



# CYNOSURE

## TECHNICAL

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# Certified for Excellence

## Trusted for Quality

We deliver UPVC profiles that exceed global standards like ASTM, ISO, EN, and RoHS. Our products undergo rigorous testing for strength, heat resistance, and durability, ensuring exceptional quality. Certified by Shriram, CIPET, and SGS, they reflect our commitment to excellence.

| Properties                                                                            | Standards               | Protocol Adopted     | Result                      | Certification From | Pg.No.       |
|---------------------------------------------------------------------------------------|-------------------------|----------------------|-----------------------------|--------------------|--------------|
| Definition , Comparison and Consequences                                              |                         |                      |                             |                    |              |
| Tensile Impact Strength                                                               | 50 MPa                  | Not Less than 30 MPa | 43                          | SHRIRAM            | 23<br>S.No-1 |
| Flexural Modulus of Elasticity Mpa                                                    | 2200 MPa                | ASTM D 790-17        | 2524 Mpa                    | SHRIRAM            | 23<br>S.No-7 |
| Charpy Impact Strength(KJ/m <sup>2</sup> )                                            | 10 KJ/m <sup>2</sup>    | ISO 179-1:2023       | 73.37 KJ/m <sup>2</sup>     | SHRIRAM            | 25<br>S.No-1 |
| Vicat Softening temperature C <sup>o</sup>                                            | 75 <sup>o</sup>         | ASTM D 1525-17       | 79 <sup>o</sup>             | SHRIRAM            | 23<br>S.No-3 |
| Heat Reversion,%                                                                      | <2%                     | EN 12608 : 16        | 0.5                         | SHRIRAM            | 23<br>S.No-4 |
| Resistance to impact by falling mass @-10°C for 1 hr falling mas 1Kg & from Height-1m | BS EN 12608-1:2016      | EN 12608 : 16        | No Brittle Failure observed | SHRIRAM            | 23<br>S.No-9 |
| RoHS                                                                                  | DIRECTIVE 2011/65/EU    | Pass                 | Pass                        | SGS                | 9            |
| Density                                                                               | Not To Exceed 1.5 gm/cc | ASTM D 792           | 1.52                        | CIPET              | 20           |
| Hardness                                                                              | 75(Shore D)             | ASTM D 2240          | 81                          | CIPET              | 20           |



## Tensile Strength Test (IS 13360 Part 5/Sec 1:1992, ISO 527 Equivalent)

### ● Definition:

Tensile strength is the maximum amount of tensile (pulling or stretching) stress a uPVC material can withstand before breaking or failing. It is determined by pulling a specimen until fracture occurs.

### ● Standard Reference:

This test is conducted as per IS 13360 Part 5/Sec 1:1992 (equivalent to ISO 527), which defines the specimen shape, testing procedure, and calculation method for consistent and comparable results.

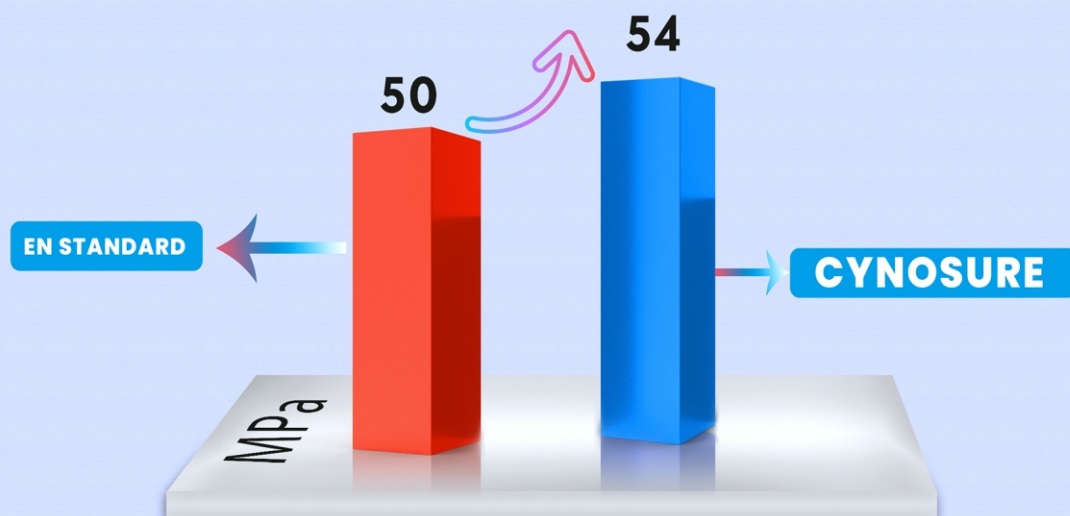
### ● Unit:

The result is expressed in megapascals (MPa), where:  
1 MPa = 1 N/mm

### ● Formula:

$$\text{Tensile Strength} = \frac{\text{Maximum Load at Break (N)}}{\text{Original Cross-sectional Area (mm}^2\text{)}}$$

● Tensile Strength (IS 13360) shows how strong a uPVC profile is when stretched — a direct measure of its mechanical toughness and reliability.



