



SPECIFICATIONS

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ACCEPTANCE OF SPECIFICATIONS

CLEARANCE

On behalf of : _____ Company

<i>NAME</i>	<i>TITLE</i>	<i>DATE</i>	<i>SIGNATURE</i>
_____	_____	_____	_____
_____	_____	_____	_____
_____	_____	_____	_____
_____	_____	_____	_____

On behalf of COVERPLA

<i>NAME</i>	<i>TITLE</i>	<i>DATE</i>	<i>SIGNATURE</i>
_____	_____	_____	_____
_____	_____	_____	_____
_____	_____	_____	_____
_____	_____	_____	_____

1. INTRODUCTION

These Specifications define commitments and practices in terms of quality regarding our products and/or services made and/or supplied by COVERPLA Company. They therefore constitute a general framework which allows both parties to agree on the quality level delivered to the client as well as on control methods implemented to achieve this quality level.

These Specifications therefore define the minimum quality acceptable by the client and constitute the standard reference applicable (in case there are no specific client specification) to all our productions and/or services.

2. SCOPE

These Specifications apply to all COVERPLA products and/or services namely:

- ✓ Glass bottles and jars (COVERPLA models or trading models),
- ✓ Plastic bottles and jars (COVERPLA models or trading models),
- ✓ Closing accessories (COVERPLA models or trading models),
- ✓ Silkscreen printing business activity, hot stamping, coating, acid etching, metallization and galvanization.
- ✓ Assembling and cutting of pumps,
- ✓ Closing accessories assembling.

3. TERMS AND CONDITIONS

3.1. Liability

COVERPLA Company is liable for any defects exceeding AQLs upon delivery to its client.

This liability does in no way relieve the client of his own liability when he releases his batches in order to put them on the market.

3.2. Agreement

These Specifications, which were signed by both parties, are considered as mutually agreed and represent our basis of work in terms of quality.

These Specifications can be possibly renegotiated on the initiative of either party. This renegotiation will have to be agreed again by both parties.

These Specifications may also be amended from time to time by COVERPLA Company. Any amendment shall result in an update of the document and this new version will then be submitted to the client for approval.

3.3. Audits

The two parties may agree to undertake audits:

- ✓ Audits carried out by the Quality Management System's client of COVERPLA Company ;
- ✓ COVERPLA may audit the client in case it should be necessary to get information about the conditions of use of the product(s).

4. STORAGE

The products are stored on pallets or shelves in cardboard boxes in clean and dry places.

Note : as for glass bottles, beyond a six-month storage period from their manufacturing date, the appearance of slight exudation which will expand in time is a likely and normal phenomenon which is linked with the composition of glass and is then not considered as a defect.

5. PACKAGING AND IDENTIFICATION OF PRODUCTS

5.1. Items Labelled « Trading »

The items which stem from the « Trading » business activity and which are not processed in our premises are subjected to the packaging and labelling conditions of our suppliers.

5.2. COVERPLA Stock-Managed Specific Items

All COVERPLA stock-managed specific items are packaged as follows:

- ✓ Glass bottles are packaged in show pack trays or arranged cardboard boxes (bracing),
- ✓ Plastic bottles are packed in cardboard boxes in bulk or arranged under PE cover,
- ✓ Accessories are packed in cardboard boxes in bulk or arranged under PE cover.

All COVERPLA stock-managed specific items are identified with a cardboard label mentioning:

- ✓ The item designation,
- ✓ The quantity per box,
- ✓ The manufacturing date.

5.3. Special Order Items

5.3.1. Labelling:

All special order items (specific colour of cover, decoration, assembling of pumps...) could be identified on customer's request with a cardboard label mentioning:

- ✓ The item designation,
- ✓ The quantity per box,
- ✓ The manufacturing date,
- ✓ The client's name,
- ✓ The order number (on customer's request),
- ✓ The client reference number (on the customer's request).

Moreover, for complete pallet orders, a pallet label mentioning the same details as the cardboard label could be affixed to the pallets.

