

CUSTOMER PRODUCT QUALITY SPECIFICATIONS

The following product quality specifications can be used as a reference tool by the fabricators to ensure they always receive the expected quality of Montelli® Surfaces products.

Please note that working with substandard products greatly increase the amount of fabrication time and can lead to end-consumer complaints. Visual inspection for defects or colour match is essential when working with Montelli® Surfaces and it is considered as a best practice. DuPont replacement policy does not include financial compensation when substandard products have been fabricated without prior approval of DuPont. Substandard products are products that fall outside the release specifications stated below. You may call your Montelli® Surfaces supplier for assistance if you are unsure of the quality of the product. Should you encounter a problem, different claim report forms are available upon request through your Montelli® Surfaces supplier.

A. Sheet product specifications

The table below presents the different release specifications you should look for when inspecting Montelli® Surfaces sheets prior to fabrication.

PROPERTY	AIM VALUE	TOLERANCES	METHOD
Breakage, Cracks	No Cracks	Edge chips, but usable length \geq nominal -10 mm and/or usable width \geq nominal -3 mm	Visual inspection and tape rule (1 mm)
Length	All lengths	-6/+13 mm	Tape rule (1 mm)
Width	All widths	\pm 4 mm	Tape rule (1 mm)
Thickness	All thickness	\pm 0.7 mm	Vernier Calliper (0.1 mm)
Longitudinal warp	0 mm	\leq 1.5 mm / 760mm	See C - Warp
Transversal warp	0 mm	\leq 1.9 mm / 760mm	See C - Warp
Face Side: Colour / Pattern consistency within one sheet	Uniform colour & Pattern	No difference in colour or pattern allowed	Visual inspection in lighting conditions similar to that found at job site. Make sample seam.
Face side: contamination*	None	Less than 3 spots \geq 0,3mm ² & $<$ 0,4mm ² / 30cm Ø Less than 10 spots \geq 0,1mm ² & $<$ 0,3mm ² / 10cm Ø	TAPPI dirt size estimation chart (for use with T213/T437)
Face side: pinholes, voids	None	Less than 5 voids 0,1mm ² / sheet	TAPPI dirt size estimation chart (for use with T213/T437)
Back side: pinholes, voids	None	Less than \leq 3 mm deep and less than 6mm in diameter	TAPPI dirt size estimation chart (for use with T213/T437)

* Please note that for Montelli® Surfaces colours with particles, particle distribution is part of the design of the colour and cannot be considered a product or a manufacturing defect.

For Calacatta colours dark pigmentation within the grey veining and/or between the grey and white base colour is expected as a normal effect of the manufacturing process.

B. Colour

An essential element to sheet inspection is checking for colour matching. The composition of Montelli® Surfaces produces slight colour variations between production cycles due to the complex blending of natural minerals and man-made polyester. Colour variations are therefore inherent in the products (within 1 sheet or sheet to sheet of the same colour). Sheets of same colour in different dimensions may show sheet to sheet variation when joined together as they are produced in different production batches. These strict guidelines below should therefore be followed to ensure the best possible colour matching of Montelli® Surfaces:

Step 1: Using sheets from the same pallet;

Step 2: Checking the code printed on each sheet and fabricating the sheets with the closest numbers when possible (example: 022109240841080063 & 022109240841080065);

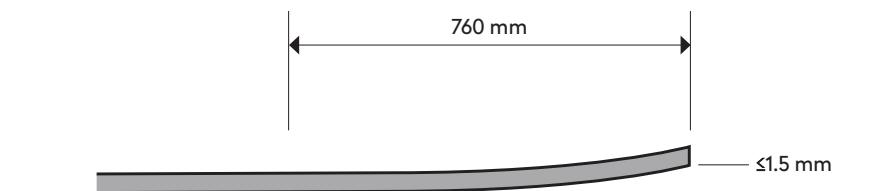
Step 3: Conducting a rapid check by gluing 2 small pieces together and visually checking the colour matching result.

In case where the ink-jet number or label is missing from a sheet within a complete pallet, it is most probable that the sheet may still be from the same batch as the others in the pallet. You may follow step 3 before commencing a job using this sheet. In case where a significant colour match difference is found to be unsatisfactory after following the 3 steps from the guidelines above, please contact your Montelli® Surfaces representative before commencing fabrication. Sensitive colours: Saturated and dark colours will show dust, scratches and other wear and tear more visibly than lighter and less saturated ones.

C. Warp

How to measure Longitudinal Warp

Put the sheet on a flat horizontal surface with the same temperature as the sheet. Check that the sheet is in contact with the surface at 760 mm from its end. Measure the gap at its end with a feeler gauge or a tapered gauge.



How to measure Transversal Warp

Put the sheet on a stable flat horizontal surface with the convex side up. Wait until the temperature of the sheet and the flat surface is the same. Record whether both longitudinal edges of the sheet are in contact with the surface. Measure the gap with a feeler gauge at its maximum at the transversal edges.



**PLEASE CONTACT YOUR MONTELLI® REPRESENTATIVE FOR MORE INFORMATION
ABOUT MONTELLI® SURFACES.**

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