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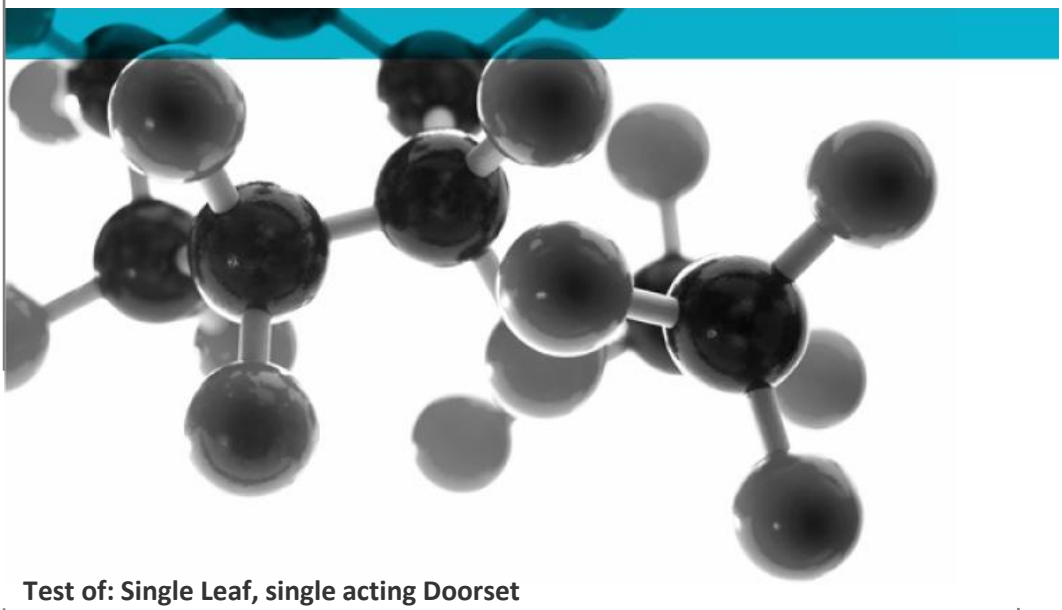
EN 1634-3: 2004

Smoke control test for door and shutter assemblies



Test of: Single Leaf, single acting Doorset

Date of Test: 16th June 2021

Copy: 1

Issue No.: 1

Sponsor: Pacific Rim Wood Limited

Ground Floor Suite
Block B, The Old Kelways
Somerton Road
Langport
SOMERSET
TA10 9SJ
United Kingdom

Document Reference: WYC504045/01

Contents

Page No.

Results of Test: WYC504045/01/Test1

Pacific Rim Wood Ltd

Ground Floor Suite
Block B, The Old Kelways
Somerton Road
Langport, SOMERSET
TA10 9SJ

This document confirms that performance testing was conducted on 16th June 2021. Testing was conducted to BS EN 1634-3: 2004 Incorporating corrigendum № 1: 2007 Fire resistance and smoke control tests for door and shutter assemblies, openable windows and elements of building hardware – Part 3: Smoke control test for door and shutter assemblies.

The following results were achieved:

Product tested	**Single Leaf, single acting Doorset**		
Test Detail	**Latched, with threshold taped**		
Summary of testing procedure			**Result**
BS EN 1634-3: 2004	**Pressure (Pa)**	**Leakage (m^3/h)**	**Leakage ($m^3/m/h$)**
Results under positive chamber (door leaf opening away from chamber)	**50**	**11.80**	**2.26**
	25	**8.17**	**1.56**
	10	**4.90**	**0.94**
Results under negative chamber (door leaf opening away from chamber)	**50**	**12.68**	**2.42**
	25	**8.45**	**1.62**
	10	**4.95**	**0.95**

Testing was carried out at ambient temperature only. The temperature of the test chamber was measured using a calibrated digital thermometer before and after testing.

The perimeter length of gap was 5.23m

Issued by:
Jamie Nelson
Technical Officer

Authorised by:
Lee Grant-Riach
Lead Technical Officer

Issue date: 8th February 2023

Warringtonfire (UK) Ltd (Part of the Element Group)
Chiltern House Stocking Lane, Hughenden Valley, High Wycombe, HP14 4ND, UK.
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1762

Results of Test: WYC504045/01/Test2

Pacific Rim Wood Ltd

Ground Floor Suite
Block B, The Old Kelways
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Langport, SOMERSET
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This document confirms that performance testing was conducted on 16th June 2021. Testing was conducted to BS EN 1634-3: 2004 Incorporating corrigendum № 1: 2007 Fire resistance and smoke control tests for door and shutter assemblies, openable windows and elements of building hardware – Part 3: Smoke control test for door and shutter assemblies.