5.3.2. Packing:

Trading items are re-packed with factory standard mode.

6. CHECKING PROCESS

6.1. Check upon Reception

The goods delivered to COVERPLA are submitted to check upon receipt through statistical sampling (based on the ISO 2859-1 standard) regarding the goods coming from suppliers who do not work according to quality assurance criteria ("QA").

However, tests and checks may be carried out with goods from suppliers who are submitted to QA in order to check whether these suppliers honour their commitments.

6.2. Check at the beginning of production

The start of our productions is submitted to a specific check in order to validate the implementation of production.

6.3. Check during production

Checks are continuously carried out during production. These checks are of an aesthetic and/or functional nature depending on the item's specifications.

6.4. Check before shipping

Upon customer's request, a statistical control before departure could be done according to financial modalities below:

Size of the lot to be checked	Taking	Prize in Euros
501 to 1 200	80	120,00 €
1 201 to 3 000	125	140,00 €
3 001 to 10 000	200	170,00 €
10 001 to 35 000	315	200,00 €
35 001 to 150 000	500	240,00 €
150 001 to 500 000	800	300,00 €
≥ 500 001	1 250	350,00 €

6.5. Quality Assurance

As regards Trading items and subcontracting activities, COVERPLA Company created a Quality Assurance system (QA) that enables us to ensure full compliance of our goods.

7. STATISTICAL CONTROL

7.1. Introduction

The controls of the products which are subjected to it are carried out:

- ✓ On the basis of a wide range of defects available in-house for COVERPLA specific items,
- ✓ On the basis of suppliers' reference systems for standard supply items.

Defects are assessed according to a method in use in our profession, i.e. according to their visual appearance and at arm's length during few seconds.

7.2. Sampling Plan and Procedure

The sampling plan used for statistical control aims to ensure the representativeness of the controlled lot.

A lot is a set of even references received by the customer in one step. The reception control by the customer must be done, by reference; on the entire delivery (a lot can't be split into several "part-lots" to check upon receipt.

The sampling taking procedure is randomly carried out at various points of the pack in a number of packages equal to the square root of the total number of packages included in the pack to be controlled (rounded up to the nearest unit).

The control is carried out according to the sampling of the ISO 2859-1 Standard.

The control plans used are:

- ✓ As a level II simple & normal procedure for most of products,
- ✓ As a level II reduced & simple procedure for some products enjoying a favourable history (i.e. products for which no complaints and/or problems have arisen in-house for some time),
- ✓ As a level S3 simple & normal procedure for technical controls.

7.3. Acceptable Quality Levels (AQLs)

The AQL (NQA - *Niveau de Qualité Acceptable* – in French) is defined for each defect class. The AQL represents the maximum percentage of defects which can be considered acceptable as an average characteristic of a controlled pack's quality.

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7.4. Quality levels for glass items

Two quality levels exist for our glass bottles: “Upgraded quality” and “Class-Mass quality”. The difference could be made by:

- ✓ the AQL for minor defects which could correspond to 4 for Upgraded quality and to 6.5 for Class-Mass quality,
- ✓ the aspect defects which are automatically considered as minor for Class-Mass quality whereas they could be considered as minor or major for Upgraded quality,
- ✓ the “OK Limit” from Upgraded quality might also be more restrictive than for the Class-Mass quality.

7.5. Defects and Associated AQLs

Critical Defect – AQL = 0.65

This defect is likely to result in accident risks for users, or to seriously disrupt the efficiency of the conditioning lines.

Major Defect – AQL = 1.5

Although non-critical, this defect may reduce the performance of the conditioning line but that does not mean that it can have notable effects on the use of the product by the user or that this defect interferes with the normal use of the item and harms the company’s brand image.

Minor Defect – AQL = 4 or 6.5

This defect does not interfere with the normal use of the product but spoils its presentation (appearance defects).

A list of these various defects and associate AQL is provided in Appendix 1 for glass bottles and jars, in Appendix 2 for plastic bottles and jars, in Appendix 3 for closing accessories and in Appendix 4 for silkscreen printing.