### CONSEQUENCES

Tensile strength directly affects product safety, durability, performance, and cost-effectiveness. Poor tensile strength can lead to product failure, customer dissatisfaction, or safety hazards.



# Weld Strength Test (IS 17953:2023)

## Weld Strength Test (IS 17953:2023)

The weld strength test, as described in IS 17953:2023, is a standard method used to determine the mechanical strength of welded corners and T-joints in uPVC profiles (commonly used for windows and doors).

In this test, profile specimens are welded at  $90^\circ \pm 1^\circ$ . The welded joint is then subjected to tensile or bending forces at a controlled speed ( $50 \pm 5$  mm/min) until failure occurs. The failure load (N) is recorded and the failure stress (MPa) is calculated based on the specimen geometry. The average value from at least three samples is reported.

### Purpose

To ensure welded joints in uPVC profiles have adequate strength and stability.

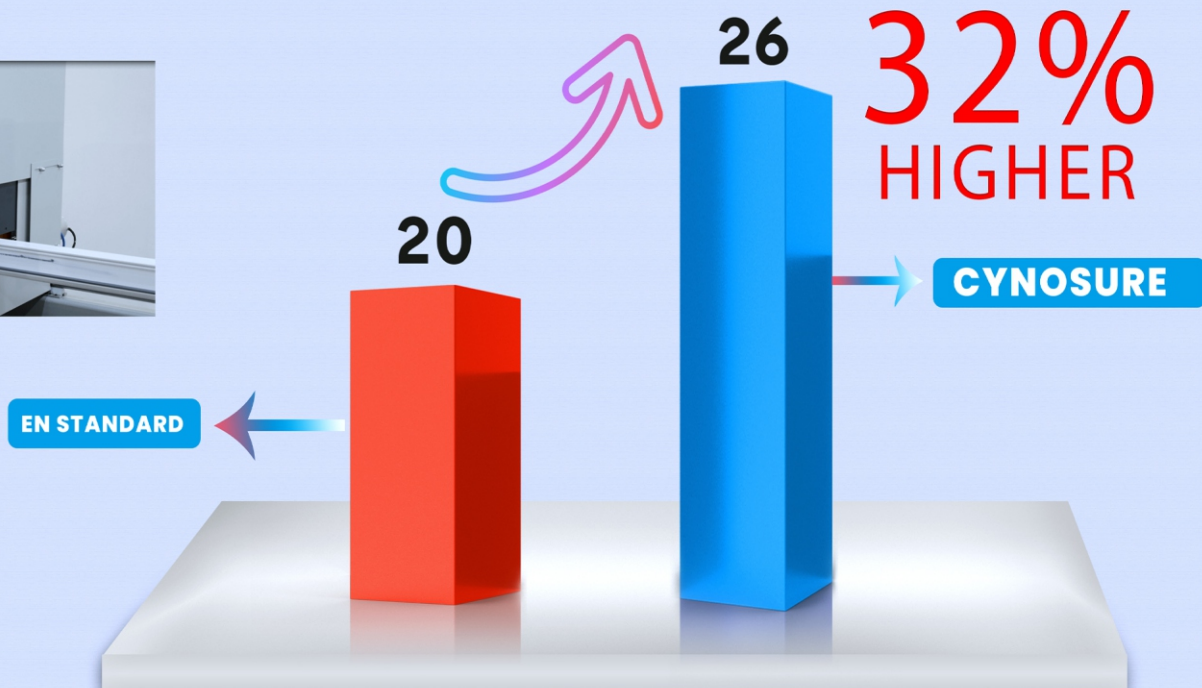
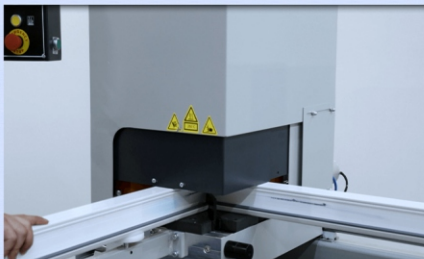
To verify that welding quality and material formulation meet Indian durability and safety requirements.

Consequence of Low Weld Strength:

Poor corner and joint stability.

Cracks or deformation during transportation and installation.

Reduced durability and higher risk of joint failure under load, wind pressure, or long-term use.



### CONSEQUENCES

Insufficient weld strength may result in cracks at welded corners and panel joints, particularly during window transit and installation, leading to premature failure and reduced product reliability.



## Vicat Softening Temperature (IS 13360 Part 6 Sec 1:1992)

### ● Definition

The Vicat Softening Temperature is the temperature at which a flat-ended needle penetrates 1 mm into the surface of a plastic specimen under a specified load, as per IS 13360.

### ● Test Principle

A specimen is placed under a 1 mm<sup>2</sup> needle.

A constant load of 10 N or 50 N is applied.

Heated at a controlled rate (50 °C/hr or 120 °C/hr).

The temperature at 1 mm penetration = VST value.