The following results were achieved:

Product tested	**Single Leaf, single acting Doorset**		
Test Detail	**Latched, with threshold untaped**		
Summary of testing procedure			**Result**
BS EN 1634-3: 2004	**Pressure (Pa)**	**Leakage (m^3/h)**	**Leakage ($m^3/m/h$)**
Results under positive chamber (door leaf opening away from chamber)	**50**	**11.91**	**1.93**
	25	**8.22**	**1.33**
	10	**4.92**	**0.80**
Results under negative chamber (door leaf opening away from chamber)	**50**	**12.79**	**2.08**
	25	**8.49**	**1.38**
	10	**4.96**	**0.81**

Testing was carried out at ambient temperature only. The temperature of the test chamber was measured using a calibrated digital thermometer before and after testing.

The perimeter length of gap was 6.16m

Issued by:
Jamie Nelson
Technical Officer

Authorised by:
Lee Grant-Riach
Lead Technical Officer
Issue date: 8th February 2023

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1762

1 Introduction

Performance testing to BS EN 1634-3: 2004 incorporating corrigendum № 1: 2007 was conducted on the doorset on 16th June 2021. The specimen was configured as a single leaf, single acting doorset. The specimen was installed opening out of the test chamber. In accordance with BS EN 16034: 2014 Annex A section A.3.2, the leaf was pre-cycled before the smoke leakage test (see section 6.1 for further details).

2 Specimen verification

The doorset was delivered to Warringtonfire smoke leakage laboratory on 9th June 2021. The component parts of the specimen were identified based on nominal information provided by the sponsor. These details are outlined in the specimen construction section of this report (section 5).

2.1 Conditioning

The specimen was made from hygroscopic materials and was conditioned for at least 72 hours at an average temperature between 17°C and 22°C. Relative humidity was between 39% and 50%.

2.2 Sampling

The doorsets manufactured and supplied for testing were sampled by Michael Chorlton of BM TRADA on 03/06/2021 under the contract reference of **SC21031-1 / 3504 NR 1** and **SC21031-4 / 3669 NR 4**, this sampling took place at GPM Group Ltd, Unit 3 Fordgate Business Park, Crabtree Manorway North, Belvedere, Kent DA17 6AS.

See Appendix 1 for sampling report.

3 Description of supporting construction

The partition was constructed of nominal 50mm x 34mm steel timber studs at 600mm centres with one layer of 12.5mm plasterboard on each face. The stud wall is taken to be of a standard wall construction.

See Section 5 for fixing and fire stopping details

4 Test Equipment

Description	Equipment reference number
Scientific Monitor	ACT-024
Tape Measure	ACT-027
Callipers	ACT-029
Stop watch	ACT-030
Laminar Flow element:	ACT-058
Pressure Transducer	ACT-060
Force Gauge	F4.42

