

Reconditioning Service-Quality criteria: Technical condition framed panels

1 Description

Description of all relevant quality criteria for frame 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: Frame formwork elements Framax, Alu-Framax, Frameco, Frami

■ Responsibility

Reconditioning service, warehouse

■ Additional documentation

Quality criteria and Reconditioning service working instructions

■ Revisions

Central Service Coordination (ZSO)

Update status	Date	Page	Changes, Supplements
New edition	May 10, 2006	complete	--
A	01.12.2008	7	Table of patches
B	13.07.2009	5,7	Plywood condition: nail holes and number of patches and stripes changed
C	08.06.2010	5	Nail holes Dokaplex added

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2 Function, assembly condition

■ Plywood fixing:

Must be complete and tightened.

**■ Silicon joint:**

Minimum 2mm wide on each side.
See that there is a continuous joint. Shrunken silicon, projection and silicon residues on the panel are not allowed.



e.g. Alu Framax Xlife element.

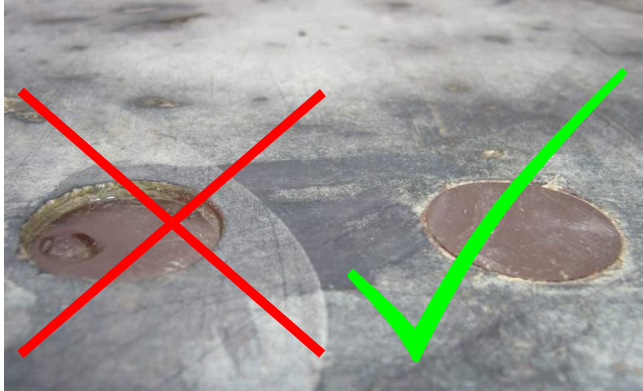
■ Panel projection:

Up to a max. of 1mm allowed, in case of a newly assembled plywood no projection allowed.

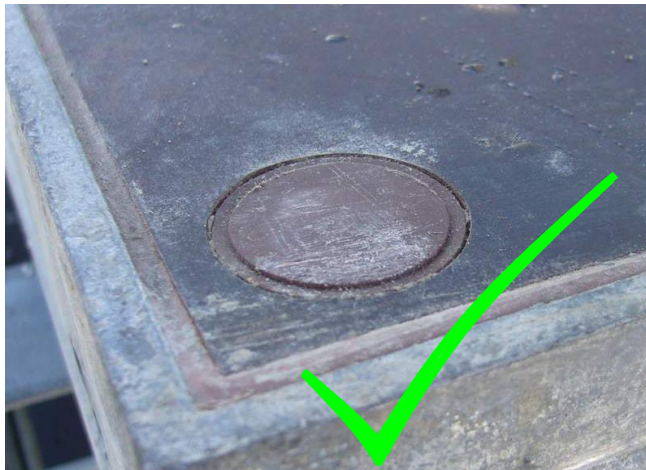


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All bore holes must be closed evenly (+/-1mm).

**■ Formwork anchor protection:**

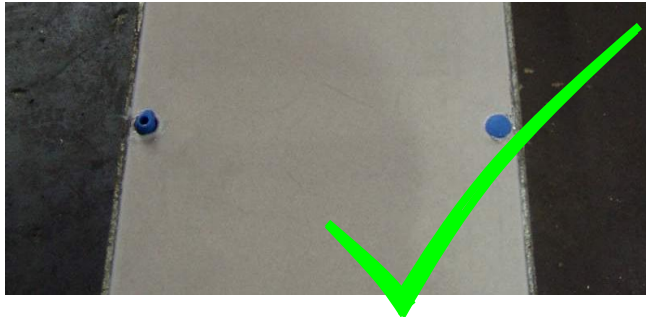
Must exist with Frami and must have a tight seat.



e.g. Frami element with assembled anchor protection and plug.



Missing anchor protection not allowed.

Reconditioning Service-Quality criteria: Technical condition framed panels**■ Plug:**

The anchoring sleeves must be closed at one element side.