### ● Why It Matters

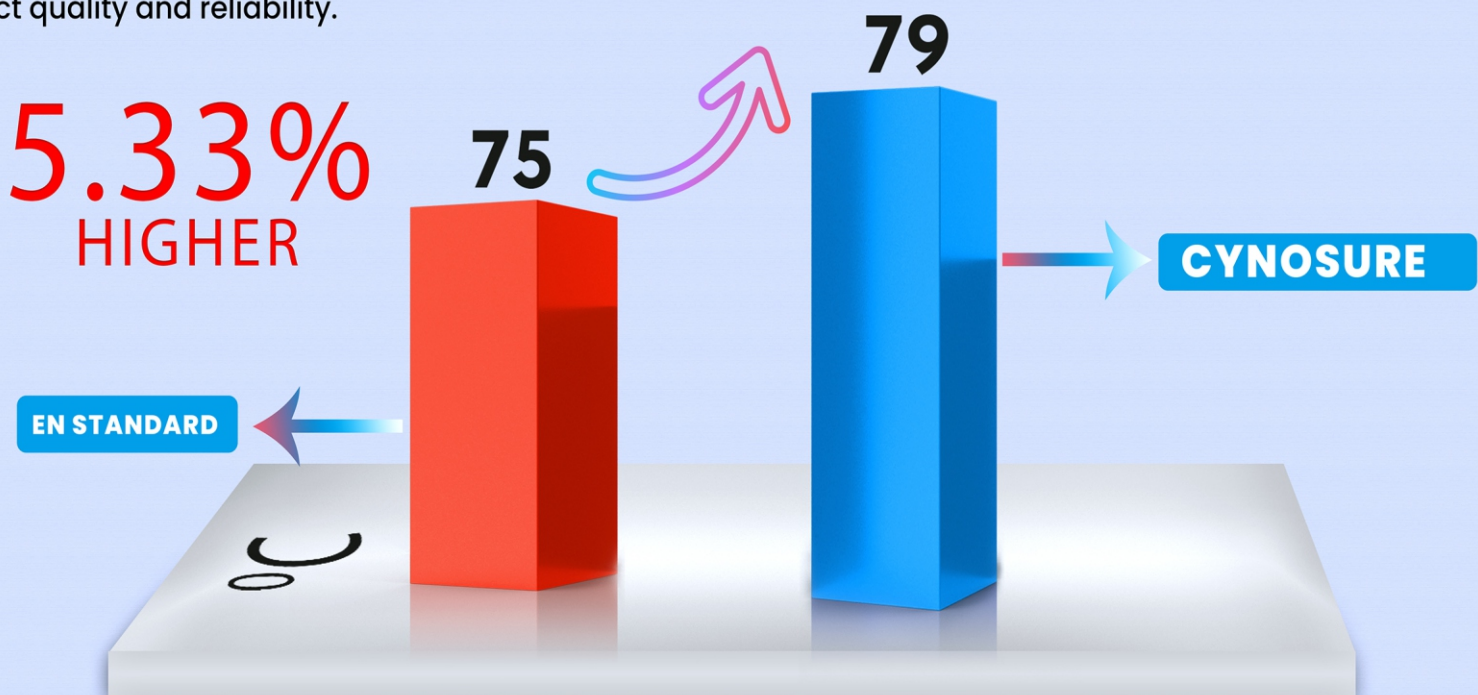
Ensures uPVC windows & doors resist deformation under heat and direct sunlight.

Higher VST = better thermal resistance & long-term durability.

Recommended: VST > 75 °C for tropical climates like India.

### ● In Short

VST indicates how much heat a uPVC profile can withstand before softening — a key benchmark of product quality and reliability.



### CONSEQUENCES

Low Vicat Softening Temperature (VST) indicates weak formulation strength, causing early deterioration. Windows may soften, crack, or degrade even under moderate heat.



## Flexural Modulus of Elasticity Test (IS 13360 Part 5/Sec 5:1992, ISO 178 Equivalent)

### Definition

The flexural modulus is the ratio of stress to strain when a uPVC specimen is bent under load. It measures the stiffness and resistance to bending of the material.

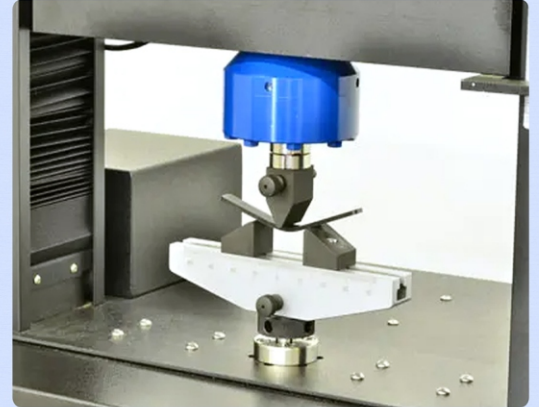
### Test Principle

A rectangular uPVC specimen is placed on two supports.

A load is applied at the center (three-point bending).

The specimen bends, and the stress-strain curve is recorded.

The slope of the curve = Flexural Modulus (MPa).