5 Drawings and Schedule of Components

Test Specimen Drawings

Figure 1 – General Elevation of the Test Construction

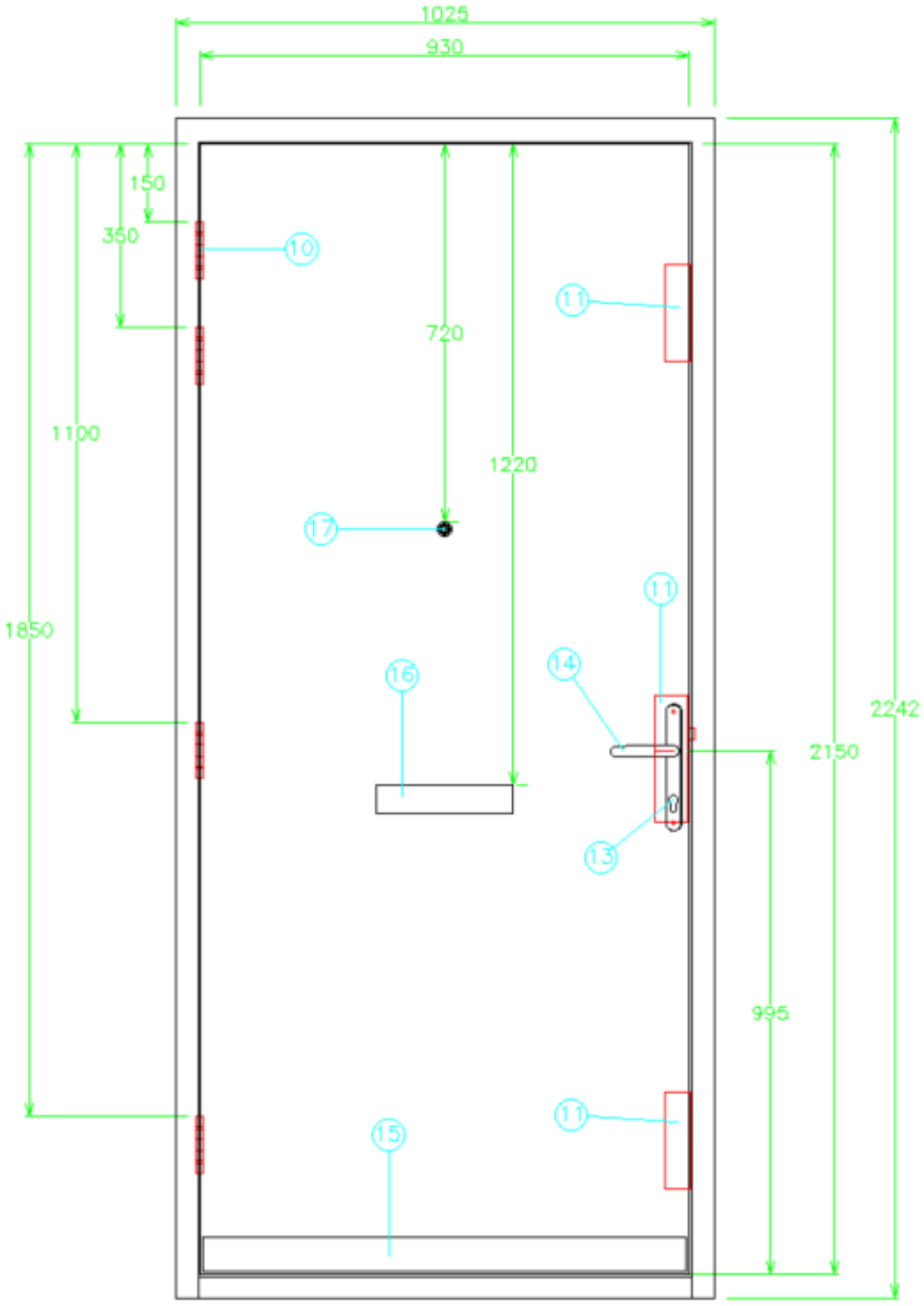


Figure 2 – Details of Door Frame, Jamb and Leaf

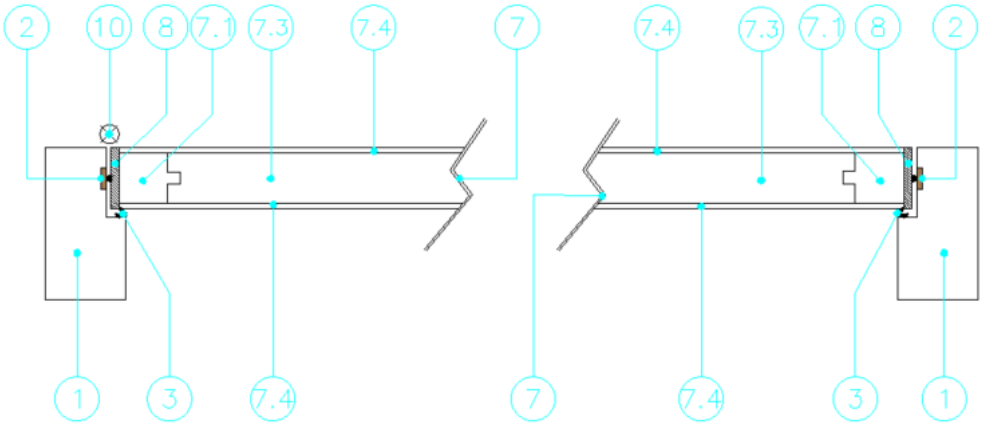
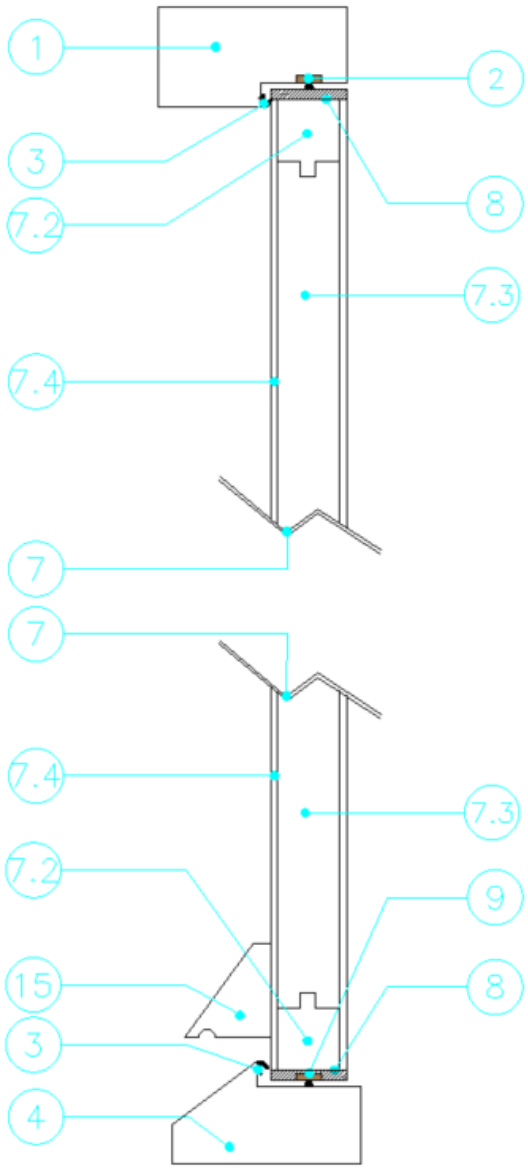


Figure 3 – Details of Door Leaf, Threshold



Schedule of Components

(Refer to Figures 1 to 3)