7.6. Acceptability and Refusal Criteria

Sampling plans and acceptability limits are defined in Tables 1 & 2 (taken from Tables of the ISO 2859-1 Standard).

Normal Control – Level II

Pack Size N	Sampling n	Critical Defect		Major Defect		Minor Defect			
		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R
501 to 1200	J 80	1	2	3	4	7	8	10	11
1201 to 3200	K 125	2	3	5	6	10	11	14	15
3201 to 10000	L 200	3	4	7	8	14	15	21	22
10001 to 35000	M 315	5	6	10	11	21	22	21	22
35001 to 150000	N 500	7	8	14	15	21	22	21	22
150001 to 500000	P 800	10	11	21	22	21	22	21	22
≥ à 500001	Q 1250	14	15	21	22	21	22	21	22

Table 1: Acceptability and Refusal Criteria with Normal Control – Level II

Reduced Control – Level II

Pack Size N	Sampling n	Critical Defect		Major Defect		Minor Defect			
		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R
501 to 1200	J 32	0	2	1	4	3	6	5	8
1201 to 3200	K 50	1	3	2	5	5	8	7	10
3201 to 10000	L 80	1	4	3	6	7	10	10	13
10001 to 35000	M 125	2	5	5	8	10	13	10	13
35001 to 150000	N 200	3	6	7	10	10	13	10	13
150001 to 500000	P 315	5	8	10	13	10	13	10	13
≥ à 500001	Q 500	7	10	10	13	10	13	10	13

Table 2: Acceptability and Refusal Criteria with Reduced Control – Level II

Normal Control – Level S3

Pack Size N	Sampling n	Critical Defect		Major Defect		Minor Defect			
		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R
501 to 1200	E 13	0	1	0	1	1	2	2	3
1201 to 3200	E 13	0	1	0	1	1	2	2	3
3201 to 10000	F 20	0	1	1	2	2	3	3	4
10001 to 35000	F 20	0	1	1	2	2	3	3	4
35001 to 150000	G 32	0	1	1	2	3	4	5	6
150001 to 500000	G 32	0	1	1	2	3	4	5	6
≥ à 500001	H 50	1	2	2	3	5	6	7	8

Table 3: Acceptability and Refusal Criteria with Normal Control – Level S3

8. ITEMS / SERVICES AND ASSOCIATED CONTROLS

It is best to first define two types of tests:

- ✓ Homologation tests are used to check the compatibility of the container/content. These tests are to be performed by the customer on the BAT samples with the final bulk.
- ✓ Conformity tests carried out by COVERPLA at reception or during production and by the customer upon receipt in order to judge the conformity of production lot (tests as described below). Only the so listed test results are opposable to COVERPLA to judge the conformity of a lot at reception.

8.1. Trading articles and outsourcing provisions

(Cf 6.1)

8.1.1. Visual control

An inspection is done in comparison to the defect range board, any color panoply and the supplier's specification.

8.1.2. Lacquering adhesion test

2 tests are to be carried out:

- ✓ Tape test,
- ✓ G1 Test.

These two tests are described in Appendix 5.

8.1.3. Metallization adhesion test

2 tests are to be carried out:

- ✓ Tape test,
- ✓ G1 Test.

These two tests are described in annex 6.

8.2. Enamel decoration

8.2.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Deco Defects,
- ✓ Positioning,
- ✓ Skew/Shift,
- ✓ Color.

8.2.2. Adhesion control

A deco adhesion dry inspection is done during production at a set frequency and according to 3 tests:

- ✓ Friction test,
- ✓ Scotch test,
- ✓ G1 Test.

These 3 tests are described in annex 7.

8.3. Ink decoration

8.3.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Deco defects,
- ✓ Positioning,
- ✓ Skew/Shift,
- ✓ Color.

8.3.2. Adhesion control

A sampling is taken during production at set intervals and control is performed 24 hours after according to the following two tests:

- ✓ Friction test,
- ✓ Scotch test.