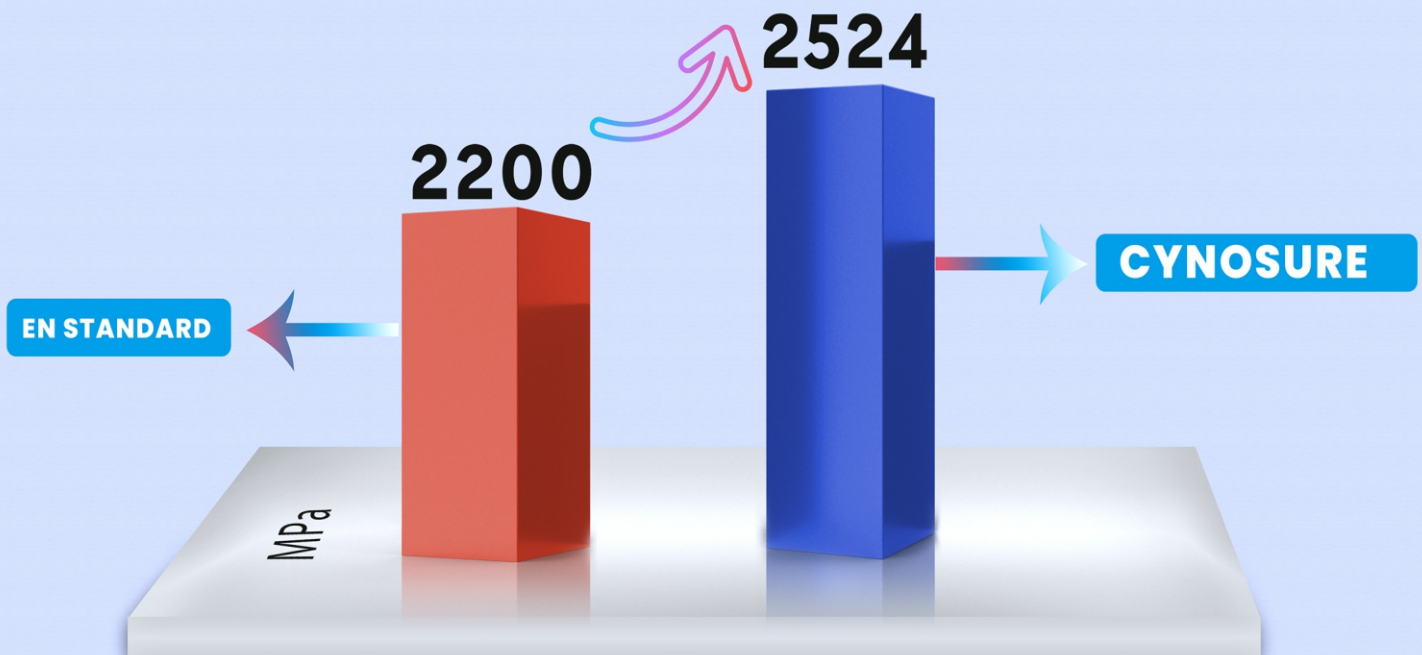
### Why It Matters

Higher Flexural Modulus = better rigidity, dimensional stability, and load-bearing capacity.

Ensures windows & doors do not deform under wind pressure or installation stress.

### In Short

Flexural Modulus shows how stiff and stable a uPVC profile is under bending loads, directly linked to strength and durability.



### CONSEQUENCES

Low Flexural Modulus means poor stiffness, causing windows to bend or deform under load. This leads to reduced strength and early structural failure.



## Charpy Impact Strength Test (ISO 179-1:2023)

### ● Definition:

Charpy Impact Strength is the measure of the energy absorbed by a material when it is struck by a swinging pendulum hammer. It represents the ability of uPVC profiles to resist sudden impact or shock loads, indicating their toughness and durability.

### ● Standard Reference:

The test is carried out as per ISO 179-1:2023 (equivalent to IS 13360 Part 5/Sec 7), which specifies the non-instrumented Charpy impact test method for determining the impact properties of plastics.

### ● Unit:

It is expressed in kilojoules per square meter (kJ/m<sup>2</sup>).

### ● Formula:

$$a_{cU} = \frac{E_c}{b \times h}$$

Where:

- $a_{cU}$  = Charpy impact strength (kJ/m<sup>2</sup>)
- $E_c$  = Energy absorbed by specimen (J)
- $b$  = Width of specimen (mm)
- $h$  = Thickness of specimen (mm)

In Simple Words:

Charpy Impact Strength (ISO 179-1) shows how tough or brittle a uPVC profile is when subjected to a sudden blow — higher values mean greater toughness and better resistance to cracking or breakage under impact.



### CONSEQUENCES

Low impact strength makes the material brittle, reducing its ability to absorb sudden shocks or loads. This increases the likelihood of cracks, chipping, or complete fracture of uPVC profiles under accidental impacts or harsh handling conditions.



## Heat Reversion Test (IS 16943:2018)

### ● Definition

Heat Reversion is the change in length (shrinkage) of a uPVC profile when it is exposed to heat in a controlled environment. This test checks the dimensional stability of uPVC profiles under high temperature conditions.

### ● Test Method

A profile specimen of specified length is cut.

Kept in a hot air oven at  $100 \pm 2^\circ\text{C}$  for 1 hour.

After cooling to room temperature, the change in length is measured.

### ● Reversion % Formula:

$$\text{Reversion}(\%) = \frac{L_0 - L_1}{L_0} \times 100$$

Where:

$L_0$  = Original Length (mm)

$L_1$  = Length After heating (mm)

### Requirement as per IS 16943:2018

Heat Reversion shall not exceed 2% for uPVC profiles.