(All values are nominal unless stated otherwise)

* Stated by sponsor, not verified by laboratory

Door Frame

1. Door Frame**	
Reference	Door type 1
Material	Sapele Head and Sapele Jambs
Density	640 kg/m^3 – values 726 – 780 kg/m^3 seen
Moisture content	8.3-9.8%
Overall size	1025mm wide x 2246mm high x 110mm deep Internal (tight) rebate Prior to painting: 937mm wide x 2157mm high
i. Frame (Head)	110mm wide x 59mm thick with 50mm wide x 15mm deep rebate
ii. Frame (Jambs)	110mm wide x 59mm thick with 50mm wide x 15mm deep rebate
iii. Stop	N/A - Integral
Jamb to Head jointing method, fixing detail and location	Rebated butt joint, fixed with 3No. 5.0mm x 100mm screws at 27.5mm intervals
Stop to Frame jointing method, fixing detail and location	N/A
Presence of Adhesives	Yes
Manufacturer	Timbond Professional
Type	PVA Wood Adhesive
Curing method	Pressure and 20 degrees heat
Application method	Nozzle application

** Manufactured at Sampling Location

2. Intumescent to frame reveal	
Manufacturer	Pyroplex
Reference	8712
Material	Intumescent brush strip
Overall section size	15mm wide x 4mm high
Application method	Self-adhesive strips
Location	Fitted 15mm from opening side
Presence of Adhesives	No

3. Smoke seal to frame reveal	
Manufacturer	Aquamac
Reference	Aquamac 21
Material	Cellular Core
Overall section size	10.7mm x 9.1mm with Kerf slot
Application method	Push Fit
Location	Inserted into the 15mm rebate closing edge, jambs, head and cill
Presence of Adhesives	None

4. Cill**	
Reference	Custom
Material	Sapele
Overall section size	145mm wide x 60mm high with 50mm x 15mm high rebate
Fixing method	Screwed into the jambs - fixed with 3No. 5.0mm x 100mm screws at 27.5mm intervals
Presence of sealants	No
Moisture content	12.6%
Presence of Adhesives	Yes
Location	Butt joint between both jambs and cill
Manufacturer	Timbond Professional
Type	PVA Wood Adhesive D3 water resistant
Curing method	Pressure and 20 degrees heat
Application method	Nozzle application

** Manufactured at Sampling Location

Fire Stopping

5. Frame to supporting construction fire stopping detail	
Manufacturer	Rockwool
Reference	Low density
Material	Rock mineral wool
Overall dimension	Full depth of frame (allowing 10mm capping either side after installation)
Application method	By hand

6. Sealant to fire stopping detail	
Manufacturer	Mann McGowan
Reference	Pyromas A
Material	Intumescent mastic
Overall section size	5-12mm wide x 10mm deep
Application method	Cartridge gun
Location	Frame perimeter both sides

Door Leaf

7. Door Leaf	
Manufacturer (blank)	Pacific Rim Wood Ltd
Reference	Flamebreak 430
Quantity of leaves on doorset	1No.
Overall leaf size prior to trimming	915mm wide x 2135mm high x 44mm thick Lippings applied directly over integral stiles and rails
Overall leaf size supplied for testing	931mm wide x 2151mm high x 44mm thick – measured at 44.6mm/ 44.7mm/ 44.6mm/ 44.6mm

7.1 Stiles	
Manufacturer	Pacific Rim Wood Ltd
Reference	Flamebreak 430
	As supplied stiles remain in place, untrimmed
Quantity	2No.
Overall section size	36mm Thick x 35mm deep incorporating a 9mm x 9mm tongue incorporated into core material
Location	1No. to each vertical edge

7.2 Rails	
Manufacturer	Pacific Rim Wood Ltd
Reference	Flamebreak 430
	As supplied rails remain in place, untrimmed
Quantity	2No.
Overall section size	36mm thick x 35mm incorporating a 9mm x 9mm tongue incorporated into core material
Location	1No each top and bottom horizontal edge

7.3 Core element	
Manufacturer	Pacific Rim Wood Ltd
Reference	Flamebreak 430
Overall section size	12mm hardwood lamels bonded at right angles to form a trilaminate 36mm core

7.4 Facings	
Manufacturer	Pacific Rim Wood Ltd
Reference	Flamebreak 430
Quantity	1No each side
Overall section size	Nominal 4mm thick tropical hardwood plywood
Location	1No. Each face
Moisture content	9.8%

8. Lippings **	
Reference	Custom
Material	Sapele
Density	Nominal 640 kg/m^3 – values seen 705 - 741 kg/m^3
Moisture content	11%
Overall size	44mm wide x 8mm thick
Fixing method	Applied to door core using a Biesse edge banding machine
Location	All sides of door core (Note: Long lippings run over short)
Adhesives	Yes
Manufacturer	Kleiberit
Type	Reactive PUR/ Hot Melt
Reference	Kleiberit 707.6 PUR
Curing method	Heat
Application method	Edge bander

