

Roca Industry AB

Taiwan Branch

TEST REPORT

SCOPE OF WORK

Glass door hinge EDGE

REPORT NUMBER

220920011GZU-001

TEST DATE(S)

2022-09-20 to 2022-10-08

ISSUE DATE

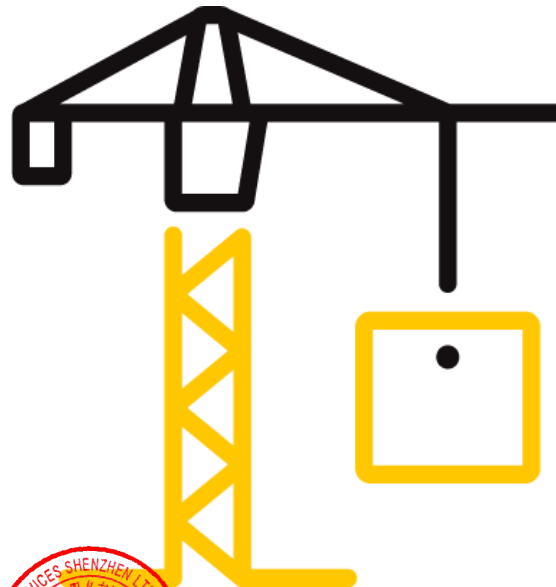
2022-10-11

[REVISED DATE]

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Intertek Testing Services Shenzhen Ltd. Guangzhou Branch



DOCUMENT CONTROL NUMBER

TTRF_Performance_02a

Effective date:2020-12-30

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Client Information:

Applicant Name:	Roca Industry AB Taiwan Branch
Address:	10th fl. No. 3, Gue Feng St. Tay-Shang District, New Taipei City, Taiwan.
Attn:	Hongwei Wu

Product Information:

Product Name	Glass door hinge EDGE	Sample Description	Good Condition
Model and/or type reference	865421, 865420	Received Date	2022-09-19
Sample ID.	220920011GZU.001~005	Sample Amount	5 PCS
Manufacturer	SI JEN ENTERPRISE CO., LTD.		
Address	No. 6-11, Antou Ln., Changhua City, Taiwan (R.O.C.)		
Test Type	Performance test, samples provided by the applicant		

Test Methods And Standards:

Test Standard	Refer to page 5
Specification Standard	Refer to page 5
Test Conclusion	/

Laboratory information:

Testing Laboratory	Intertek testing services Shenzhen Ltd. Guangzhou Branch
Test location	Room 4103 & 4203, No. 63 Punan Road, Huangpu District, Guangzhou, China

Report Authorized :Approved By: Nelson Zhu
Nelson Zhu
ReviewerChecked By: Ziqing Chen
Ziqing Chen
Project Engineer

Noted: If you have any questions for the report, please contact: lillian.lf.he@intertek.com

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General product information:

The samples define as Glass door hinge EDGE, all are the same structure and material other than finish. The models and test plan were listed in the following table, and the photos refer to the Appendix B

Model No.	Finish	Test plan
865421	Painted black RAL 9005	Full test
865420	Painted grey RAL 9006	Evaluation



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Test Items, Method and Results:

No.	Test Item	Test Parameter	Test Result	Verdict
1	Durability test	<p>Refer to Clause 7.5 of EN 1935: 2002/AC:2003</p> <p>Mount the hinge on the test apparatus specified in 6.1 using the appropriate method specified in 6.3.</p> <p>Ensure that the hinge has not previously been subjected to any other tests.</p> <p>Rotate the hinged element through the lesser of $92,5^\circ \pm 2,5^\circ$ or the full angular movement permitted by the hinge for 20 cycles without shock.</p> <p>Measure and record the torque required to initiate movement of the hinged element at opening angles of $0^\circ \pm 5^\circ$, $30^\circ \pm 5^\circ$, $60^\circ \pm 5^\circ$ and $90^\circ \pm 5^\circ$.</p> <p>Measure and record the initial horizontal and vertical gaps between the hinged element and the datum surfaces.</p> <p>Measure and record the torque on the fixing screws at the beginning and end of the test.</p> <p>Operate the hinged element through the lesser of $92,5^\circ \pm 2,5^\circ$ or the full angular movement permitted by the hinge for the appropriate number of cycles specified in Table 1.</p> <p>Ensure that each cycle commences with the hinge fully closed and the speed of operation is (600 ± 30) cycles per hour.</p>	<p>For model 865421:</p> <p>Door mass: 60 kg Door width: 1000 mm Hinge distance: 1540 mm.</p> <p>Before the durability test, initial friction torque measurements: 0 degree: 2,08 Nm 30 degree: 1,84 Nm 60 degree: 2,24 Nm 90 degree: 2,40 Nm</p> <p>After 25 000 cycles, all the parts remain operational and not require any adjustment.</p> <p>Final friction torque measurements: 0 degree: 2,40 Nm 30 degree: 2,08 Nm 60 degree: 2,40 Nm 90 degree: 2,16 Nm.</p> <p>Lateral wear of the hinge: 0,40 mm Vertical wear of the hinge: 0,14 mm.</p>	—

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Appendix A: Product Drawing

Sharp edges removed		General tol. acc. to ISO 2768-Tm, ISO 2768-2JK		Rough castings ±0.0mm	
Nom. measurement	< 6	< 30	< 120	< 400	< 1000
Deviation	±0.1	±0.2	±0.3	±0.5	±0.8
Rev.	Date	Sign.	Description		
2	2022-05-06	AC	Screw M8x16 changed to M8x20		
Checked					

Item no.	Surface treatment
865420	Painted grey RAL 9006
865421	Painted black RAL 9005

Notice: Unless otherwise stated the following applies

Notes:

- GREASE Hinge shaft (pos 3) so that surface meeting bushing is lubricated.
- Deliver cover (pos 9) not assembled (but protected).

B-B (1:1)

A-A (1:1)

Pos	Qty	City	Part number	Description	Scale	Item number
13	1		ISO 10642 - M8 x 20	Hexagon Socket Countersunk Head Screw-1 - Product grade A	1:1	2022-08-29
12	1		10001573	Sticker		
11	1		860890	Bushing		860890
10	2		10001474	3M-double sided tape 30x10mm, min 0.5mm thick (after protection removed)		
9	1		10001986	Slide cover		
8	1		10001987	Attachment plate		
7	1		ISO 4026 - M5 x 4	Hexagon socket set screws with flat point		
6	2		10001952	Sealing Hartzell 1.2mm self adhesive one side (from Germany)		
5	2		860894	Rivet		
4	2		860898	Flange Bearing DE-trading 120010		860898
3	1		10001943	Hinge shaft		
2	1		10001985	Hinge part door		
1	1		10001981	Frame part glass door hinge		

Temp	AC	Checked	Weight	
AC		A22-003		2
Glass door hinge EDGE				10001982

Surface treatment: 1:1

Scale: 1:1

Item number: 2022-08-29

1: Only for glass body
 2: Only for production of hinge and spring
 3: Only for production of hinge and spring
 4: Only for production of hinge and spring

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Appendix B : Product Photo



865421



865420

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Revision:

Revision No.	Date	REVISION	Reviser	Reviewer
/	/	Original Report Issue	/	/

*****End of Report*****

11/07/2022