

**EINGELANGT**

**- 2. Juli 2013**

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# INSPECTION REPORT

Contract no: 934/2013 - RT 27.06.2013  
OBG/BAJ

Customer: Welde GmbH  
Donaufelderstrasse 216  
AT-1220 Wien

Subject: 1<sup>st</sup> inspection 2013 of the factory production control for  
the manufacturing of film faced plywood of the type EN 636-3 S  
in the manufacturing plant of Lessoplast Plc in BG-5600 Troyan

Date of contract: 02.08.2010 (inspection contract)

Date of sample delivery: --

Date of control: 07.06.2013

Period of validity: 10 months

Pages: 5

Enclosures: --

## 1. Contract

In the inspection contract dating from 02.08.2010 the company Welde GmbH, AT-1220 Vienna mandated Holzforschung Austria to perform an inspection of the manufacturing plant of Lessoplast Plc in BG-5600 Troyan and of the factory production control (FPC) for film faced plywood of the technical class EN 636-3 S according to EN 13986 and according to the European Construction Products Directive.

## 2. Tests

### 2.1. References

EN 13986	Wood-based panels for use in construction - Characteristics, evaluation of conformity and marking (01.04.2005)
EN 636	Plywood - Specifications (01.11.2012)

### 2.2. System of conformity

Systems of attestation of conformity	System 2+ according to the European Construction Products Directive (89/106 EEC)
Scope of the certification	Certification of the factory production control (FPC) for manufacturing of the following product.
Relevant product	Film faced plywood of the technical class EM 636-3 S according to EN 636 plywood for external use as a structural component

### 2.3. Inspection

The inspection at the manufacturing plant Lessoplast Plc in BG-5600 Troyan was performed by Mr. DI G. Oberdorfer from Holzforschung Austria on 07.06.2013 in the presence of Mr. T. Tsochev (Lessoplast Plc) and relevant production and laboratory staff.

The factory production control and the production process were inspected through random checks of documents and through visual controls.

## 2.4. Manufacturer

Company name (before 01.07.2013): Lessoplast Plc  
 Company name (after 01.07.2013) Welde Bulgaria PLC  
 Field(s) of operation: Manufacturing of plywood and fiberboard  
 Site: BG-5600 Troyan  
 Existing certifications and regular inspections: not applicable

## 2.5. Corporate Personnel

Contact person: Mr. I. Stamenov M.B.A. (Welde GmbH)  
 Contact person: Mr. T. Tsochev (Lessoplast Plc)  
 Quality management: Mrs. E. Guevska.  
 Head of laboratory: Mrs. A. Abgelova

## 2.6. Products

Among other products the company Lessoplast Plc manufacturers at the site in BG-5600 Troyan plywood of the following type:

Product: Film faced plywood for external use as a structural component  
 Type: EN 636-3 S  
 Adhesive: Phenolformaldehyde (PF)  
 Formaldehyde class: E1

## 3. Inspection and evaluation of the factory production control (FPC)

In the course of the inspection of the factory production control the following elements were checked in detail:

- Range and type of the certified products/product groups:  
Plywood of the technical class EN 636-3 S for the structural use in exterior applications
- Modification pertaining to the production methods or the technical specifications and the respective documentation:  
Since the initial inspection of the production no modifications of the production methods and facilities were implemented. The production facilities were inspected during the running production in the sequence of the production process. The system for the glue spreading process and the corresponding quality assurance procedure and results were reviewed in particular.



- **Modification of the factory production controls system:**  
Since the initial inspection of the production no modification of the factory production controls system were implemented. Statistical data analysis based on EN 326-2 is being maintained and expanded. Following the spirit of a modern quality management system the documentation system is also being expanded one step at a time.
- **Changes of staff since the last inspection:**  
Since the last inspection no relevant changes with respect to the staff occurred.
- **Type, specifications and reception control of raw materials:**  
With respect to the requirements and procedures no significant modifications were implemented; however raw material supply is adapted to changing market conditions on a continuous basis. Relevant procedures were checked at random using the reception control for adhesives as an example.
- **Type, scope, frequency and implementation of the production control:**  
The requirements according to EN 13986 (Table 12) are being met.
- **Modification of testing equipment:**  
No relevant equipment was changed or modified.
- **Testing procedure witnessed during the inspection:**  
During this inspection no testing procedure could be observed.
- **Results of the factory production control:**  
The results of the factory production control were checked at random using the results of bending strength, bending stiffness and bond quality tests. No deviation from the requirements of EN 13986 and EN 636 were observed.
- **Maintenance of testing equipment:**  
Random checks of laboratory equipment (e.g. universal testing machine, analytical scale) regarding their proper calibration and maintenance did not highlight any shortcomings.
- **System for detection of deviations and faults:**  
During the inspection period no modification of the respective system were implemented; the system remains unchanged since the time of the initial plant inspection. During the inspection period no relevant claims had been filed.
- **Claims management:**  
During the course of the inspection period no claims with respect to the CE mark occurred.
- **Conformity of the CE marking:**  
The CE marking of the respective film faced plywood products has to be expanded to always state the technical class EN 636-3S. The CE marking affixed to the panels stacks has to always include the information requested by EN 13986 (see: ZA.3.3 of EN 13986:2004 and figure ZA.4)
  - Kennnummer der Zertifizierungsstelle für die werkseigene Produktionskontrolle (d.h. 1359)
  - Nummer des Zertifikat der Konformität der werkseigenen Produktionskontrolle (d.h. 0255)

#### 4. Complaints note in the preceding report

In the preceding report no complaints were noted which still had to be resolved.

Recommendations to be implemented in the medium term or on an on-going basis:

- Establishment of a standard documentation system (structure and management of documents).
- Establishment and maintenance of a system for managing measuring and testing equipment.
- Performing paired tests on matched specimens with external testing laboratories in order to ensure consistency of test procedures.
- Establishment and maintenance of a system for managing standards (including information on the status of standard, the staff members to whom standards were distributed etc.)

#### 5. Summary of the evaluation

On 07.06.2013 an inspection of the manufacturing plant of Lessoplast Plc in BG-5600 Troyan and of the factory production control (FPC) for film faced plywood of the technical class EN 636-3 S according to EN 13986 and according to the European Construction Products Directive was performed.

The inspection did not reveal any significant deficiencies in the factory production control system. The marking requirements of EN 13986 have to be implemented consistently. CentrSystem for the management of testing equipment and of relevant standards should be established.

The current factory production control system is regarded as satisfactory. However, a stepwise modernization and standardization of the documentation system is recommended to be implemented in the medium term. To this end the company Lessoplast Plc in BG-5600 Troyan is called to prepare a suitable action plan.

HOLZFORSCHUNG AUSTRIA

  
DI Georg Oberdorfer

Authorised signatory and technical consultant



  
Bernhard Hager

In case of dispute the original German version prevails. This translation is for information purposes only.

Holzforchung Austria is accredited and notified by the Austrian Federal Ministry for Economy, Family and Youth as a testing and inspection (Notified Body 1087).

The results and statements given in this document relate only to the tested materials, the present information and the state of the art at the time of investigation. Publication in excerpts is only permitted with the written approval of Holzforchung Austria.