Presence of Mechanical Fixings	No

** Manufactured at Sampling Location

9. Smoke seal to Bottom Leaf Edge	
Manufacturer	Pyroplex
Reference	8712
Material	Intumescent brush strip
Overall section size	15mm wide x 4mm high
Application method	Self-adhesive and pinned with 18 gauge 30mm pins
Location	Full length on bottom of leaf
Presence of Adhesives	No

Hardware

10. Hinges	
Supplier	NICO Manufacturing Ltd
Reference	NICO security hinge
Quantity	4No. hinges per leaf
Primary material	Satin Stainless Steel
Type	Grade 13 R10 Stainless Butt Hinge with two ball bearings
Size	102mm length x 3mm thick x 75mm Open width
i. knuckle	14Ømm x 107mm high
ii. blades	102mm high x 31mm wide x 3mm thick
iii. security pin	7Ømm x 13mm high
Fixings	8No. screws/hinge.
i. type	Wood screws
ii. material	Steel*
iii. sizes	4.5Ømm x 30mm long
iv. number off per blade	4No. screws/blade
Position of each hinge relative to the head of the leaf	Top hinge: 200mm from the top of leaf until middle of hinge Second hinge from the top: 400mm from the top of the leaf until middle of hinge Middle hinge: 1150mm from the top of the leaf until middle of the hinge – equally spaced between 2nd and 4th hinge Bottom hinge: 1901mm from the top of the leaf until the middle of the hinge – 250mm up from bottom to hinge centre.*
Details of intumescent protection	2No. 1mm thick x 100mm long x 30mm wide radius NOR910 Norsound intumescent pad. One applied between the hinge blade and frame and the other one between the other hinge blade and the leaf
Interruptions to Intumescent within the frame reveal	Hinge blade fully interrupts seal in frame reveal.

11. Lockset / Latch	
Manufacturer	Winkhaus GmbH & Co.
Reference	Winkhaus AV2 F2070 (Label attached ART 2559895, ORD EMR 18887221)
Material	
i. Lockcase	Galvanised steel*
ii. Forend plate	Stainless steel*
iii. Latch bolt	Galvanised steel*
iv. Lock bolt	Galvanised steel*
v. Top and bottom lock case	Galvanised steel*
vi. Top and bottom lock bolts	Galvanised steel*
Overall sizes	
i. Central Lockcase	185mm high x 15mm wide x 70mm deep Prep: 18mm wide x 78mm deep
ii. Forend plate	1770mm high x 20mm wide x 3mm thick Prep 20mm wide x 3.2mm deep Additional groove for actuator arms 16mm wide x 7.3mm deep
iii. Latch bolt	30mm high x 10mm wide x 10mm projection
iv. Lock bolt	30mm high x 6mm wide x 20mm single projection
v. Top and bottom lock case	11.3mm high x 15mm wide x 40mm deep Prep: 18mm wide x 49mm deep
vi. Top and bottom lock bolts	45mm high x 8mm wide x 25mm projection
Fixing method	12No. 3.5mm thread x 50mm long wood screws
Operation of latch bolt	Operated by lever handles
Operation of lock bolt	Operated by Euro cylinder
Operation of Top and bottom lock bolts	Operated by both the lever handles and euro cylinder
Details of intumescent protection	

i. Central lockcase	Interdens 1mm OFFICIAL Winkhaus AV2 kit lock protection
ii. Top and bottom lock case	Interdens 1mm OFFICIAL Winkhaus AV2 kit lock protection
iii. Forend plate	None
Interruptions to Intumescent within the frame reveal	None
i. Forend plate	N/A
Location of centre of the spindle relative to the bottom of the leaf	Centre of the spindle measures 974mm from the bottom of the leaf

12. Keeps	
Manufacturer	Winkhaus GmbH & Co
Reference	Winkhaus STVSBAV2 (top & bottom keeps) and Winkhaus STVSBFR24 (RH and LH centre keeps) Top / bottom keeps marked 4933 948 Centre keep marked 4937 125
Material	
i. Centre Strike Plate and Keep	Stainless steel*
ii. Top and Bottom Strike Plate and Keep	Stainless steel*
Overall sizes	
i. Centre Strike Plate	100mm high x 35mm wide x 1.5mm thick Prep: Depths from frame rebate. 1st groove: 24.5mm wide x 235mm long x 6.5mm deep 2nd groove: 16.3mm wide x 180mm long x 8.8mm deep Latch mortice: 18.9mm wide x 57mm long x 28.8mm deep Deadbolt mortice: 16.6mm wide x 67mm long x 28.8mm deep Strike plate relief: 6.1mm deep x 52mm long

ii. Centre Keep Plate	234mm high x 24mm wide x 2mm thick
iii. Top and Bottom Strike Plate	112mm high x 35mm wide x 1.5mm thick Prep: Depths from frame rebate. 1st groove: 24.5mm wide x 172mm long x 6mm deep 2nd groove: 24.5mm wide x 155mm long x 7.6mm deep Hook mortice: 18mm wide x 28.3mm long x 28.3mm deep Strike plate relief: 6.1mm deep x 112mm long
iv. Top and Bottom Keep Plate	175mm high x 24mm wide x 2mm thick
Fixing method	
i. Centre Strike Plate and Keep	3No. 4.0mm diameter x 25mm long screws shown
ii. Top and Bottom Strike Plate and Keep	2No. (Per keep) 4.0mm diameter x 25mm long screws shown
Details of intumescent protection	
i. Centre Strike Plate and Keep	Interdens 1mm OFFICIAL Winkhaus AV2 kit keep protection
ii. Top and Bottom Strike Plate and Keep	Interdens 1mm OFFICIAL Winkhaus AV2 kit keep protection
Interruptions to Intumescent within the frame reveal	Keeps fully interrupt seal in frame reveal.

