Test report no.:	**105409/13-II**
Customer:	EGE-Profil Tic. ve San. A.S. Atatürk Organize Sanayi Bölgesi 10003 Sokak No.: 5 35510 CIGLI-IZMIR TURKEY
Production site:	35510 CIGLI-IZMIR TURKEY
Test:	Testing and classification of a window profile made of PVC-U according to DIN EN 12608: 2003-09 (profile specific characteristics)
System:	Zendow Plus
Profile designation:	Sash 12630
Designation of formulation:	**Ege 10 compound**
Base of stabilization:	CaZn
Producer of formulation:	EGE-Profil, 35510 CIGLI-IZMIR, TURKEY
Sample receipt:	2013-03-18 (profiles) and 2013-05-17 (drawings)
Test period:	2013-04-08 to 2013-06-14
Result:	The requirements are <u>not</u> met regarding item 4.2 (Dimensions) and item 4.7 (Weldability).
Classification:	**EN 12608 -** climate zone**-II-**wall thickness

This test report comprises 5 pages.

Würzburg, 2013-06-20
Rs/km

International akkreditiert SKZ - TeConA GmbH

i. V.
Dr. Anton Zahn

i. A.
Wolfgang Ries

SKZ – TeConA GmbH
Testing, Quality Assurance, Certification
Friedrich-Bergius-Ring 22
97076 Würzburg

Geschäftsführer
Dr.-Ing. Gerald Aengenheyster
HRB 7840
Amtsgericht Würzburg

Tel. +49 931 4104-0
Fax +49 931 4104-477
tecona@skz.de
www.skz.de

1. Order

The company EGE-Profil Tic. ve San. A.S., Atatürk Organize Sanayi Bölgesi, 10003 Sokak No.: 5, 35510 CIGLI-IZMIR, TURKEY, ordered the following test to be carried out at SKZ - TeConA GmbH: Testing and classification of a window profile made of PVC-U according to DIN EN 12608: 2003-09 (profile specific characteristics).

2. Test material

On 18 March 2013 SKZ - TeConA GmbH received following samples for testing:

8 x 1 m window profile made of PVC-U and 3 welded corners

Profile designation:	Sash 12630
Profile marking:	---

3. Test procedure

The following tests were carried out according to DIN EN 12608, window profiles made of PVC-U "Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors - Classification, requirements and test methods", edition 2003-09.

Unless indicated otherwise, pre-testing storage and the test itself were carried out at standard conditioning atmosphere 23/50, class 1 according to DIN EN ISO 291: 2008-08.

Usually we carry out tests according to standards for which we have an accreditation. The list of all standards for which we are accredited is shown on the homepage at www.skz.de.

3.1 Appearance

The profile sections sent were subjected to visual inspection. The surface shall be smooth, flat and free from pitting, impurities, cavities and other surface defects. The edges of the profiles shall be clean and burr-free.

3.2 Dimensions

The dimensional test and the test in respect of deviation from straightness were carried out according to item 6.2, test methods.

For the dimensional test of the profile sections, the requirements according to item 5.3 and additional features from the profile drawing were taken into consideration.

3.3 Mass of main profiles

The determination of the mass of the profile sections was carried out according to item 6.3, test methods.

3.4 Dimensional change after heat ageing

The test was carried out according to EN 479 on 3 samples.

3.5 Resistance to impact of main profiles by falling mass

The test was carried out according to EN 477 on 10 samples.

The samples, stored at -10 °C, were tested according to classification II (falling mass 1000 g, falling height 1500 mm).

3.6 Behaviour after heating at 150 °C

The test was carried out according to EN 478 on 3 samples.

3.7 Weldability

The weldability test was carried out according to EN 514, compression bending test. The breaking stress was determined in N/ mm².

4. Results

4.1 Appearance and delivery condition

The profiles were smooth, the edges were clean and burr-free. There weren't any non-conformities.

4.2 External dimensions and functional dimensions as well as wall thickness class A and deviation from straightness in mm:

Measuring point	Actual value [mm]	Set value [mm]	Deviation [mm]
1	**59.1**	60.0 ± 0.5	**-0.9**
2	60.1	60.0 ± 0.5	0.1
3	70.0	70.0 ± 0.3	0
Wall thickness	3.0	≥ 2.8	0.2
Wall thickness	2.8	≥ 2.5	0.3
Wall thickness	2.6	≥ 2.5	0.1
Wall thickness	2.0	≥ 2.0	0

Deviation from straightness in mm/m — Actual value: 0.2 — Required value: ≤ 1

4.3 Mass per meter length in g/m — Actual value: 1530 — Required value: 1477

Deviation from required value in % — Actual value: 3.6 — Required value: ≥ -5

4.4 Dimensional change after heat ageing

	Dimensional change in % required value: ≤ 2.0						**Difference between sight surfaces**		
	Sight surface 1			**Sight surface 2**			**Required value: ≤ 0.4**		
Sample	1	2	3	1	2	3	1	2	3
actual value	1.1	1.2	1.2	1.2	1.2	1.2	0.1	0	0

4.5 Resistance to impact by falling mass (class II, falling height 1500 mm)

Breaking rate in % Actual value: 0 Required value: ≤ 10

4.6 Behaviour after heating: without any complaint

4.7 Weldability

medium tensile stress at break in N/mm² Actual value: 44.0 Required value: ≥ 35 N/mm²

lowest single value in N/mm² Actual value: **25.3** Required value: ≥ 30 N/mm²