



TUBULAR CORE DOORSET – NTL, INDIA



NATIONAL TESTING LABORATORY PVT. LTD.

F.No. FO1 (5.10)

Plot No. 83/14, Street No. 1, Opp. Metro Pillar No. 557
Udyog Nagar, Mundka Industrial Area, New Delhi-110041
Ph. : 011-28343761-65 (5 Lines), Email : ntl Delhi@yahoo.co.in
Visit us : www.nationaltestinglaboratory.net

TEST-REPORT

Issued to:

M/s Greenlam Industries Ltd,
RIICO Industrial Area PH-2
E 176-179, SP-02, Behror-301701(Raj)

Report No. :- 201009GEN00003640

Date of Report :- 09/11/2020

Your Ref. No. :- Nil

DT:-08.10.2020

Date of Receipt :- 09/10/2020

Sample Description :- Tubular Core Door Leaf (Size:-2100x900x38mm)

Sample ID :- GIL-20-0065

S.No	Test Parameter	Clause	Test Method	Test Result	Requirement IS 2202(Pt-1):1999 Ammd.-1,2, 3 & 4
1.	Construction	Cl. 7			
(i)	Stile and Rail	Cl.7.3		Satisfactory	Shall be made of one piece, without any Joint.
2.	Workmanship and Finish	Cl. 9.3	Visual	Satisfactory	All four edges of the door Shutter shall be square. Both faces of the door shutter shall be sanded to a smooth even texture.
3.	Number of Defect for Type of Face Panel	Cl. 9.3 T-2 IS 303			
	a) Face			Nil	Shall be 3 for type – A /
	b) Back			Nil	5 for type – B
4.	Surface Defect-for Type Surface: A/ B:	Cl .5.2 of IS 303:1989			
	a) Blister			Nil	Nil
	b) Checks			Satisfactory	Individual checks not more than 50/100mm in length and the total length not more than 500/1000mm/m2
	c) Discoloration			Nil	Nil / 5 %
	d) Dote			Satisfactory	5/15 cm/m ²
	e) Insect hole			Satisfactory	Scattered up to 12/24 Holes / m ²
	f) Joints			Satisfactory	One joints for every multiple of 200 mm provided no individual piece is less than 100mm in width/ No Restriction.
	g) Knots (dead)			Satisfactory	2/4 upto 12/20 dia/m ²
	h) Pin knots (dead)			Satisfactory	2/6m ²
	i) Pin knots (Live)			Satisfactory	No Restriction
	j) Knots (Tight)			Satisfactory	6 up to 25mm dia/m ² No Restriction
	k) Patches			Satisfactory	4 patches/m2/any number provided they are all tight patches and do not mar the appearance.

Lab Incharge

B. N. JHA
Authorised Signatory

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	l) Splits			Satisfactory	2/3 splits each not more than 1/4mm wide and length not more than 100/150 mm provided they are filled with suitable filler. veneer insert. split upto 25mm long 0.8mm wide may be ignored provided they are suitable filled with a filler.
	m) Swirl			Satisfactory	Unlimited provided they do not more than appearance /No Restriction.
5.	Dimension and Squareness Test , mm	Cl. 11.1	IS 4020(Pt-2):1998		
	a) Height			2103.3	2100 ±5
	b) Width			903	900 ± 5
	c) Thickness			38.57	38 ± 1
	d) Variation in Thickness			0.52	0.80 Max.
	e) Squareness			0.49	Shall not deviate by more than 1mm on a length of 500 mm
6.	General Flatness Test, mm	Cl. 11.2	IS 4020 (Pt-3):1998		The twist, cupping and warping shall not exceed 6mm
	a) Twist			2.49	
	b) Warping			2.46	
	c) Cupping			2.65	
7.	Local Planeness Test	Cl. 11.3	IS 4020 (Pt-4):1998	0.26	The depth of deviation Measured at any point shall not be more than 0.5mm
8.	Impact Indentation Test	Cl. 11.4	IS 4020 (Pt-5):1998		Shall have no defects such as cracking, teasing or delamination and the depth of indentation shall not be more than 0.2 mm
	a) Appearance			Satisfactory	
	b) Depth of Indentation ,mm			0.14	

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S. No	Test Parameter	Clause	Test Method	Test Result	Requirement IS 2202(Pt-1):1999 Ammd.-1,2, 3 & 4
9.	Flexure Test	Cl. 11.5	IS 4020(Pt-6):1998		
	a) Deflection after application of load, mm			48.4	Note more than L /30 or w/15 which ever as less i.e 60.2
	b) Residual deflection after removal of load ,mm			3.40	Note more than 1 /10 of deflection i.e 6.02
10.	Edge Loading Test	Cl. 11.6	IS 4020(Pt-7):1998		
	a) Deflection After application of Load, mm			3.76	The deflection of the edge at max. load shall not be more than 5mm
	b) Residual Deflection after Removal of the Load, mm			0.28	On removal of the load the residual deflection shall not be more than 0.5mm
	c) Lateral buckling after application of load, mm			0.96	Not more than 2
	d) Lateral buckling after removal of load			Nil	Shall be no Residual Lateral Buckling.
11.	Shock Resistance	Cl. 11.7	IS 4020(Pt-8):1998		
	a) Soft and Light body Impact			Satisfactory	There shall be no visible damage in any part of the door after twenty five blows on each end.
	b) Soft and Heavy body Impact			Satisfactory	The normally hang shutter with hangings fixings and fastening should with stand without any significant permanent deformation and without deterioration the five impacts on both sides of shutter.
12.	Buckling Test, mm	Cl. 11.8	IS 4020 (Pt-9):1998		
	a) Initial deflection			44.8	Note more than 50
	b) Residual Deflection			3.46	Note more than 5
	c) Appearance			No any Deterioration	Shall not show any deterioration

