

KÖMMERLING *88plus*® WINDOW PROFILE SYSTEM'S DECLARATION OF CONFORMITY

5 January, 2015, No. 150105 – 2Wx

JSC "Profine Baltic", company code 111702714, address Tilzes str. 101, LT-91100, Klaipėda, Lithuania, responsibly declare, that our provided KÖMMERLING *88plus* system's PVC-U (Unplasticized polyvinyl chloride) profiles for windows and doors production are made by extrusion process. They conform European Union requirements in respect with German and Lithuanian Republic standarts and regulatory acts: BS EN ISO 9001:2000, EN DIN LST 12608 : 2003, RAL-GZ 716/1 and Lithuanian Hygiene Norms LT HN 105:2004 (Polymeric Construction Products and Polymeric Furniture Materials).

KÖMMERLING *88plus* system's profiles are produced using GreenLine technology which is based on Ca (calcium) and Zn (zinc) stabilisers (***Pb (lead) and Pb compounds are not beeing used.***

1. Technical data of the KBE system's:

Material: PVC white and coloured moulding material. In accordance with DIN 7748 - PVC-U, EDLP, 080–35-28. In accordance to LST EN 12608:2003 - „Virgin material“ and inner walls („invisible part“ after glazing) „Recycline“ LST EN 12608:2003 – „own reprocessable material“.

Classification according to main profiles in accordance with LST DIN EN 12608:2003;

the thickness of profile walls: :	Class “B”;	
Used PVC stabilizers based on:	Ca/Zn (KÖMMERLING „ GREEN LINE “ technology);	
Classification:	in accordance with LST DIN EN 12608:2003;	
Tolerances of dimensions:	in accordance with LST DIN EN 12608:2003;	
Climatic zone:	meets the requirements of the zone – S;	
Resistance to Impact:	Class II	
Profile marking:	in accordance with LST DIN EN 12608:2003: „ EN 12608 – S – II – B “;	
Physical characteristics of the material:	in accordance with LST DIN EN 12608:2003 conformity, approved;	
Colour / texture:	white (matches RAL 9016), structural and wood imitation colours palette in accordance with the KÖMMERLING <i>88plus</i> range;	
Painting:	available;	
Processing availability:	boring, milling, cutting, polishing, boiling;	
Corner junction:	welding;	
Glass:	all glass and filling;	
Glazing:	dry glazing with PCE and EPDM sealing materials;	
Water outlet:	milling/ boring, outlet via special chambers;	
Hardware system to bonding:	Standard, KÖMMERLING – approved;	

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Cleaning and maintenance: material designed for cleaning of plastic materials, water and appropriate cleaning agents.

2. Physical characteristics of **KÖMMERLING** system:

Material density,

Test in accordance with LST DIN EN ISO 1183: 1,44 g/m³

Softening temperature. Test in

accordance with LST DIN ISO 306: $\geq 80^{\circ}\text{C}$

Linear dilatation rate,
(from -30°C to 50°C)

$0,8 \times 10^{-4} \text{ K}^{-1}$

Impact to resistance. Test in

accordance with Charpy

impact strength DIN EN ISO 179-2

$\geq 45 \text{ kJ/m}^2$

Impact to resistance at minus temperature

up to -40°C . Test in accordance with DIN53543

no mechanical damages

Stretching force (stress fracture).

Test in accordance with DIN EN ISO 527

$\geq 40 \text{ N/mm}^2$

Flexural modulus of elasticity, in accordance
with LST EN 12608:2003.

E-Modul. Test in accordance with

LST DIN EN ISO 527

$\geq 2500 \text{ N/mm}^2$

Ball indentation hardness.

Test in accordance with DIN ISO 239 T1

100 N/mm^2

Thermal conductivity.