13. Cylinder with thumbturn	
Manufacturer	ERA
Reference	BS-L-T3535-51 – Stamped with TS007 and KM553031
Material	Steel*
Overall size	34mm high x 17mm wide x 70mm long euro profile

14. Lever handles	
Manufacturer	Winkhaus GmbH & Co
Reference	Winkhaus Melbourne 1672/2390N – ZA/3816N
Material	F1 aluminium with silver effect*
Overall size	External face plate: 258mm high x 34mm wide x 15mm thick x 4mm cylinder incorporated escutcheon projection Internal face plate: 258mm high x 34mm wide x 10mm thick Handles: 30mm high x 135mm wide x 65mm projection
Fixing method, fixing material, sizes, quantity and location	Face plates are connected by 3No. 5.0mm x 60mm steel bolts.
Details of intumescent protection	N/A

15. Rain guard / Weatherbar**	
Reference	Custom
Material	Sapele*
Density	640kg/m^3
Moisture content	9.7%
Overall size	55mm high x 900mm wide x 45mm projection
Fixing method, fixing material, sizes, quantity and location	4No. 5.0mm x 50mm wood screws at regular intervals

** Manufactured at sampling location

16. Letter plate	
Manufacturer	UAP Limited
Reference	Soterian TS008 letterplate
Material	
i. Body	Galvanised steel*
ii. Face plate	Aluminium*
iii. Security cowl	Aluminium*
Overall size	
i. Body size	53mm high x 260mm wide x 70mm thick
ii. Cut out size	External size 40mm high x 259.5mm wide* – measured at 38mm high x 258mm wide Internal size 55mm high x 259.5mm wide* – measured at 55mm high x 258mm wide
iii. Footprint	External footprint: 77mm high x 305mm wide x 18mm thick Internal footprint: 115mm high x 305mm wide x 35mm thick
iv. Security cowl	115mm high x 305mm wide x 6mm thick x 35mm projection
Fixing method	Various screws and bolts provided in the letter plate kit 4 No. machine screws as supplied bolted through to outer cowel 6 No. 4mm x 25mm long screws for internal faceplate
Presence of sealants	No
Details of intumescent protection	Bespoke intumescent protection pre-fitted on internal framing and external face plate. Tubes around screw bosses.

17. Door viewer	
Manufacturer	UAP Limited
Reference	14mm wide angle door viewer
Material	Brass core and steel barrel*
Overall size	
i. Body	14mm dia
ii. Footprint	22mm dia to unexposed face 26mm dia to exposed face
iii. Cut out	16.4mm dia
Fixing method	
Location	721mm from the head of the leaf to the centre of the cut out and 465.5mm from the closing edge of the leaf to the centre of the aperture – measured at 1430mm from foot
Details of intumescent protection	45mm long x 40mm wide x 1mm thick reinforced bespoke intumescent jacket rolled and inserted in the aperture prior to the door viewer being installed – supplied with viewer

6 Pre-test measurements

6.1 Operational check

Prior to testing, the doorsets were subjected to appropriate mechanical pre-test conditioning in accordance with the requirement of BS EN 16034. Specifically the pre-cycle requirement within Annex A.2.2:

Operability Pre-cycling

Minimum angle of opening:	90°
Number of operation cycles completed:	25

Specimen Self-Closing

Angle of Measurement	10°±2°
Closing speed	N/a*

6.2 Retention forces

Measured in accordance with BS EN 1634-3: 2004 section 10.1.2.