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S. No	Test Parameter	Clause	Test Method	Test Result	Requirement IS 2202(Pt-1):1999 Ammd.-1,2, 3 & 4
12.	Slamming Test	Cl. 11.9	IS 4020(Pt-10):1998	Passes the Test	shall not have any visible damage in any part of door at the end of 50 Successive impact.
13.	Misuse Test	Cl. 11.10	IS 4020(Pt-11):1998	Satisfactory	There shall not be any permanent deformation of the fixing on any other part of the door sets in hindering its normal working after the test.
14.	Varying Humidity Test	Cl.11.11	IS 4020(Pt-12):1998	Satisfactory	There shall not any visible warping twisting or delamination.
	a) General Planeness, mm			0.37	Shall not be more than 1.0mm
	b) Recovery, %			97.76	The recovery of original size after subjecting the door to high and low humidity shall be at least 90% of the change in dimension.
15.	End Immersion Test	Cl. 11.12	IS 4020(Pt-13):1998	No delamination	Shall have no delamination at the end of the test.
16.	Knife Test	Cl. 11.13	IS 4020(Pt-14):1998	Pass Standard	Excellent bond / min. Pass Standard bond / poor bond
17.	Glue Adhesion Test	Cl. 11.14	IS 4020(Pt-15):1998	No delamination	No Delamination has occurred
18.	Screw withdrawal Resistance Test	Cl. 11.15	IS 4020(Pt-16):1998		
	a) Load to withdrawal,N			1382	Shall not be less than 1000N on withdrawal,
	b) Appearance			Satisfactory	There shall be no visible damage to the surface either by delamination or extra chipping off at the points of withdrawal.

Remarks:- The Sample conforms to IS 2202 (Pt-1):1999 with Amd 1,2,3,& 4 for flush door shutter with respect to above test only.

End of Report

JM
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Quality Manager

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Report No. :- 201009GEN00003641

Date of Report :- 09/11/2020

Your Ref. No. :- AFPM/0945/2020-2021

DT:-08.10.2020

Date of Receipt :- 09/10/2020

Sample Description :- Door Frame 2143x972x45mm (Rebated stream beech frame with natural polish)

Sample ID :- GIL-20-0065

S. No.	Test	Units	Clause No.	Test Method	Results	Requirement IS 4021:1995	Conformity
1.	Moisture Content	%	Cl. 4.1.2	IS 11215:1991	7.9	16 Max.	Yes
2.	Defects Prohibited		Cl. 4.1.4	Visually	Satisfactory	Knots Shall not Occur at Joint or at Locations Where hold fasts/hinges are to be fixed.	Yes
3.	Defects Permitted		Cl. 4.1.5	Visually			Yes
(i)	Cross grain				Satisfactory	No Steeper Than 1 in 15	Yes
(ii)	Sound Knots and Live Knots						
	a) Size	mm			Satisfactory	20 Max.	Yes
	b) Number per meter				Satisfactory	1	Yes
(iii)	Decay Knots, dead Knots and Knots holes				Satisfactory	Not more than 10 mm Size Centrally located and not more than 1 knot per meter. These Shall be Completely Put out and tightly plugged with Seasoned timber of the Same Species and properly glued. So that is grains run.	Yes
(iv)	Pitch Pockets or Streaks				None	None	Yes
(v)	Sap Wood				Satisfactory	Total not exceeding 5 mm wide and 150 mm long per meter.	Yes
(vi)	Pinholes (other than Due to live intestation)				Satisfactory	Permitted provided they are not in Clusters.	Yes
(vii)	Worm holes				None	None	Yes
(viii)	Checks, depth				Satisfactory	3 mm provided it is fully Stopped	Yes


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4.	Construction and Workmanship		Cl. 5.1	Visually	Satisfactory	Timber Shall be Shown in the direction of grain. Sawing Shall be truly Straight and Square. The Scantling Shall be planed Smooth and accurate to the full dimensions rebates etc, before assembly. Patching or plugging of any kind Shall not be permitted except as provided herein.	Yes
			Cl. 5.1.1		Satisfactory	All members of frame Shall be exactly at right angles. The right angle Shall be Checked from the inside Surface of The Respective members.	Yes
			Cl. 5.1.2		Satisfactory	All members of frame Shall be Straight Without any Warp or bow and Shall have Smooth well-planned on three Sides exposed at right angles to each other.	Yes
5.	Dimension	mm	Cl. 6	IS 4021:1995			
	i) Width				973.3	972 +3 -0	Yes
	ii) Thickness				45.1	45 + 2 - 3	Yes
	iii) Total height				2143	2143 +3 -0	Yes

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