### CONSEQUENCES

IF HEAT REVERSION IS HIGH, PROFILES MAY WARP OR SHRINK AFTER INSTALLATION.  
THIS LEADS TO POOR FITTING, GAPS, AND REDUCED SERVICE LIFE OF WINDOWS/DOORS.



**TEST REPORT****Report No. : MAN:HL:1548004308****ISSUE DATE: 25-Jun-2024****ASSRE PLASTO WORLD INT. PVT. LTD.**BALIADANGA, NH 34, P.O-BALLADANGA, P.S- KALIACHAK,  
DISTT- MALDA,(WEST BENGAL)- 732201  
INDIA**CONTACT PERSON: MD.ARIF****THE FOLLOWING SAMPLE(S) WAS/WERE SUBMITTED AND IDENTIFIED BY/ON BEHALF OF THE CUSTOMER AS :**

|                             |                           |
|-----------------------------|---------------------------|
| <b>SAMPLE DESCRIPTION</b>   | ASSRE PLASTO UPVC PROFILE |
| <b>COLOUR</b>               | WHITE                     |
| <b>STYLE NO.</b>            | POWDER                    |
| <b>ARTICLE NO./REF. NO.</b> | 1                         |

**LAB PROVIDED DETAILS:****CONDITION OF SAMPLE** COMPLETE AND OK**THE LOCATION OF PERFORMANCE OF THE LABORATORY ACTIVITIES:** SGS GURUGRAM LABORATORY**SAMPLE RECD ON** 05-Jun-2024 **TESTING PERIOD :** 10-Jun-2024 - 25-Jun-2024**SUMMARY OF TEST RESULTS:**

| TESTS                                                                                                                                                                                                                                                                                                                                         | PASS | FAIL | REMARKS |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|------|---------|
| RoHS Directive (EU) 2015/863 amending Annex II to Directive 2011/65/EU- Cadmium, Lead, Mercury, Hexavalent chromium, Polybrominated biphenyls (PBBs), Polybrominated diphenyl ethers (PBDEs) and Phthalates such as Bis(2-ethylhexyl) phthalate (DEHP), Butyl benzyl phthalate (BBP), Dibutyl phthalate (DBP) and Diisobutyl phthalate (DIBP) | P    |      |         |

**Remarks:** P=Pass

F=Fail

**TEST(S) RESULT & METHOD:** PLEASE REFER TO NEXT PAGE(S). RESULTS APPLY TO THE SAMPLE AS RECEIVED**Per Pro SGS India Pvt. Ltd.****SANDIP BHUSHAN**  
**TECHNICAL MANAGER****Authorized Signatory-Mechanical**Email your Test Report Related Enquiries at [Feedback.HLT@sgs.com](mailto:Feedback.HLT@sgs.com)

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No decision rule is applied, when comparing the measurement result (s) with the applicable limit(s) according to the specification in the respective standard or as shared by the customer.

Connectivity and product, Testing Laboratory, Plot no. 21, Sector 3, IMT Manesar, Gurugram District, Haryana- 122050 (India) t: (+91-124 678 7600

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**TEST REPORT****Report No. : MAN:HL:1548004308****ISSUE DATE: 25-Jun-2024**

NON ACCREDITED TEST(S)

**Test Part Description:**

| Product No. | Sample No. | Material Description      | Remarks |
|-------------|------------|---------------------------|---------|
| 1           | 1          | ASSRE PLASTO UPVC PROFILE | --      |

**Remarks:**

- (1) 1mg/kg=0.0001%
- (2) MDL = Method Detection Limit
- (3) ND = Not Detected (<MDL)
- (4) - = not regulated

**RoHS Directive (EU) 2015/863 amending Annex II to Directive 2011/65/EU****Test Method:**

- (1) With reference to IEC 62321-5:2013, determination of Cadmium by ICP-OES.
- (2) With reference to IEC 62321-5:2013, determination of Lead by ICP-OES.
- (3) With reference to IEC 62321-4:2013+A1:2017, determination of Mercury by ICP-OES.
- (4) With reference to IEC 62321-7-1:2015, determination of Hexavalent Chromium by Colorimetric Method using UV-Vis and/or with reference to IEC 62321-5:2013, determination of Chromium by ICP-OES.
- (5) With reference to IEC 62321-6:2015, determination of PBBs and PBDEs by GC-MS.
- (6) With reference to IEC 62321-8:2017, determination of phthalates by GC-MS.