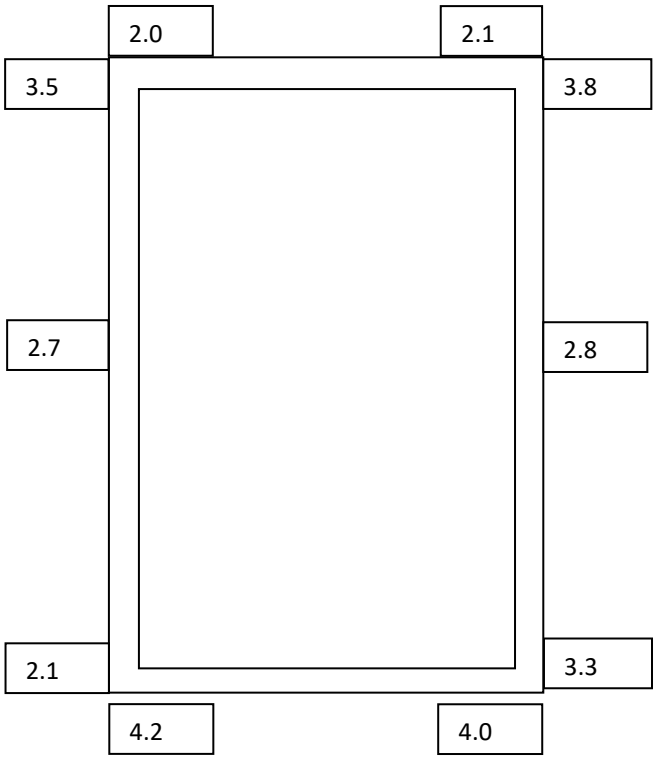
Opening Forces
N/A*

*no closer fitted on doorset for test

6.3 Leaf/frame gaps

The gaps were measured before testing commenced – See diagram below (Gaps were measured within 20mm from corners and at the centre of stiles) – All measurements given in mm.

Lock Side Hinge side



7 Limitations

- The results only relate to the behaviour of the specimen submitted for test, as described in the Technical Specification (section 5), and under the particular conditions of test.
- The results are not intended to be the sole criteria for assessing the smoke leakage performance of the element in use nor do they necessarily reflect the actual behaviour once installed on site.
- The specification and interpretation of test methods are the subject of ongoing development and refinement. Changes in associated legislation may also occur. For these reasons it is recommended that the relevance of test reports over 5 years old should be considered by the user. WARRINGTONFIRE will be able to offer a review of the procedures adopted for a particular test to ensure that they are consistent with current practices.
- The results are solely for use by the sponsor and the stated purpose.
- The sponsor cannot rely on information provided without consent from WARRINGTONFIRE.
- Any recommendations are specific to the assignment and the sponsor.
- Extracts from the report are not permitted.

8 Field of direct application of test results

The results of the test are directly applicable to similar constructions where one or more of the changes listed in BS EN 1634-3: 2004, Clause 13, are made and the construction continues to comply with that appropriate design code for its stiffness and stability. Other changes are not permitted by the document. A copy of the field of direct application is available from Warringtonfire upon request.

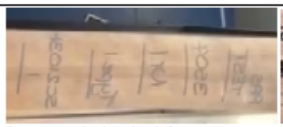
Appendix 1 – Sampling Report

(2 Pages)

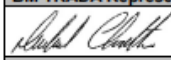
bmtrada Proud to be part of element	SAMPLING VISIT REPORT	Company Name	Pacific Rim Wood Ltd
		Establishment No.	006/1686
		BM TRADA Notified Body ID: 1224	

Company Head Office Address	Pacific Rim Wood Ltd Pt Kutai Timber Indonesia Jl. Tanjung Tembaga Baru, Pelabuhan Probolinggo 67201, Jawa Timur Indonesia	Contact Name	Mr Shaun Hannan
		Telephone	01598 710100
		Email Address	Shaun@prwuk.com

Location where sampling was conducted if different from Head Office Address	Visit Date	BMT Representative
GPM Group Ltd, Unit 3 Fordgate Business Park, Crabtree Manorway North, Belvedere, Kent DA17 6AS	03/06/2021	Michael Chorlton

Requirement	Evidence / Comments
Opening Meeting (names of those present)	Mr Paul Baddick (GPM) / Mr Adam Wilton (GPM)
Contract Reference	SC21031-1 / 3504 NR 1
Technical Specification document reference. Photographs to be taken of all critical areas highlighted in the Technical Specification	TS T – Door Type 1 Technical Specification (Mark up available). Additionally a mark up of the PAS24 draft report has been made.
Description of product(s) sampled	Single timber based flush doorset based on PRUK Flamebreak 430 blank.
Product identification / reference numbers / codes	GPM Job Ref: 3504 Nr 1
Batch number(s)	N/A
Date of manufacture	Manufactured in stages between 17/05 and 03/06
Quantity of stock and size of sample(s) taken	1No. doorset at 1025mm wide x 2246mm high (Leaf: 931 wide x 2151 high)
Traceability of material records ie Purchase Orders and delivery notes	Door cores initially labelled, hardware generally marked or package labelled, intumescents marked, frame and lipping material timber checks made, POs requested for unmarked intumescents and hardware.
Example of sampler's markings applied to the product(s) (contract reference, signature of client, date of manufacture)	  Leaves marked on bottom, frames marked on back face.
Confirmation of minimum mandatory video/live checks undertaken	☐ ~~Glazing assembly (where applicable)~~ ✓ Finished doorset with markings ✓ Hardware prep and fitting (where applicable) ✓ Sampling pack discussion
Details of any further FPC processes witnessed during the visit.	Dimensional checks made throughout.
Determine the essential characteristics of the product and confirm the details of in-process checks conducted on the sample to ensure conformity.	Door blanks (FB 430) selected and marked. Lipped on all four edges with 9mm lippings. Trimmed to size and machined for hinge and lock and ancillary hardware. Frame assembly and machined pockets / mortices. Painting was not witnessed, however traceability recorded via marking. Final assembly including hardware protection and fitting. NOTE: A Closer was not fitted and the supporting construction requirements not communicated. Laboratory to finalise requirements.
Confirm any clauses within the Technical Specification that were found to be different on the sampled product/s. ***Non-conformances may be raised for pre-cert and audit test sampling***	The following clauses of the technical specification have been amended or have information added by the sampler: 1 door frame, 8 seals, 12 Cill, 16 leaf, 16.1-16.6 core, 16.9 lippings, 19 seal, 21 hinges, 24 lockset, 25 keeps, 26 cylinder, 29 rainguard, 30 letterplate, 31 veiwer, 32 security bar.
Closing Meeting (names of those present)	Mr Paul Baddick

