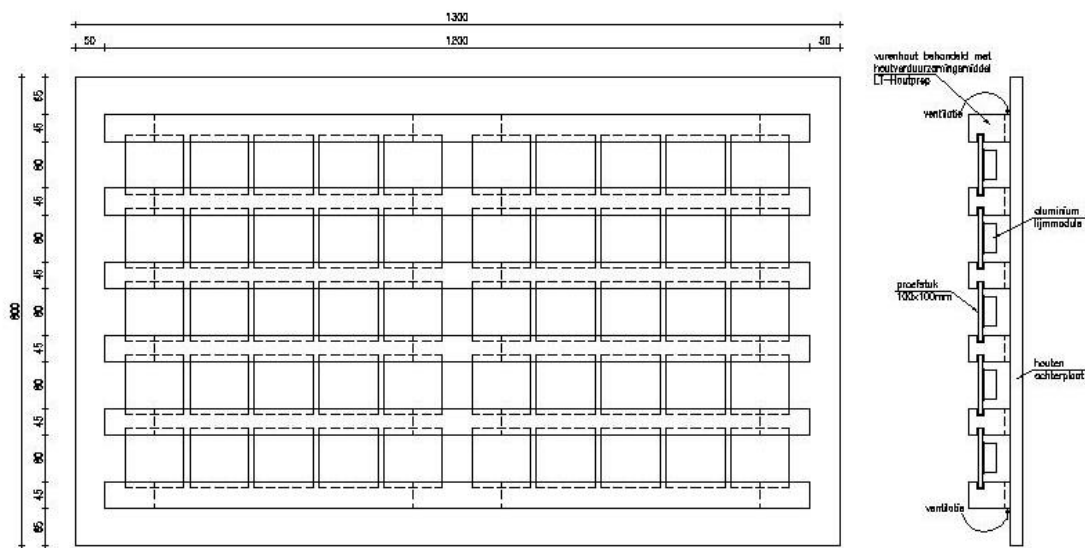


TEST PROCEDURE 10: ADHESION PROCEDURE CONTROL (OUTDOOR EXPOSURE)

In the outdoor air conditions at the time, the applicator is routinely provided with an aluminium (EN-AW-6060/AlMgSi0.5) adhesion module supplied by Tweha with a test piece, being a façade panel measuring 100 x 100 mm. The test proceeds in accordance with the specified processing guidelines and the procedure for the adhesion of the façade panels. Here the production conditions such as air humidity and temperature are recorded by the applicator in a separate weekly statement.



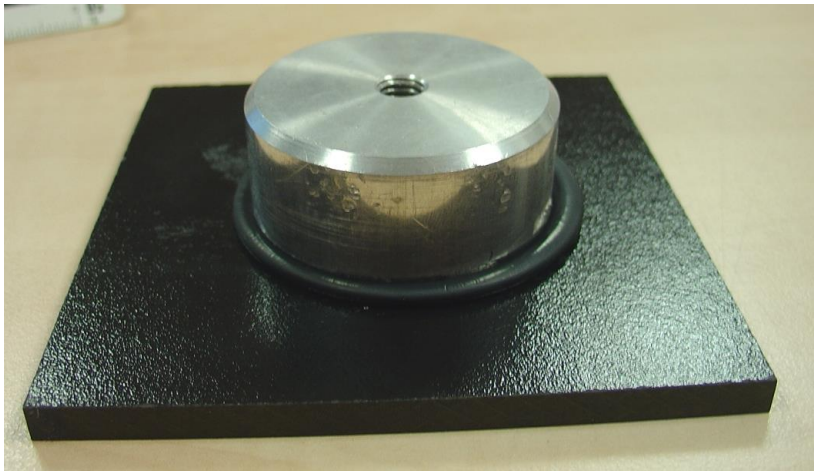
The test piece concerned is in turn placed in a test rack (see sketch). The exposure of the test piece, or façade panel of 100 x 100 mm, to the outdoor air conditions at the time must correspond to the conditions to which the façade panels will be exposed during the curing process in practice. The arrangement of the test rack must accordingly be such that the curing conditions of the test pieces also correspond to the situation in practice.

The corresponding properties of the façade surface produced daily and the test piece, or façade panel of 100 x 100 mm, must be documented by the concurrent mention of a serial number and date on both the façade drawing and the relative test piece.

After at least 10 weeks of the adhesive curing, the tensile strength of each test piece is controlled, whereby the joint between the aluminium adhesion module and the test piece is loaded perpendicular at a speed of 5 mm/min until breakage occurs.

As a result the following properties are determined:

1. Total adhesion surface in mm²
2. Maximum force in N
3. Tensile strength in N/mm²
4. Characteristic tensile strength value in N/mm²



The characteristic value for the tensile strength must suffice with regard to the requirement as provided in the BRL 4101, part 7, product requirements for adhesive as described in article 4.1.1. and 4.1.2. (maximum tolerance of 20% compared to the calculation value as mentioned in the KOMO quality certificate).

If it is observed that the tolerance amounts to $> 20\%$, a suitable maintenance or inspection plan must be put in place for the façade surface for which the test piece is intended.

Then, if a claim is made on the insured product guarantee, these test results together with the completed weekly statements are to be submitted to Tweha.