

CHARACTERISTIC / PROPERTY	UNIT:	SPECIFICATION:	DETAIL:																																																																																												
GRADE:	N/A	100% Acrylic. *EN 438 Decorative laminate guidelines.	ANSI / NEMA / ASTM																																																																																												
SIZE:		<table border="1"> <thead> <tr> <th rowspan="2">Specification</th> <th colspan="2">Tolerance</th> <th colspan="2">Range</th> </tr> <tr> <th>(+)</th> <th>(-)</th> <th>Min</th> <th>Max</th> </tr> </thead> <tbody> <tr> <td>3073</td> <td>3.2</td> <td>3.2</td> <td>3069.8</td> <td>3076.2</td> </tr> <tr> <td>3660</td> <td>3.2</td> <td>3.2</td> <td>3656.8</td> <td>3663.2</td> </tr> <tr> <td>762</td> <td>3.2</td> <td>3.2</td> <td>758.8</td> <td>765.2</td> </tr> <tr> <td>1370</td> <td>3.2</td> <td>3.2</td> <td>1366.8</td> <td>1373.2</td> </tr> <tr> <td>4.0</td> <td>0.3</td> <td>0.3</td> <td>3.7</td> <td>4.3</td> </tr> <tr> <td>6.0</td> <td>0.3</td> <td>0.3</td> <td>5.7</td> <td>6.3</td> </tr> <tr> <td>12.3</td> <td>0.3</td> <td>0.3</td> <td>12</td> <td>12.6</td> </tr> </tbody> </table>	Specification	Tolerance		Range		(+)	(-)	Min	Max	3073	3.2	3.2	3069.8	3076.2	3660	3.2	3.2	3656.8	3663.2	762	3.2	3.2	758.8	765.2	1370	3.2	3.2	1366.8	1373.2	4.0	0.3	0.3	3.7	4.3	6.0	0.3	0.3	5.7	6.3	12.3	0.3	0.3	12	12.6	<p>* Concession allowable on length only. Item must meet minimum dimensions</p> <p>* Range / fluctuation not to exceed defined tolerance</p> <p>* Magicstone</p>																																																
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Edge Straightness & Squareness:	mm / m	1.5mm / m (Target max deviation). <i>May fluctuate dependent on length tolerances agreed</i>	EN 438 // NEMA LD3-2000																																																																																												
Flatness / Warp:	mm	< 1mm max deflection over 600mm span	EN 438 // NEMA LD3-2000																																																																																												
Sanding:		Face / Top: 400 Wet grit polished Back / reverse: 50 to 80 grit dry sand	50 preferred																																																																																												
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Packaging & Identification		<p>SHEETS: <u>No protective films on sheet, unless specified / agreed.</u></p> <ul style="list-style-type: none"> > All sheets face up, 1 colour, 1 size per pallet (top sheet to be adequately protected from damage) > Each sheet identified with a peelable label adhered to one corner of the top 'face' surface. > Each label to have 4 copies of same information for manufacturing use (4 separate peel off labels) <u>At minimum label to include: Barcode, Design Name, Item Code and batch number.</u> > Sheet material information to be printed on underside of sheets (product and batch traceability). <u>At Minimum: Product code, Description / Décor, Batch and/or date Information</u> <p>PALLETS: <u>No MDF (Medium Density Fibre board)</u></p> <ul style="list-style-type: none"> > Pallet configuration to be agreed in advance of any delivery (drawing specifics to be agreed) <u>Central bearer in pallet and build out from centres (for fork lift entry)</u> <u>Clearance considerations for forklifts: 70mm height. (x2) 175mm widths. 750mm central gap</u> > Pallet to always be larger than the material itself (no overhanging material). > Pallet labels on all 4 sides (design name, item code, quantity and all associated batch numbers). > On each long side of pallet: Décor, Décor code and size to be clearly stamped / written on. > Cover (hardboard normally) required for top sheet for protection. > Minimum of 4 straps with corner protectors. > Max Sheets / Pallet: 4mm (x60), 6mm (x20), 12mm (x15) 																																																																																													

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Surface Defects		<u>At given viewing distance and lighting:</u> Maximum contamination area equivalent to 1.0mm/m proportional to the sheet size under inspection. With a target of '0 defects'. <u>Example(s):</u> 1 Spot or group of spots not to exceed 1.0mm / m. Or simply - If eye immediately drawn to any surface variant / defect.	EN 438 // ANSI / NEMA LD3-2000
Performance Testing		Customer / Supplier agreed criteria from selected standards.	EN 438 // ANSI / NEMA LD3-2000
Non-Conforming Product		Edge defects, broken corners, contamination etc... will be inspected against standard AQL. Sheets will be rejected on individual merit and basis, however if over Acceptable Quality Level full pallet / batch / delivery may be rejected.	

APPENDIX 1:

NEMA LD 3 2000	12.3mm		6mm		4mm	
	Cleanability rating	Stain rating	Cleanability rating	Stain rating	Cleanability rating	Stain rating
Distilled Water	0	•	0	•	0	•
Tap Water	0	•	0	•	0	•
Ethyl Alcohol, 50% Solution	0	•	0	•	0	•
Isopropyl Alcohol, 70% Solution	0	•	0	•	0	•
VM&P Naphtha/Ethyl Alcohol, 50/50 Solution	0	•	0	•	0	•
Nail Polish Remover	0	•	0	•	0	•
Acetone	0	•	0	•	0	•
Bar Soap Solution, 5% in Water	0	•	0	•	0	•
Household Detergent, 5% in Water	0	•	0	•	0	•
Household Ammonia	0	•	0	•	0	•
Tomato Ketchup	0	•	0	•	0	•
Vegetable Oil	0	•	0	•	0	•
Trisodium Phosphate, 1% Solution	0	•	0	•	0	•
Coffee	0	•	0	•	0	•
Tea	0	•	0	•	0	•
Whole Milk	0	•	0	•	0	•
Citric Acid, 10% Solution	0	•	0	•	0	•
Yellow Mustard	0	•	0	•	0	•
10% Povidone Iodine	3	•	3	•	3	•
Distilled Vinegar	0	•	0	•	0	•
Lipstick (Red)	1	•	1	•	1	•
Washable Ink (blue)	1	•	1	•	1	•
Grape Juice	0	•	0	•	0	•
Red Food Dye	1	•	1	•	1	•
Beet Juice	0	•	0	•	0	•
Merthiolate	1	•	1	•	1	•
Wax Crayon	1	•	1	•	1	•
Shoe Polish (Black Paste)	3	•	3	•	3	•
Ball Pen Ink	3	•	3	•	3	•
Felt Pen Ink	3	•	3	•	3	•
Black Permanent Marker	3	•	3	•	3	•
#2 Pencil	3	•	3	•	3	•
Supermarket Stamp Ink (Purple)	1	•	1	•	1	•

- 0 Rating - Staining reagent removed with a cellulose sponge moistened with water.
- 1 Rating - Staining reagent removed with a cellulose sponge moistened with water and commercial cleanser.
- 2 Rating - Staining reagent removed with a stiff nylon bristle brush with a commercial cleanser and baking soda.
- 3 Rating - Staining reagent removed with a cotton ball saturated with acetone.
- 4 Rating - Staining reagent removed with a cotton ball saturated with hypochlorite bleach.
- 5 Rating - Stains remaining after the previous cleaning steps are rated 5.

• = No Effect

NOTE: Cleaning and rating performed by NEMA LD 3 2000 protocol.

INVOLVEMENTS:

Technical	David Grant	Business Manager
Purchasing	Paul Howell	Logistics Director