 doka Die Schalungstechniker	Technical Specification TS ZSO 007	Page: 1 / 6
		As of: Oct. 5, 2006
Reconditioning Service-Quality criteria: Technical condition Circular formwork elements H20		

Released by: Obiegli

1. Description

Description of all relevant quality criteria for Circular formwork elements.

The „Reconditioning service quality criteria“ are simplified summaries of the Reconditioning service working instructions and are generally translated into the languages of all our branch offices.

■ Applicable zone

Doka Group

Products: Circular formwork elements H20

■ Responsibility

Reconditioning service, warehouse

■ Additional documentation

Working instruction ZSO 016: Reconditioning Service Circular formwork H20

Technical Specification TS ZSO 001: Reconditioning Service-Quality criteria: Cleaning condition

Technical Specification TS ZSO 002: Reconditioning Service-Quality criteria: General Technical condition

■ Revisions

Central Service Coordination (ZSO)

Update status	Date	Page	Changes, Supplements
<i>New edition</i>	<i>Oct. 5, 2006</i>	<i>complete</i>	

■ Distribution

Doka Sales:	Manager, Branch office manager, Director commercial office, Logistics-Sales, Director reconditioning service resp. warehouse
Doka Engineering:	F&E, ZSO
Doka Production:	QS, ZAS, DMB, DHV

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2. Function, assembly condition

■ Assembled parts must be complete:



Beam holders, turnbuckles, steel waling RD, lifting bracket and/or screwing plate, fixing ledges etc.

■ Screw connections:



Must be complete and have tight seat. Beam holder, steel waling, lifting bracket and/or screwing plate. At fixing ledges 1 missing screw each 1,20m allowed.



No gap allowed at screw connection of plywood.

■ Gap between the panels:



Gap of max. 1mm allowed.

Reconditioning Service-Quality criteria: Technical condition Circular formwork elements H20**■ Offset of panel edge to beam:**

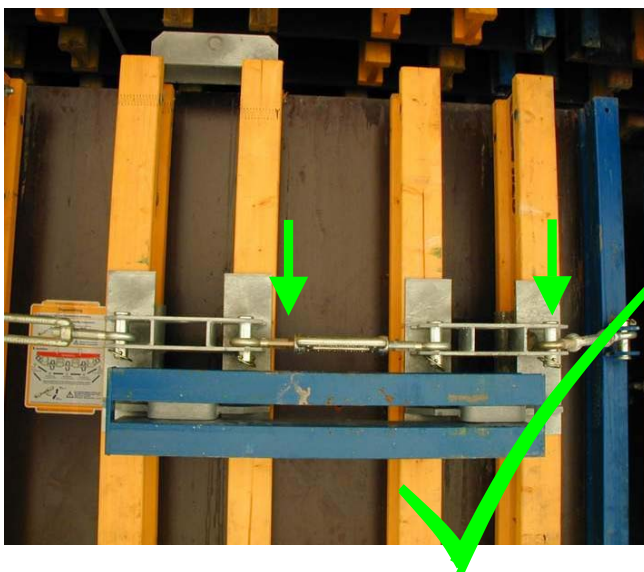
Plywood overlap up to 3mm allowed.

The beam may overlap the panel up to 1mm.

The end of the profile may not overlap the panel.

■ Releasing agent:

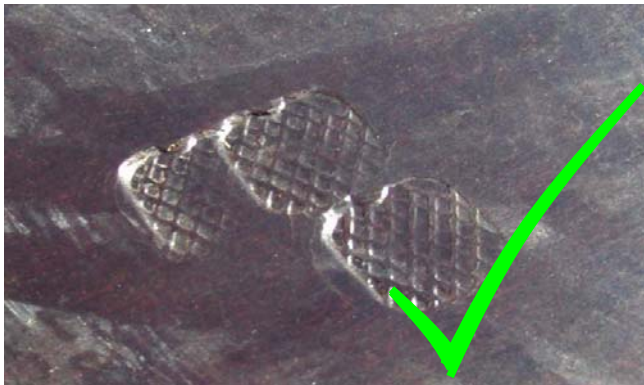
The profiles and the plywood are spread filmy with releasing agent.

■ Turnbuckles:

In order to guarantee that the direction of rotation of all turnbuckles is equal, the yellow screw, which additionally is marked by an "L", must be on the left side.

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3. Plywood condition

■ Dents:

Up to a size of 2 patches D60 and a depth of maximum 1mm allowed.

■ Nail holes:

Allowed, foreign parts (e.g. nails, screws) not allowed.

■ Plywood delamination:

Up to a size of ¼ patch allowed.

Reconditioning Service-Quality criteria: Technical condition Circular formwork elements H20**■ Additional boreholes:**

Not allowed

**■ Scratches:**

Superficial scratches allowed.

Deeper scratches up to a width of 2mm and a depth of 2mm allowed.

**■ Damages to the edges:**

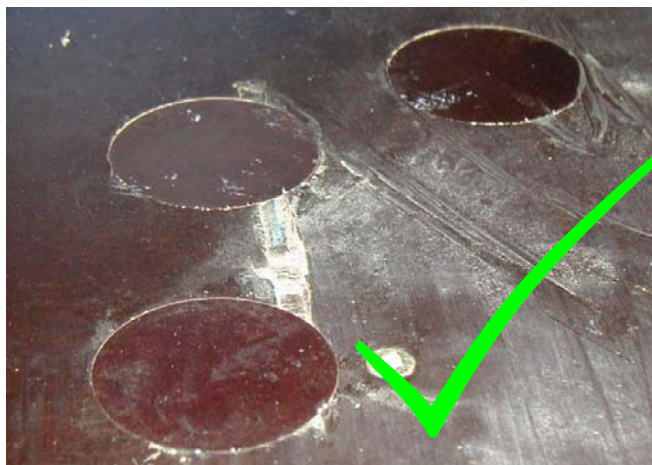
Continuous frayed spots of a maximum size of 30 x 3mm are allowed. Frayed spots of a size of 50 x 5mm up to 20mm in width are allowed selectively. But this may not lead to leakage at stacking. Parts that are sticking out must be grinded off and sealed by varnish.



Reconditioning Service-Quality criteria: Technical condition Circular formwork elements H20**■ Patches, plugs:**

Width	Height	max. number thereof flawed spots	max. formations	max. number plugs
2,5	0,7	7	4	4
2,5	1,2	12	6	6
2,5	2,4	24	12	12
2,5	3,0	30	15	15
2,5	3,6	36	18	18
2,5	4,8	48	24	24
2,4	0,7	7	4	4
2,4	1,2	12	6	6
2,4	2,4	24	12	12
2,4	3,0	30	15	15
2,4	3,6	36	18	18
2,4	4,8	48	24	24

The maximum number of flawed spots that are being mended by Dokaplex patches or plugs is defined in the adjoining table. One formation consists of a maximum of 4 patches (overlap of +/- 0,5 mm allowed).

**■ Buckling or breakage of the plywood:**

Not allowed.