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**TEST REPORT****Report No. : MAN:HL:1548004308****ISSUE DATE: 25-Jun-2024**

NON ACCREDITED TEST(S)

**TEST RESULTS:**

| Test Item(s):                       | Unit  | Results     | MDL | Limit |
|-------------------------------------|-------|-------------|-----|-------|
| Cadmium(Cd)                         | mg/kg | n.d.        | 5   | 100   |
| Lead (Pb)                           | mg/kg | 8.5         | 5   | 1000  |
| Mercury (Hg)                        | mg/kg | n.d.        | 5   | 1000  |
| Hexavalent Chromium (CrVI)          | mg/kg | n.d.        | 8   | 1000  |
| <b>Sum of PBBs</b>                  | mg/kg | <b>n.d.</b> | -   | 1000  |
| Monobromobiphenyl                   | mg/kg | n.d.        | 50  | -     |
| Dibromobiphenyl                     | mg/kg | n.d.        | 50  | -     |
| Tribromobiphenyl                    | mg/kg | n.d.        | 50  | -     |
| Tetrabromobiphenyl                  | mg/kg | n.d.        | 50  | -     |
| Hexabromobiphenyl                   | mg/kg | n.d.        | 50  | -     |
| Pentabromobiphenyl                  | mg/kg | n.d.        | 50  | -     |
| Heptabromobiphenyl                  | mg/kg | n.d.        | 50  | -     |
| Octabromobiphenyl                   | mg/kg | n.d.        | 50  | -     |
| Nonabromobiphenyl                   | mg/kg | n.d.        | 50  | -     |
| Decabromobiphenyl                   | mg/kg | n.d.        | 50  | -     |
| <b>Sum of PBDEs</b>                 | mg/kg | <b>n.d.</b> | -   | 1000  |
| Monobromodiphenyl ether             | mg/kg | n.d.        | 50  | -     |
| Dibromodiphenyl ether               | mg/kg | n.d.        | 50  | -     |
| Tribromodiphenyl ether              | mg/kg | n.d.        | 50  | -     |
| Tetrabromodiphenyl ether            | mg/kg | n.d.        | 50  | -     |
| Pentabromodiphenyl ether            | mg/kg | n.d.        | 50  | -     |
| Hexabromodiphenyl ether             | mg/kg | n.d.        | 50  | -     |
| Heptabromodiphenyl ether            | mg/kg | n.d.        | 50  | -     |
| Octabromodiphenyl ether             | mg/kg | n.d.        | 50  | -     |
| Nonabromodiphenyl ether             | mg/kg | n.d.        | 50  | -     |
| Decabromodiphenyl ether             | mg/kg | n.d.        | 50  | -     |
| Dibutyl phthalate (DBP)             | mg/kg | n.d.        | 100 | 1000  |
| Butyl benzyl phthalate (BBP)        | mg/kg | n.d.        | 100 | 1000  |
| Bis (2-ethylhexyl) phthalate (DEHP) | mg/kg | n.d.        | 100 | 1000  |
| Diisobutyl Phthalates (DIBP)        | mg/kg | n.d.        | 100 | 1000  |

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# TEST REPORT

Report No. : MAN:HL:1548004308

ISSUE DATE: 25-Jun-2024



NON ACCREDITED TEST(S)

## Not Notes:

- (1) The maximum permissible limit is quoted from RoHS Directive (EU) 2015/863.
- (2) IEC 62321 series is equivalent to EN 62321 series.  
[https://www.cenelec.eu/dyn/www/f?p=104:30:1742232870351101:::FSP\\_ORG\\_ID,FSP\\_LANG\\_ID:1258637,25](https://www.cenelec.eu/dyn/www/f?p=104:30:1742232870351101:::FSP_ORG_ID,FSP_LANG_ID:1258637,25)
- (3) The restriction of DEHP, BBP, DBP and DIBP shall apply to medical devices, including in vitro medical devices, and monitoring and control instruments, including industrial monitoring and control instruments, from 22 July 2021.
- (4) Test has been sub-contracted to ISO/IEC 17025 accredited laboratory.
- (5) Testing has been performed as per customer request.

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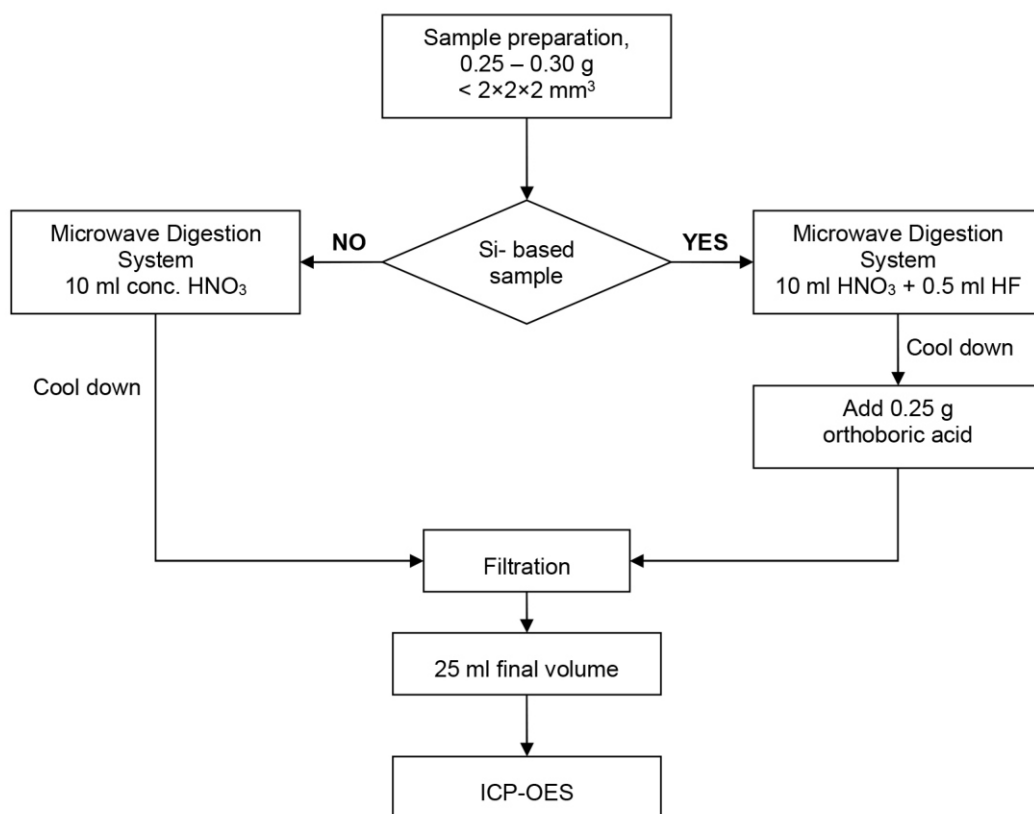
Report No. : MAN:HL:1548004308

