



Quality Control Procedures and Warranty

A. Raw Materials and Component

All raw materials and components receive two inspections prior to assembly. All raw materials arrive from vendors with certified dates and batch codes for all resin compounds that are checked with delivery manifest upon receipt. Raw materials receive a second check prior to manufacturing processes. The receiving department, upon arrival from vendors, inspects all finished component sub-assemblies. Subassembly components are checked again for size, fit, finish and quality upon assembly of installation kits and prior to assembly of finished product.

B. Manufacturing

1. Molding- All molds have individual numbers and are inspected and cleaned prior to each molding cycle. Ongoing part quality inspections can be traced to individual molds for quality assurance.
2. Inspection- Prior to finishing, all parts are inspected for voids, weight, thickness, and finish compliance.
 - a. Correctable defects are sent back for correction to build part weight and thickness, or receive cosmetic repairs to finish.
 - b. Any part found with a void or cure problem, or cannot be repaired to meet 100% finished product standards is scrapped.

3. Composite Component Standards

"SNOUT" composite components are hand and chopper gun laminations of these properties:

Physical Properties of Unsaturated Polyester Resin Reinforced Laminates
(33 / 66 Glass / Resin 1.5 oz mat Laminates .125 in.)

| | |
|------------------------------------|-----------|
| Flexural Strength (psi) ASTM D-790 | 27,100 |
| Flexural Modulus (psi) ASTM D-790 | 1,157,000 |
| Tensile Strength (psi) ASTM D-638 | 16,700 |
| Tensile Modulus (psi) ASTM D-638 | 1,457,000 |
| Tensile Elongation (%) ASTM D-638 | 1.54 |
| Hardness, Barcol 934.1 ASTM D-2583 | 55 - 60 |

Physical Properties of ISO Gel Coat

| | <u>Room Temp. Cure 45 Hrs</u> | <u>Post Cure 50° 24 Hrs</u> |
|---|-------------------------------|-----------------------------|
| Tensile Strength | 6,218 | 6,581 |
| Elongation, % | 2.70 | 1.90 |
| Flexural Strength, psi | 11,363 | 11,329 |
| Heat Distortion, °F | 0.544 x 106 | 0.713 x 106 |
| Mandrel Flex, Mandrel Diameter in Inches | -- | 1.0 |

4. Finishing- After molding and passing inspection, parts move to trimming and finishing.
 - a. Molding flash is trimmed around perimeter of part to a uniform and smooth surface free of projections or fibers.
 - b. Holes are cut for hatches and vents. All cuts are checked for uniform circularity, size, and absence of protrusions.
 - c. Hatch is installed and tested for ease of opening and closure.
5. Final Check- Prior to packing, each part receives an additional inspection for fit, finish, and overall quality. Rejected parts are sent back to production for correction, passed parts move to packing and shipping.

C. Packing and Shipping

Most parts are packed into containers in a nested state according to size to prevent damage in shipping. Larger parts are strapped to a custom skid for shipping and delivery. All parts receive a final inspection for correct order execution and part quality prior to delivery to customer.

D. Warranty

Best Management Products, Inc. warrants for a period of one year from date of delivery to the original purchaser that the product is free from defects in material and workmanship. BMP, Inc. makes no other warrant of any kind, expressed or implied, in fact or in law, including without limitation, the warranty of Merchantability or the warranty of fitness for a particular purpose other than the warranty set forth above. Failure to follow the instructions for installation provided by BMP, Inc. will void this warranty.

E. Contacts

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