Test of Thermal Insulating

Materials in accordance with DIN 52612

$0,16 \text{ W/mK}$

Flammability. Test in accordance

with DIN 4102

hardly flammable;
self-extinguishing

The relative dielectric constant

Test in accordance with DIN 53483

3,3 by 50 Hz

2,9 by 106 Hz

Flame spread index LST 1532:1998/ 1K:2001

0.0

Electrical properties, resistance

in accordance with DIN VBE 0303 T3

10^{16} W/cm



Light resistance (Colour conversion by irradiating) in accordance with LST EN 20105-A02:1997, (ISO 105-A02:1993) and RAL-GZ 716/1	2-3 grey-scale level, (After 12.0 GJ/m ² irradiation energy of flow density, is equal/better than grade 3 of grey scale)
Physiological characteristics and Environmental behaviour	- inert, neutral, resistance to atmospheric influence, chemical resistance, and resistance to decay guarantees no danger to health and environment while maintenance.
Thermal transmittance In accordance LST EN ISO 10077, LST EN ISO 12567.	-U _w – Windows, dependent of glazing and fillers, average value ~ 1.0 - 0.7 W/(m ² K); U _f 0,79 - 1,1 W/(m ² K);
In accordance with requirements of windows energy efficiency EU (2002/91/EC), DK BR10 : 2010 Windows with dimensions (1,23m X 1,48m) is equivalent	- Class from A to B by E _{ref} 0-17 kWh/m ²
3. Gasket and weatherstripping.	
Material	EPDM/PVC-P
Density. Test in accordance with DIN 53479:	1240 kg/m ³
Stretching force	≥7.0 MPa
Hardness degree	60 IRHD
Breaking elasticity	≥ 250%
Absolute breaking elasticity at temperature alteration in accordance with DIN 53504/53455	320%
Permanent deformation. Test in accordance with DIN ISO 815:	≤70%
(-25 C° /22h/25%)	
(100C°/22h/25%)	≤35%
Solubility in water	insoluble
Atmosphere resistance DIN 53 504 (elasticity)	220
WGK class of hazard to waters	0
Stabilizers (materials)	Ca/Zn



Category of use in type accordance with EN 12365-1	G
Working range in accordance with EN 12365-1	Class 3
Working temperature range in accordance with 12365-1 (at alteration of min. 17%, max. 89%)	Class 3
Linear compression force LST EN 12365-2 LST EN 12365-1	Class 7/8
Deflection recovery LST EN 12365-3 LST EN 12365-1	Class 0
Recovery after ageing LST EN 12365-4 LST EN 12365-1	Class 0

Gaskets are made on a co-extrusion-based process (PCE). Replacement of gaskets is available.

4. Reinforcement in accordance with DIN EN 10142:

Material:	DX 51 D +Z
Zinc coating:	200-275 g/m ²
Breaking elasticity R _m	500 N/mm ²
Relative elongation, δ 4	≥20
A ₈₀	22%
Yield strength , re	310-320 MPa
Tensile strength, rm	370-380 MPa
Elasticity module, E	200GPa

Basis for declaration of conformity:

- Prüfbericht SKZ Nr. 88529/09-I, Nr. 88529/09-II, SKZ – TeConA GmbH , DAR Akkreditierung Würzburg 2009-10-14;
- Prüfbericht SKZ Nr. 89491/10 SKZ – TeConA GmbH , DAR Akkreditierung Würzburg, 2010.04.21;
- IFT – Systempass Fenster nach EN 14351-1 Nr. 110 35485/4-0.1 IFT Rosenheim GMBH, 2010.04.1;
- Zusammenfassender Prüfbericht EN 14351-1 gms. Prüfnormen Nr. 101 35485/B, IFT Rosenheim GMBH, 2009.06.24;
- Prüfbericht F2008/58. PIB Prüfinstitut für Bauelemente GmbH, 2008.12.05;
- Prüfbericht P5-181/2009 nach DIN EN 12412-2, Fraunhofer IBP, Stuttgart 2009.11.18;
- Technische Lieferspezifikationen für Stahlverstärkungen aus Metall, issued by GerbhardStahl 2005.01;
- Prüfzeugnis zur Prüfung Nr.101 23765, issued by 2001.07.03 IFT Rosenheim GMBH ;
- Prüfzeugnis zur Prüfung Nr.101 01563/1, issued by 1998.07.17 IFT Rosenheim GMBH;



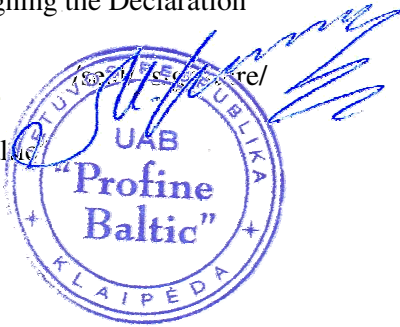
- Conformity to RAL RG 716/1 standard, registration No. 159;
- Flame index determination SMB-11/2004, issued on 19 03 2004 by Fire Test Centre at the Ministry of Internal Affairs or the Republic of Lithuania;
- Certificate of Hygiene of non-foodstuff No. 2-2-I-42056/07, issued by the Republic of Lithuania State Public Health Service.

Expiry of the declaration – 31 December, 2015.

Authorized for signing the Declaration

Marius Ulozas

UAN "Profine Baltic"
Project Manager



This declaration No. 150105-2Wx is issued only to companies "UAB 'WINDEX'" use