These two tests are described in annex 7.

8.4. Hot Stamping

8.4.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Deco Defects,
- ✓ Positioning,
- ✓ Skew/Shift,
- ✓ Color.

8.4.2. Adhesion control

A sampling is taken during production at set intervals and control is performed 24 hours after according to the following two tests:

- ✓ Friction test,
- ✓ Scotch test.

These two tests are described in annex 7.

8.5. Injection

8.5.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Molding Defects,
- ✓ Color.

8.5.2. Functional control

A sampling is taken during production at a set frequency for inspection, which consists of assembling the molded part on its support to verify the hold/retention (manual method).

8.6. Pump assembly and diptube cut

8.6.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Visual defects,
- ✓ Diptube length,
- ✓ Color.

Diptube tolerances:

- ✓ Length under 50 mm: +/-0.5 mm
- ✓ 51 to 100 mm length: +/-1 mm
- ✓ 101 to 150 mm length: +/-1.5 mm
- ✓ Length over 151 mm: +/-2 mm

8.6.2. Functional control

A sampling is taken during production and it primed at set intervals (10 sprays with water).

8.7. Cap assembly

A visual and assembly control is performed at the end of production.

9. LIMITED RESPONSIBILITY OF COVERPLA

9.1. Check upon Reception by the Client

9.1.1. Acceptance

The packs which comply with the minimum quality level specified in these Specifications are accepted.

However, if the number of defective items proves to be close to the refusal limit, the client may, at his discretion, give notice of these defects by sending COVERPLA Company "quality remarks".

If the number of defective items proves to be higher than the acceptance limit and if the client considers that the checked pack can be nonetheless used, the client may accept the pack with reservations and shall give written notice of these reservations to COVERPLA Company which shall give a decision on its responsibility. In case any pack is accepted with reservations and the client fails to give notice of these reservations to COVERPLA, the latter shall relieve itself of any responsibility in case of problems.

9.1.2. Refusal

In case any pack fails to comply with the minimum quality level specified in these Specifications, this pack shall be refused and a complaint shall be sent to COVERPLA Company.

COVERPLA Company reserves the right to undertake any countercheck at the client's office. However, in case COVERPLA accepts the complaint, two cases may arise which consist in:

- ✓ Either making the products comply with the aforementioned standards on site on the client's initiative. However, this requires prior estimate to be made out as well as written acceptance of this estimate by COVERPLA Company. Once this process has been completed, the defective products shall be made available to COVERPLA and the invoice (request for payment) shall be sent.
- ✓ Or replacing the defective pack at COVERPLA's expense (as quickly as possible).

In case COVERPLA delivers the goods to a principal on behalf of a client (filler...) the implementation of production of the items by the principal shall be considered an acceptance of the goods on behalf of the client.

9.2. Complaint

The client shall notify COVERPLA by mail or fax of any complaint he intends to submit.

This complaint shall include:

- ✓ Product number
- ✓ Order number and date
- ✓ Total quantity of pack
- ✓ Listing/label of pallet and/or box
- ✓ Representative sample of defect(s) (at least 10 to 15 units)
- ✓ Number of items considered defective
- ✓ Description of the defect(s) and of its/their consequences
- ✓ Place where defect(s) were identified: decorator, packer,...
- ✓ Statistical control sheet drawn up upon reception of the pack according to the ISO 2859-1 standard.

Any complaint shall be received at the latest within 1 month from the date of reception of the goods. After this deadline, the delivery shall be considered accepted by the client.

In case of dispute, COVERPLA's responsibility shall be exclusively limited to the delivered goods and shall absolutely not cover additional costs due to decoration, packed products, over pack and any other additional costs. Only costs which were submitted to COVERPLA Company's prior agreement shall be born by COVERPLA.

9.3. Liability Exclusion

It is the customer's responsibility to perform the compatibility of our components with:

- ✓ The products intended to come into contact with our components,
- ✓ The subsequent treatments or handlings performed on our components.