ISSUE DATE: 25-Jun-2024



NON ACCREDITED TEST(S)

### Process Flow for analysis of metal contents in plastics, metals and electronic components sample



Analyzed By: Mahesh Panday

Checked By: Bikram Deo Ohdar

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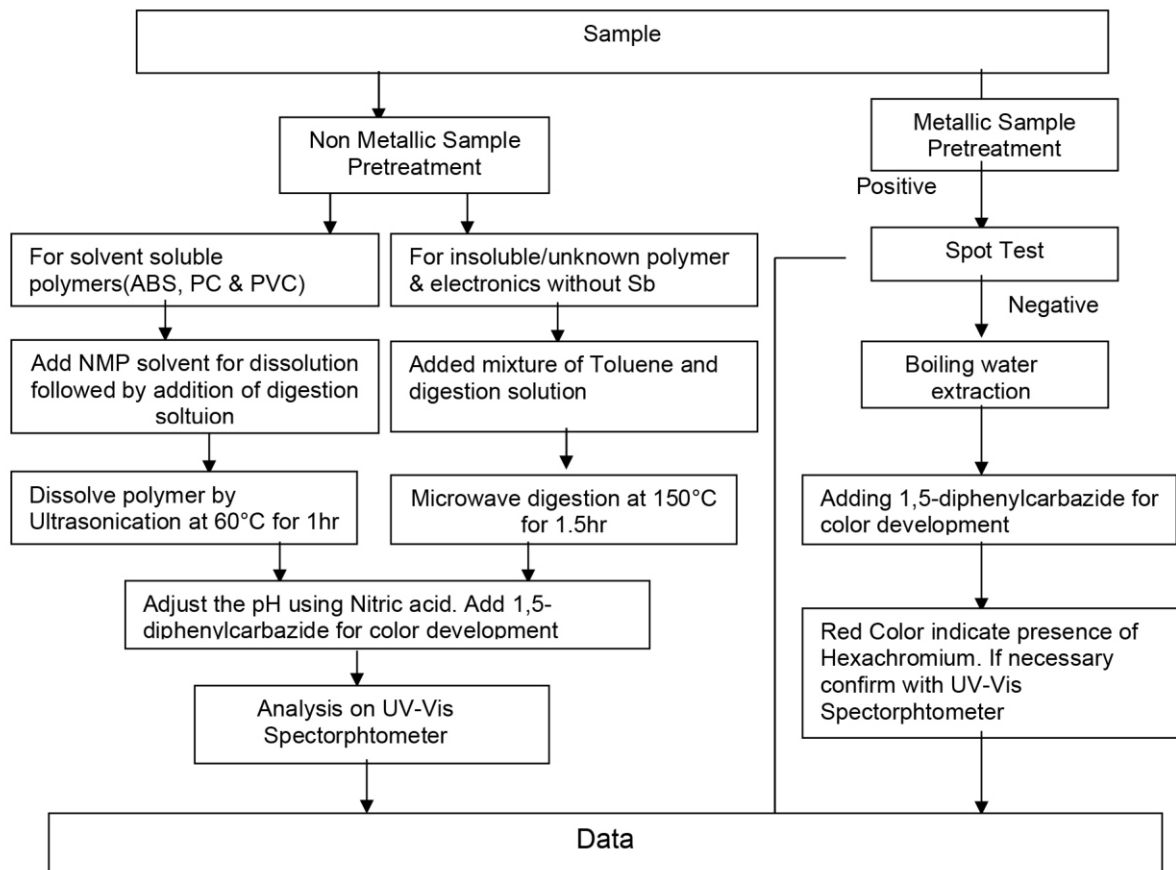
Report No. : MAN:HL:1548004308

ISSUE DATE: 25-Jun-2024



NON ACCREDITED TEST(S)

