

RAW MATERIALS

- Unsaturated orthophthalic polyester resins
- Unsaturated isophthalic polyester resins with UV stabilisation for gelcoat
- Chopped fiberglass (Mat) used to give all the physical characteristics to the laminate ensuring a perfect smooth surface on the outer side
- Cross-woven fibreglass (woven roving) used to improve the mechanical properties of the laminate

TECHNICAL SPECIFICATIONS

The type of external and internal finish, thickness, physical-mechanical properties, reaction to fire, resistance to chemical agents, etc. are described in detail in the trade catalogues (CTL 135) and product technical information sheets.

TOLERANCES

Tolerances are detailed in the trade catalogues and product technical information sheets.

Standard dimensional tolerances

		ROLLS	PANELS
Width (mm):	up to 1500		2 (es. 0,+2)
	> 1500		4 (es. 0,+4)
Length (mm):		±1%	Up to 2000: 4 (es. 0,+4)
			2001 ÷ 4000: 6 (es. 0,+6)
			4001 ÷ 8000: 8 (es. 0,+8)
			8001 ÷ 12000: 10 (es. 0,+10)
			>12000: to be agreed
Squareness (mm)		//	<i>Max. difference between diagonals</i>
			Up to 3000: 5
			3001 ÷ 5000: 10
*Average thickness (mm):	up to 2	±0,2	//
	> 2	±10%	//

* average thickness of the roll determined by min. 6 measurements taken in both longitudinal sides at a distance of 10 m. The first and the last measurements shall be at a distance of 5 m from roll edges (internal method).

PRODUCTION PROCESS

The work instructions and related setting plans are applied.

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6	02/06/2020	Updated paragraphs "Quality controls" and "Complaints and returns"	RQSA	DC	DG
Rev.	Date	Description	Drafted by:	Checked by:	Approved by:

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Brianza Plastica S.p.A.

Company with **UNI EN ISO 9001:20015 certified Quality Management System (certif. N° 106 SQP-IIP)**

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<http://www.brianzaplastica.it> • e-mail: info@brianzaplastica.it

Stock Capital € 3,000,000 fully paid • Company Register of Milan n° 00865040158

Econ. Admin. Index (REA) Milan n° 602163 • Tax Code: 00865040158 • VAT n° IT00698250966

TESTS, CHECKS AND INSPECTIONS

The raw materials used, semi-finished and finished products are subjected to the inspections required by the “Inspection plan.”

DETECTION AND IDENTIFICATION OF “IMPERFECTIONS”

The laminates are subjected to final visual inspection to ensure a high standard quality. To help the Customer, the “imperfections” discovered are reported directly on the roll using a red label affixed near the imperfection on both sides and recorded on the inspection sheet (type of imperfection, position).

Furthermore, to help the Customer at the time of receipt of the goods, a **blue tape** is applied around the circumference of the external packaging. On identification label is also recorded the positioning of imperfections.



Below list of non-exhaustive imperfections detectable (PUNCTIFORM IMPERFECTIONS area ≥ 10 mm² or CONTINUOS IMPERFECTION < 10 m):

- Air bubbles
- Cracks/cracking
- Spots
- Folds in the protection film
- Streaks/blooms/scratches
- Etc.

For each roll max nr 3 punctiform imperfections are allowed (if the imperfections are on the ends of roll they will be cut out. Only real length will be invoiced). The roll is invoiced net of imperfections (1 linear meter for imperfection).

In case of min nr 4 punctiform imperfections or min nr 1 continuous imperfection (≥ 10 linear meters) the roll will be downgraded (a **red tape** is applied around the circumference of the external packaging).

PACKING

	ROLLS	PANELS
Primary packing	PE bubble film Cardboard crowns on roll ends	Cardboard sheet to cover the pallet
Secondary packing	PE stretch film	Not provided
		

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LABELLING

	ROLLS	SHEETS
Identification label	 <p>ELYCOLD batch ID B000012486-001 06/05/2019 R2-BN68A13</p> <p>Cliente Customer Brianza Plastica S.p.A.</p> <p>Cod. Art. BP Product code FFLS1S03003B11 Ordine Cliente Customer order N.4500311971 Conferma d'ordine Order confirmation V1900003452</p> <p>Larghezza (m) Width 2,26 Lunghezza (m) Length 60 Qtà Qty 1</p> <p>Colore Colour White FIAT 249 Rinforzo vetroso Glass reinforcement CSM 300 / Wr300</p> <p>Finitura esterna Top surface finish Glossy (Film prot.) Finitura interna Back surface finish Dense Film Grooved</p> <p>Imperfezioni (posizione) Imperfections (positioning) 0 10 20 30 40 50 60</p> <p>Cod. Art. Cliente Customer product code</p> <p>Created by Universal Document Converter</p>	
	<p>ID label with "customer name, product description, manufacturing date and barcode batch number" to ensure traceability</p>	
	ID label on each roll 100%	ID label on each packaging unit - pallet)
<p>Rolls with "imperfections" ⇒ blue tape is applied around the circumference of the external packaging near ID label. On identification label (graduated scale) is also recorded the positioning of imperfections.</p>		

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PALLETISING/STOWAGE

R O L L S	<p>Palletised horizontally on disposable wooden pallets + polystyrene cradles + wooden slats + crosswise straps</p>  <p>Maximum package weight: 2,500 kg</p>	<p>Palletised horizontally on steel cradle (to be made) + crosswise straps</p>  <p>Maximum package weight: 2,500 kg</p>
	<p>Bulk rolls in horizontal on polystyrene cradles (1st layer) for container transport</p>  	
P A N E L S	<p>Palletised on disposable wooden pallets <u>made to measure to contain the panels completely</u> with loading surface consisting of a flat bed + crosswise straps Cradle pallets for panel width >2.40 m</p>  <p>Maximum package weight: 2,500 kg</p>	

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TRACEABILITY

The raw materials used and the finished products are identified by means of labels, cards, etc., and can be traced through the incoming and outgoing identification and registration documents.

STORAGE CUSTOMER

The product must be stored inside (preferably indoor) on flat and dry floor, away from heat source, protected from the weather, from the moisture and from direct exposure to sunlight to avoid discoloration and lead to poor adhesive bonding.

To preserve the surface and to avoid difficulties in detaching the protective film, is necessary:

- store the laminates at temperature between -10 °C and 65 °C
- remove protective foil at temperature between 5 °C and 30 °C

It is preferable to store rolls vertically (falling materials hazard if precautions are not taken). If rolls are stored horizontally is to avoid the overlap.

Following the first-in-first-out (FIFO) method of stock rotation, it is preferable to use products within 6 months of manufacturing date

Especially, during cold season, it is preferable to put the product near working area (however at room temperature) 24 hours before using.

For more details, refer to the "Elycold and Elyplan laminates storage manual".

QUALITY CONTROLS

Before use, the Buyer shall subject the products to thorough testing* following its own testing plan to identify any defects that may make the batch unsuitable for its intended use. **A suitability check must ALWAYS be carried out on the first piece produced using the material purchased by BP so that, in the event of an aesthetic defect concealed by a protective film, its use can be immediately stopped.** For example, significant surface, aesthetic, dimensional and colour anomalies in the batch are considered as defects.

**Checking must be carried out on a suitable sample size which is representative of each supply batch (the batch number is on the packaging identification label)*

COMPLAINTS AND RETURNS

Any complaint / return is managed in accordance with points 7 and 8 of the "General Conditions of Sale" of Brianza Plastica Spa, a document downloadable from the website www.brianzaplastica.it

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