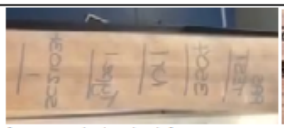
Declaration	I declare that the product/s witnessed during this sampling visit are representative of normal production.

Company Representative Name (Print)	Company Representative Position
Sent to Paul Baddick (GPM) and verbally approved	N/A
BM TRADA Representative Signature	**Company Representative Signature**
	N/A

bmtrada Proud to be part of element	**SAMPLING VISIT REPORT**	Company Name	**Pacific Rim Wood Ltd**
		Establishment No.	**006/1686**
		BM TRADA Notified Body ID: **1224**	

Company Head Office Address	**Pacific Rim Wood Ltd** **Pt Kutai Timber Indonesia** **Jl. Tanjung Tembaga Baru, Pelabuhan** **Probolinggo 67201, Jawa Timur** **Indonesia**	**Contact Name**	**Mr Shaun Hannan**
		Telephone	**01598 710100**
		Email Address	**Shaun@prwuk.com**

Location where sampling was conducted if different from Head Office Address	**Visit Date**	**BMT Representative**
GPM Group Ltd, Unit 3 Fordgate Business Park, Crabtree Manorway North, Belvedere, Kent DA17 6AS	03/06/2021	Michael Chorlton

Requirement	**Evidence / Comments**	
Opening Meeting (names of those present)	Mr Paul Baddick (GPM) / Mr Adam Wilton (GPM)	
Contract Reference	SC21031-4 / 3669 NR 4	
Technical Specification document reference. Photographs to be taken of all critical areas highlighted in the Technical Specification	TS T – Door Type 1 Technical Specification (Mark up available). Additionally a mark up of the PAS24 draft report has been made.	
Description of product(s) sampled	Single timber based flush doorset based on PRUK Flamebreak 430 blank.	
Product identification / reference numbers / codes	GPM Job Ref: 3669 Nr 4	
Batch number(s)	N/A	
Date of manufacture	Manufactured in stages between 17/05 and 03/06	
Quantity of stock and size of sample(s) taken	1No. doorset at 1025mm wide x 2246mm high (Leaf: 931 wide x 2151 high)	
Traceability of material records ie Purchase Orders and delivery notes	Door cores initially labelled, hardware generally marked or package labelled, intumescents marked, frame and lipping material timber checks made, POs requested for unmarked intumescents and hardware.	
Example of sampler's markings applied to the product(s) (contract reference, signature of client, date of manufacture)	 Leaves marked on bottom, frames marked on back face.	
Confirmation of minimum mandatory video/live checks undertaken	☐ ~~Glazing assembly (where applicable)~~	✓ Finished doorset with markings
	✓ Hardware prep and fitting (where applicable)	✓ Sampling pack discussion
Details of any further FPC processes witnessed during the visit.	Dimensional checks made throughout.	
Determine the essential characteristics of the product and confirm the details of in-process checks conducted on the sample to ensure conformity.	Door blanks (FB 430) selected and marked. Lipped on all four edges with 9mm lippings. Trimmed to size and machined for hinge and lock and ancillary hardware. Frame assembly and machined pockets / mortices. Painting was not witnessed, however traceability recorded via marking. Final assembly including hardware protection and fitting. NOTE: A Closer was not fitted and the supporting construction requirements not communicated. Laboratory to finalise requirements.	
Confirm any clauses within the Technical Specification that were found to be different on the sampled product/s. ***Non-conformances may be raised for pre-cert and audit test sampling***	The following clauses of the technical specification have been amended or have information added by the sampler: 1 door frame, 8 seals, 12 Cill, 16 leaf, 16.1-16.6 core, 16.9 lippings, 19 seal, 21 hinges, 24 lockset, 25 keeps, 26 cylinder, 29 rainguard, 30 letterplate, 31 velwer, 32 security bar.	
Closing Meeting (names of those present)	Mr Paul Baddick	

Declaration	I declare that the product/s witnessed during this sampling visit are representative of normal production.

Company Representative Name (Print)	**Company Representative Position**
Sent to Paul Baddick (GPM) and verbally approved	N/A
BM TRADA Representative Signature	**Company Representative Signature**
	N/A