It will not be our responsibility if the component defect is caused by an incompatibility between or by the container and the content. Our sole responsibility is limited to the tests referred to in section 8.

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APPENDIX 1: GLASS DEFECTS

Critical Defects / NQA = 0.65

Spike	Gross distortions
Inside projection	Body and neck diameter > maximum
Tramp glass	Overall height > maximum
Sharp edges	Dimensions of the neck aperture
Bird swing	Mixture of bottles
Finish distortion affecting seal	Resistance of the internal pressure upon specifications
Breakage without glass in packaging	Resistance of the vertical pressure upon specification
Internal, visible foreign bodies	

Non exhaustive list

Major Defects / AQL = 1.5

Overpress neck finish	Overall height < mini
Capacity < minimum or > maximum	Volume out off tolerances
Leaner > 1.3% of the bottle's total height	Checked body and bottom
Diameter back ring > maximum	Chipped
Body and neck diameter < minimum	Open blister
External dimensions of neck > maximum	

Non exhaustive list

Minor Defects* / AQL = 4 or 6.5

*: Upon limit acceptable sample

Frosted finish	Check on collar
Air bubble	Check on body
Fire polishing bubble (oil bubble)	Check on base
Crizzled	Wavy cords
Non-sharp stuck glass	Cold mould
Cords and scratches	Orange peel
Surface cord	Overpressed seams
Opal glass which is translucent	Irregular distribution of glass (appearance)
Washboard	External dirt
Check on neck	Colour outside agreed tolerances

Non exhaustive list

Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 2: PLASTIC DEFECTS

Critical Defects / AQL = 0.65	
Foreign bodies Non-observance of functional dimensions (interruption of conditioning) Colour error	Out of roundness of the collar forbidding corking Leaker Mixture of bottles

Non exhaustive list

Major Defects / AQL = 1.5	
Overpressed neck finish (uneasy screwing) Non-observance of functional dimensions (slow down of conditioning)	Irregular of matter (uneasy filling and labelling) Wrongly shaped product

Non exhaustive list

Minor Defects* / AQL = 4	
*: Upon limit acceptable sample	
Blemish (black point, scratch, thread...) Inner pinch mark at the bottom of the bottle	Colour change outside agreed tolerances

Non exhaustive list

The magnified effect, orange-peel effect and reflexion due to over-thickness at material are not considered as defects on PET bottles.

Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 3: CLOSING ACCESSORIES DEFECTS

Critical defects / AQL = 0.65

Non-compliant matter Crooked screwing	No seal
--	---------

Non exhaustive list

Major defects / AQL = 1.5

Non-compliant functional dimensions Pulling out force outside specifications	Colour outside agreed tolerances
---	----------------------------------

Non exhaustive list

Minor defects / AQL = 4
*: Upon limit acceptable sample

Scratches Scallops Lack of matter Overpressed seams Injection point Metal coating problem	Air bubbles / Blister Black points Mark / Blow Dirt Shrinkage
--	---

Non exhaustive list

Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 4: EXTRA FINISHING DEFECTS

Critical Defects / AQL = 0.65			
<i>PRINTING</i>	<i>HOT STAMPING</i>	<i>LACQUERING</i>	<i>METALLIZATION</i>
Wrong film Wrong colour Legal text illegible Partial absence of printing on legal notices Chipped bottles when printing Distortion of the bottle after the passage into the oven with alteration of capacity	Wrong film Wrong colour Legal text illegible Partial absence of printing on legal notices Chipped bottles when printing Distortion of the bottle after the passage into the oven with alteration of capacity	Wrong colour Broken neck	Wrong colour Broken neck
			<i>FROSTING</i> Broken neck