Frami: All anchoring sleeves must be closed.

e.g. Universal plug and stacking cone with Xlife element

■ Foreign parts:

Not allowed (screws, nails)

e.g. Nail in Xlife plywood not allowed.

■ Releasing agent:

The outside of the element frame and the Dokaplex plywood are spread filmy with releasing agent.

Xlife plywood is not sprayed.

■ Colour marking:

Colour markings for the distinction between the different element types of the same size must be visible.
(Universal element, Frami anchoring element, 0.55m wide elements),

e.g. Framax universal element marked blue

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3 Plywood condition

■ Dents:

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

e.g. Alu Framax Xlife element

■ Nail holes:

Dokaplex: allowed

Xlife: Allowed up to a diameter of 4mm. Projections allowed up to 1mm.

e.g. Nail hole with projection >1mm in Xlife element

■ Plywood delaminations:

Up to the size of ¼ patch with

Dokaplex plywood allowed.

Delamination of the plastic coating with Xlife panel not allowed.

Reconditioning Service-Quality criteria: Technical condition framed panels**■ Additional boreholes:**

Not allowed.

**■ Scratches:**

Dokaplex: Superficial scratches allowed. Deep scratches up to a width of 2mm and a depth of 2mm allowed.



Xlife: Deep scratches allowed unless they do not penetrate the plastic coating. Overlapping plastic not allowed.

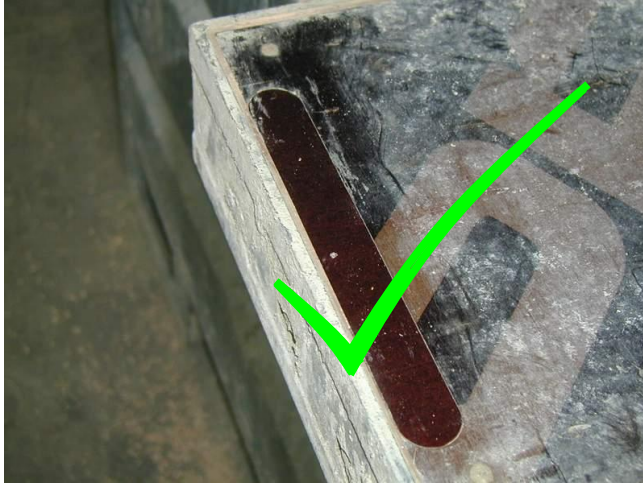
e.g. Xlife element with deep scratch

■ Burnt surfaces:

Not allowed.



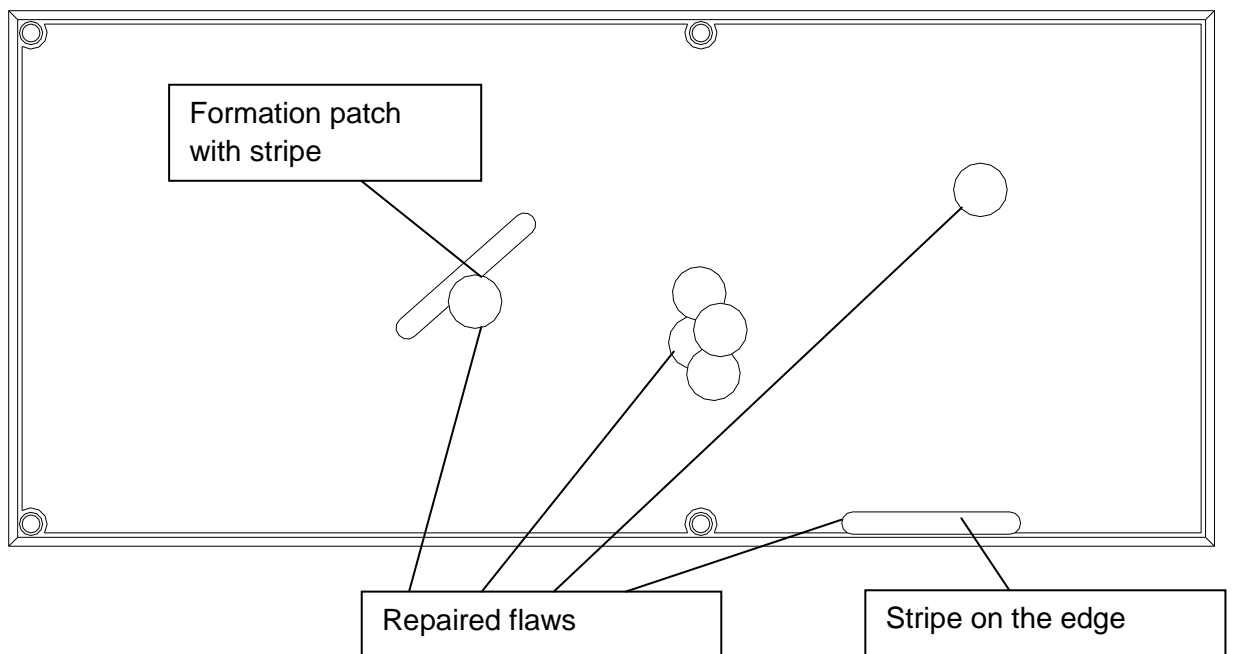
e.g. Melted spot on Xlife panel not allowed.

