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Assessment of Production

Agreed Quality Plan
for

MARISEAL 250

Agrément Certificate 17/5443

Document reference	17 5443 AQP 310717
Date of issue	31 July 2017
BBA Section responsible	Construction Products
BBA Project Manager	Richard May
Other products covered by BBA Certificates manufactured on this site:	None

Product name: MARISEAL 250

Product range:

MARISEAL 250 is a cold applied and cold curing, one component polyurethane membrane based on elastomeric hydrophobic resins. The polymer cures by reaction with ground and air moisture.

MARISEAL FABRIC is a 110 g·m⁻² is a non-woven polyester used to reinforce the systems.

MARISEAL 710 is a solvent based polyurethane for porous substrate preparation.

MARISEAL AQUA PRIMER is a water-based epoxy primer for porous and non-porous substrate preparation

Production location:

Produced by: Maris Polymers S.A

Address: Industrial Area of Inofita
Inofita
32011
Greece

Telephone: 00 30 22620 32918-9

Fax: 00 30 22620 32040

Contact: Athena Maris (Mobile: 00306936549044)

Title: Finance Director

E-mail: athenamaris@marispolymers.gr

Is the above production site covered by ISO 9001 Registration? Yes

If YES, Registration No: 01 100 045987

Assessed by (organisation): TÜV

Scope of assessment:

Development and production of polyurethane Systems.

Purchasing data & receiving inspection and testing:

Incoming product	Supplier	Property measured	Method of test	Frequency of testing	Acceptance limits
Desmophen 2061BD	Bayer (Covetsro)	Based on certificate of analysis of the product. Issued by the manufacturer	Based on certificate of analysis of the product. Issued by the manufacturer	Based on certificate of analysis of the product. Issued by the manufacturer	Based on certificate of analysis of the product. Issued by the manufacturer
Desmophen 1262BD					
Desmophen 5034BT					
Desmodur T80					
Desmodur VRL20					
Xylene	Shell Aiel				
Additives	BYK				
Filler	Dionisos Marble				
Pigments	Bayer (Covetsro) Lanxess (Bayferrox)				
Epilink 360	Air Products				
Epoxy RES LR 2257	Java				
MARISEAL Fabric	Subrenat				

Product identification and traceability:

A unique batch number is produced by the software that manages the production of the factory. The numbering system follows each product from its production to dispatch. Examples are given below:

MarisSeal 250 (White)
 Batch: 17028905
 Date: 19/03/2017
 Code: X026-0000-0025
 25Kg

Marisseal 250 (Light Ivory)
 Batch:16025277
 Date:18/08/2016
 Code: FR26-0003-0006
 6Kg

MariSeal 250 (Red)
 Batch:17028305
 Date:10/02/2017
 Code P026 -- 0134-0025
 25Kg

MariSeal Aquprimer
 Batch:17028902
 Date 17/03/2017

MariSeal 710
 Batch:17028898
 Date 17/03/2017

Method of production and process control:

The incoming raw materials are checked by the quality control and correctly stored.

Production is by mixing and reacting of the recipe components to a formulation.

All orders are entered into the manufacturing programme. The manufacturing date, batch number and manufacturing recipe are forwarded to production.

Samples are taken during and after the production in order to check against the required specifications.

If satisfactory, the products are transferred to storage for labelling, packaging and preparation for shipment.

Note to Inspector – Following initial audit, the client stated that they would provide a systematic way to track and identify changes to the batch recipe formulation, and provide a list of the current formulation dates/numbers. This has not yet been provided by factory.

In-process inspection and testing:

All testing is in the 'Final inspection and testing' section of this Quality Plan.

Final inspection and testing:**Mariseal 250**

Property measured	Method used	Frequency	Acceptance limits	Action upon rejection
Visual Inspection	In House Testing	Constant	Good flow and levelling	If they are completely off spec they are destroyed. If slightly off spec they may be recycled.
Tack Free Time	In House Testing		8 – 18 hours	
Density	In house testing		1.38 – 1.42 g·cm ⁻³	
Viscosity	ASTM D 4889		4 to 8 minutes	

Mariseal 710

Property measured	Method used	Frequency	Acceptance limits	Action upon rejection
Visual Inspection	In House Testing	Constant	Good flow and levelling	If they are completely off spec they are destroyed. If slightly off spec they may be recycled.
Tack Free Time	In House Testing		2 – 4 hours	
Density	In house testing		0.98 – 1.02 g·cm ⁻³	
Viscosity	ASTM D 4889		5 to 20 seconds	

Mariseal Aqua Primer Part A

Property measured	Method used	Frequency	Acceptance limits	Action upon rejection
Visual Inspection	In House Testing	Constant	Good flow and levelling	If they are completely off spec they are destroyed. If slightly off spec they may be recycled.
Tack Free Time	In House Testing		40 – 70 minutes	
Density	In house testing		0.99 – 1.03 g·cm ⁻³	
Viscosity	ASTM D 4889		4 to 8 minutes	

Mariseal Aqua Primer Part B

Property measured	Method used	Frequency	Acceptance limits	Action upon rejection
Visual Inspection	In House Testing	Constant	Good flow and levelling	If they are completely off spec they are destroyed. If slightly off spec they may be recycled.
Tack Free Time	In House Testing		40 – 70 minutes	
Density	In house testing		1.12 – 1.16 g·cm ⁻³	
Viscosity	ASTM D 4889		1 to 3 minutes	

Calibration:

The calibration procedures are referenced in QP11 of the ISO 9001 Manual. Once a year by an external partner and internally with pre weighed weights.

Packaging:

Metal pails placed on pallets and wrapped by transparent film

Labelling:

Sticker with batch number of the product name together with safety texts.

Use of the BBA symbol:

This will be on the product labels and on our brochures.

Training:

The training procedures are referenced in QP19 of the ISO 9001 Manual. Yearly evaluation of staff. Yearly training programme. Continuous training and staff assessment. CV accompanying their documentations

Complaints:

The customer complaint procedures are referenced in QP20 of the ISO 9001 Manual. The paperwork that accompanies the customer complaints is filed and evaluated yearly by management.

Quality policy: We undertake to have the product produced and placed on the market as described above. We will advise the BBA of any changes and receive agreement from the BBA before the changes are implemented.

Signed

Dated

Title

End of Quality Plan

For BBA internal use only	
BBA Cert(s): 17/5443	Approved by: _____ Date: _____

Appendix – Document Revisions

Revision No	Reason for re-issue	Date