipment can

exceed 90 cubic yards per hour. The most common model of volumetric mixers available today produces one cubic yard each minute.

5. There Is A Huge Learning Curve & Complex Operation With Volumetric Concrete Mixers.

Not quite. While it's crucial each operator receive proper training — which is necessary with all equipment used at a job site — a volumetric mixer operator will have more training than an operator for a barrel mixer. However, extensive and on-going training is available for calibration, maintenance, and operation of your equipment.



Volumetric concrete mixers can do standard concrete, latex modified, flowable fill, color, fast setting, and more.



Volumetric mixers meet DOT specifications and are widely used around the U.S.

Why Volumetric Mixers Are Perfect For DOT Projects

Millions of motorists and pedestrians depend on highways, streets, and all size and type of roadways every day. Any time these thoroughfares are inaccessible, whether due to a small repair or full-scale replacement, headaches and hassles generally ensue as DOT crews scramble to complete the concrete work on time and on budget.

Speed & Safety Are Tied Together

One way crews have worked around this issue is with fast setting concrete, especially during overnight projects. At night is a popular timeslot for work as there is generally less traffic passing by or through



A roadway, such as a bridge deck, can be reopened in a few hours when using fast-setting concrete and a volumetric mixer.

the work area, creating a safer environment for everyone involved.

Yet, timely repairs can be hard to come by for DOT crews, especially when short

loads and access to concrete come into play. These factors exacerbate contingent timelines, all of which focus on safety to motorists, pedestrian, and workers.

So how can volumetric concrete mixers eliminate many common challenges to regular DOT projects?

Multiple Design Mixes For One DOT Project

Let's start with design mixes. A traditional barrel mixer is limited to providing one pre-specified mix at a time. But a volumetric mixer can produce however many mixes that are necessary to complete the work with one unit. There are not any schedules to align or juggle, but only the ability to pour from your own mobile batch plant.

An example is work done on bridge decks. Many, especially in climates with

snow and ice during the winter months, rely on latex modified concrete to hinder the freeze-thaw cycle. A volumetric mixer can produce the latex blend and regular concrete, saving time and money for separate units and scheduling.

Save On Equipment Without Sacrificing End Results

One mobile concrete mixer can handle any type of cement powder, including fast setting which is commonly used in road projects. This does away with the longstanding need to bring in a different barrel truck specifically to pour a fast setting variety and a different truck for a mix

using a standard cement powder. Also, you have control over every ounce of concrete thanks to a precise proportioning system.

Fast & Efficient Repairs

It's rare for an entire roadway to need replacement. Instead, it's the smaller repairs that snarl traffic, even for a few hours. Since volumetric mixers easily work with fast setting concrete powders, such as Rapid Set and FasTrac, your crew begins and finishes these repairs in significantly less time. Less traffic impediment means less safety risk to workers and less headache for motorists and pedestrians.



Indiana DOT employees discuss the bridge deck repairs performed with a Cemen Tech volumetric mixer.



From highway repairs (top) to bridge deck overlays, volumetric mixers can do it all.

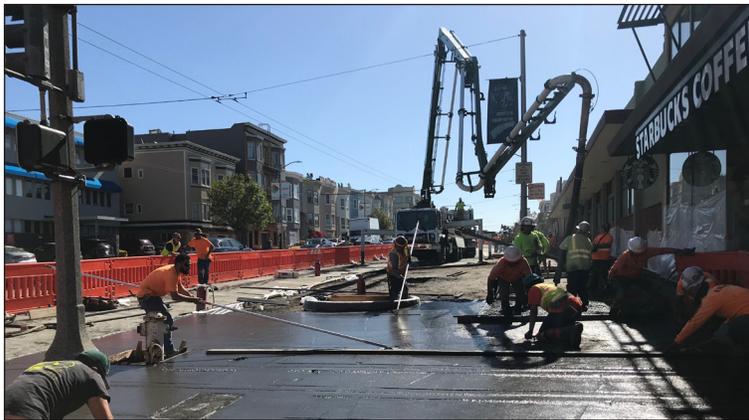
Can Volumetric Mixers Work With A Concrete Pump?

Yes! The fresh concrete mix pours into the hopper of the concrete pump the same as it would from a traditional barrel mixer. Because pumps are frequently used in building construction and precast applications, being able to change slump and other crucial details with minimal work stoppages is key.

Bauman Landscaping & Construction primarily handles public works projects for the City of San Francisco

using a fleet of Cemen Tech volumetric mixers. But the company also produces building concrete with its 32-meter concrete pump.

“We use the volumetric mixer to put into the pump. It’s really compatible with concrete pumps and the mix comes out well,” Mike Bauman, owner and president, said. “We can get into tight access spots with our volumetric mixer with a pump.”





Time is of the essence in many situations, but more so when pouring the foundations for homes in the outskirts of a major city like Atlanta, Georgia. That's one reason Summit Site-Mix owner Wes Holman made the decision to invest in several C60 volumetric mixers. An offshoot on the investment? Improved quality of concrete, reduced downtime for employees, and further integration with their sister company, Paramount Foundations.



Volumetric mixers allow you to pour exactly what you need, anywhere, anytime.

Most Common Questions From New Volumetric Users

How Do You Set The Gates For A Mix?

Gates are adjusted to the proper indicator marks based on previous calibration. Reference the O&M manual for calibration instructions. With proper gate settings per the mix design requirements, correct and accurate concrete and flowable fill will be produced. You can be assured of accuracy and replication.

When Should Wear Blades On The Mixing Auger Be Replaced?

Make sure the blade does not wear pass the bolt hole that holds the blade to the flighting and mounts. If the blades are worn to within 1/8-inch of

the countersunk hole on the face of the wear blade, then they need to be replaced. Be sure to watch the first half of the auger, as it will have the most wear. The discharge blades may last twice as long as the first half because once the material is mixed together, it is less abrasive and wears less on the blades.

When replacing the blades, over tightening the bolts can cause them to crack. Make sure you use the spacer washers between the blade and flighting.

What Mix Angle Should The Mixer Run?

The mix angle directly affects the quality of the concrete. Mixers need to run at

a good mix angle for retention, with an ideal angle of 25 degrees to 30 degrees and no less than 15 degrees. The higher the angle, the longer the retention of the concrete and the better the mix. If you could see the concrete, it would be rolling back and moving in a Figure 8 pattern through the homogenizing auger mixer. If the mix continually backs up in the mixing auger, lower the angle. Longer retention in the mixer will help admixtures have time to react, will help stop any false/flash in the concrete and will help with reducing bleed water.

If you have more questions, check out our frequently asked questions web page. Do not hesitate to contact us if you need our assistance.