Non exhaustive list

Major Defects / AQL = 1.5			
<i>PRINTING</i>	<i>HOT STAMPING</i>	<i>LACQUERING</i>	<i>METALLIZATION</i>
Poor adhesion of decoration Colour outside agreed tolerances Mixture of printed bottles Inside stained bottle	Poor adhesion of decoration Colour outside agreed tolerances Mixture of printed bottles Inside stained bottle	Poor adhesion of lacquering Colour outside agreed tolerances Lack Inside stained bottle	Poor adhesion of metallization
			<i>FROSTING</i> Inside stained bottle

Non exhaustive list

Minor Defects / AQL = 4			
*: Upon limit acceptable sample			
<i>PRINTING</i>	<i>HOT STAMPING</i>	<i>LACQUERING</i>	<i>METALLIZATION</i>
Outside stained bottle Blurred text Distorted decoration Cracked decoration Spoilt finishing Scallops Dust in printing Printing position (shift over than 2 mm for cylindrical bottle and 1 mm for flat bottles) Gap height (1 mm) Partial absence of printing (excluding legal notices)	Outside stained bottle Blurred text Shiners Blow of stoking Buckle Dust in printing Printing position (shift over than 2 mm for cylindrical bottle and 1 mm for flat bottles) Gap height (1 mm) Partial absence of printing (excluding legal notices)	Orange peel Scratch Little lack Chocked Dust Plush Excess of lacquering Stain	Scratch Little lack Chocked Dust Stain Excess of metallization
			<i>FROSTING</i> Little lack Cords Scratch (except that caused by the packaging) Grease

Non exhaustive list

Eventual scratches on pieces (at the bottom) due to marking process of printing are not considered as defects.

Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 5: LACQUERING DECORATION ADHESION TEST

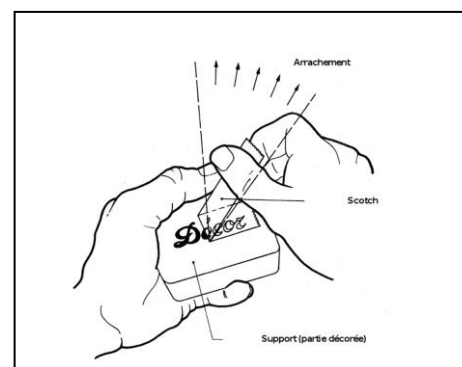
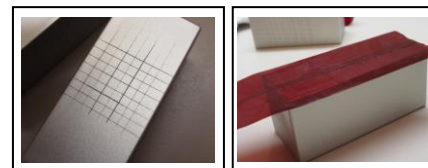
I. SCOTCH TEST:

a) Material:

Adhesive tape 3M - ref# 616
Cutter

b) Procedure:

- Using the cutter, make a crosshatch.
- Apply the adhesive tape to the crosshatch surface while strongly pressing with your finger to ensure a good contact of the tape on the crosshatch
- Wait one minute and then quickly tear off the adhesive tape without jolt at an approximate angle of 45 to 90°



c) Results:

Compare results with to the chart below.

Cotation	Aspect de surface après test
5	Rien
4	
3	
2	
1	
0	> 65%

In general, the **examination of the aspect of the samples tested must lead to a rating from 0 to 5**, index 0 being the worst index, index 5 being allotted if one does not note deterioration. A batch will be considered to be in conformity if allotted quotations are at least equal to 3, as on the diagram opposite:

II. G1 TEST (liquid mix with Alcohol):

a) Procedure:

- Submerge the decorated part in the G1 solution so that it is completely immersed
- After 24 hours, pull out the decorated part and lightly rub it with your finger

b) Results:

There should not be any decoration distortion or difference in the colour shade.