Reconditioning Service-Quality criteria: Technical condition framed panels■ **Patches, stripes:****Framax, Alu Framax, Frameco, Frami**

Single patches or stripes and formations of stripes and patches are allowed with no limitation. It is only allowed to put 4 patches and/or stripes in formation. It is allowed to add 4 patches and/or stripes to already existing formations. Projections of patches/stripes of +/- 0,5mm allowed.



e.g. Element repaired with stripes and Xlife element repaired with patch



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4 Deformations of the element frame

The stability of the frame must not be affected. The functions of the connecting surfaces and the inside profiles must be given.

■ Bending up to 1mm/lin.m.:



On the plywood side allowed.

Determines the straightness of the shuttered area.

■ Bending up to 2mm/lin.m.:



Allowed at all profiles except those on the plywood side.

e.g. Too strong bending at Frami-element.

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■ Deformations up to 1mm:



At the concrete side of the frame and on the sealing areas (plywood-sided contact areas) allowed.

e.g. too strong deformation on the cover plate of the inside corner on the plywood-sided edge.



e.g. Too strong deformation on the frame profile (contact area)

■ Deformations up to 2mm:



Generally allowed on all other surfaces.

e.g. Frame profile

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■ Deformations up to 5mm:



Allowed on one side of frames and cross profiles up to a length of 80mm.

e.g. Dent in frame profile

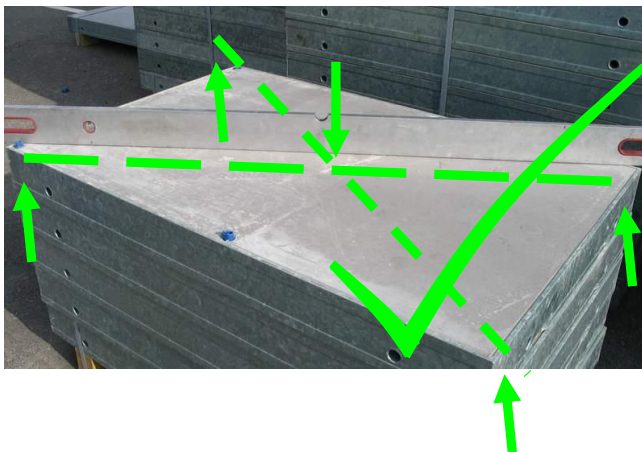
■ Nail holes, cracks, dents:



No nail holes allowed in element frames.

e.g. Nail hole in aluminium frame profile not allowed.

■ Distortion:



3 mm per element length allowed.

At Frami 2,70/3,00m 5mm distortion allowed.

e.g. Xlife element 0,90x1,35m