APPENDIX 6: METALLIZATION DECORATION ADHESION TEST

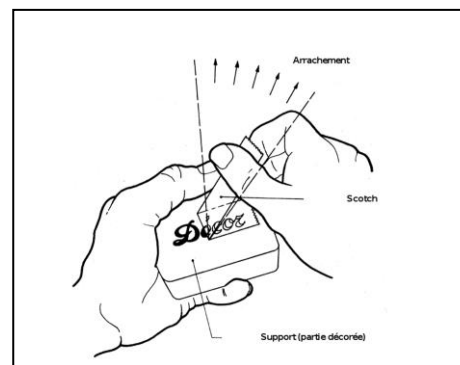
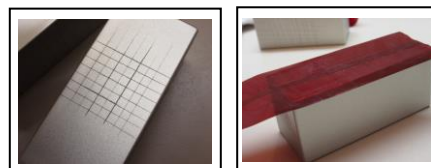
I. SCOTCH TEST:

a) Material:

Adhesive tape 3M - ref# 616
Cutter

b) Procedure:

- Using the cutter, make a crosshatch.
- Apply the adhesive tape to the crosshatch surface while strongly pressing with your finger to ensure a good contact of the tape on the crosshatch
- Wait one minute and then quickly tear off the adhesive tape without jolt at an approximate angle of 45 to 90°



c) Results:

Compare results with to the chart below.

Cotation	Aspect de surface après test
5	Rien
4	
3	
2	
1	
0	> 65%

In general, the **examination of the aspect of the samples tested must lead to a rating from 0 to 5**, index 0 being the worst index, index 5 being allotted if one does not note deterioration. A batch will be considered to be in conformity if allotted quotations are at least equal to 3, as on the diagram opposite:

II. G1 TEST (liquid mix with Alcohol):

a) Material:

A crystallizer
Wool cotton
G1 solution

b) Procedure:

- Soak the cotton with G1 solution
- Wet the entire part to be tested in G1 solution
- Repeat procedure #2 every hour during the entire time of the test
- Place the part(s) to be tested on the cotton, ensuring that you do not cover the area with the decoration edges with the cotton
- Examine the part every hour, without touching it, at a distance of about 30 cm for approximately 10 seconds.

c) Results:

- If after 1 hour we observe a defect, it is rated 0
- If after 2 hours we observe a defect, it is rated 1
- If after 3 hours we observe a defect, it is rated 2
- If after 4 hours we observe a defect, it is rated 3
- If after 5 hours we observe a defect, it is rated 4
- If after 6 hours we observe a defect, it is rated 5

The defects are very variable. They can be observed as pitting, blistering or swelling.

Whatever the nature of the defects, as soon as we observe a defect, the test is stopped. The result is rated according to the time the first defect appears.

The result is considered good if the rating is equal or above a rating of 3.

APPENDIX 7: INKS AND HOT STAMPING DECORATION ADHESION TEST

I. FRICTION TEST:

Friction on the deco with the thumb should not cause deterioration, which means that the part should not have any staining.

The friction between two parts one against the other or of a part on the surface of its pack out should not show signs of deterioration, and should not leave marks on the other part. The friction should be applied without excessive force.

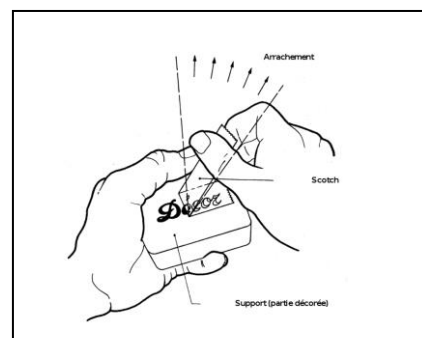
II. SCOTCH TEST:

a) Material:

Adhesive tape 3M - ref# 616

b) Procedure:

- Apply the adhesive tape to the crosshatch surface while strongly pressing with your finger to ensure a good contact of the tape on the crosshatch
- Wait one minute and then quickly tear off the adhesive tape without jolt at an approximate angle of 45 to 90°



c) Results:

We allow a slight distortion of the decoration as long as it does not affect the legibility or the comprehension of the text.

Anything that does not fall under these criteria will be considered defective.

III. G1 TEST (only for enamel decoration):

a) Procedure:

- Submerge the decorated part in the G1 solution so that it is completely immersed
- After 24 hours, pull out the decorated part and lightly rub it with your finger

b) Results:

There should not be any decoration distortion or difference in the colour shade.