## Process Flow for analysis of Hexachromium contents in plastics, metals and electronic components sample



Analyzed By: Mahesh Pandey

Checked By: Bikram Deo Ohdar

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# TEST REPORT

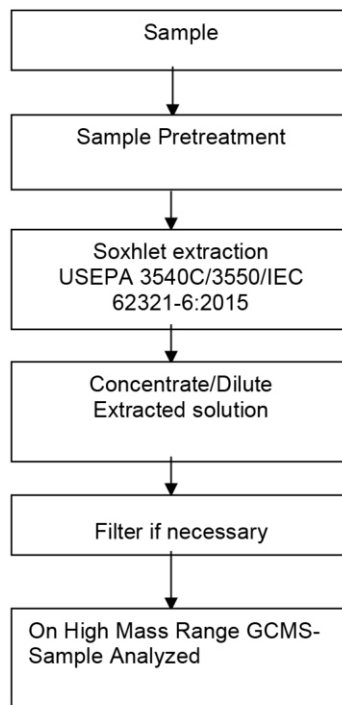
Report No. : MAN:HL:1548004308

ISSUE DATE: 25-Jun-2024



NON ACCREDITED TEST(S)

## Process Flow for analysis of Flame Retardants in plastics, metals and electronic components sample



Analyzed By : Ashish Shrivastava

Checked By : Vijai Chauhan

JOE No. : 2448802241

400267946

Page 7 of 9

Control No.: 1548004786

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SGS India Pvt. Ltd

Connectivity and product, Testing Laboratory, Plot no. 21, Sector 3, IMT Manesar, Gurugram District, Haryana- 122050 (India) t: (+91-124 678 7600

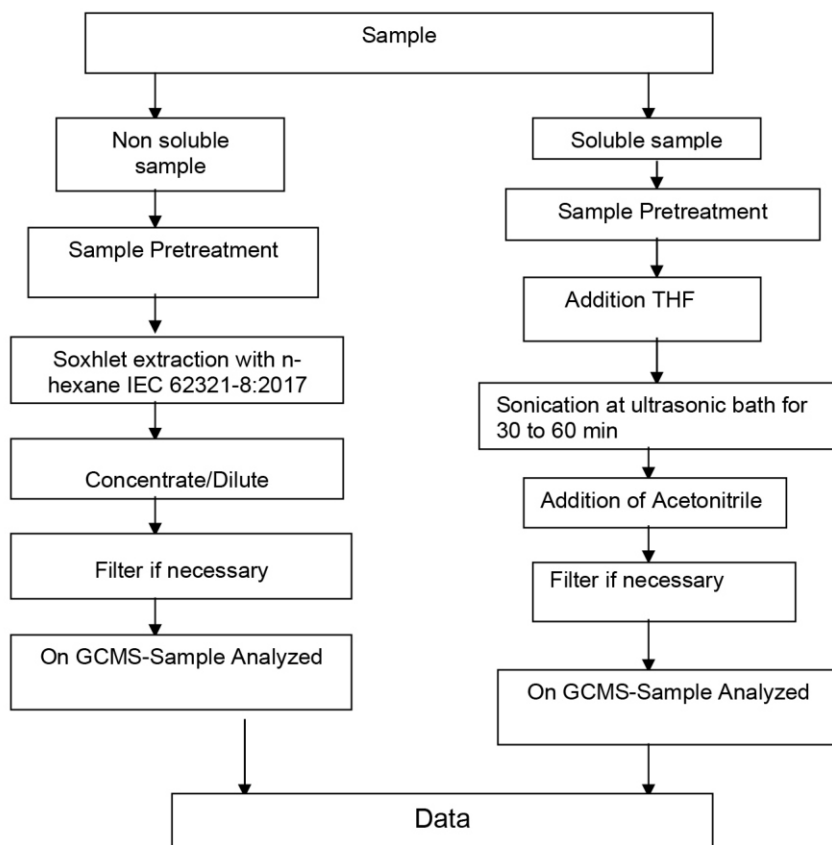
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NON ACCREDITED TEST(S)

**Process Flow for analysis of Phthalates in Electrotechnical Product As per soxhelt Extraction or THF Extraction:**



Analyzed By: Ashish Shrivastava

Checked By: Vijai Chauhan



## TEST REPORT

Report No. : MAN:HL:1548004308

ISSUE DATE: 25-Jun-2024



Sample as Received



\*\*\*\*\* END OF REPORT\*\*\*\*\*

JOE No. : 2448802241

400267946

Page 9 of 9

Control No.: 1548004786

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SGS India Pvt. Ltd

Connectivity and product, Testing Laboratory, Plot no. 21, Sector 3, IMT Manesar, Gurugram District, Haryana- 122050 (India) t: (+91-124 678 7600

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**CIPET सिपेट**  
probe . perform . practice . plastics

## सिपेट: सेंटर फॉर स्किलिंग एण्ड टेक्निकल सपोर्ट (सी एस टी एस)

रसायन और पेट्रो रसायन विभाग, रसायन एवं उर्वरक मंत्रालय, भारत सरकार  
सिटी सेंटर, डाकघर - देभोग, हल्दिया, जिला - पूर्व मेदिनीपुर, पिन - 721657 (प. बं.)

**CIPET: CENTER FOR SKILLING AND TECHNICAL SUPPORT (CSTS)**

Department of Chemicals & Petrochemicals, Ministry of Chemicals & Fertilizers, Govt. of India  
City Center, P.O.- Debhog, Haldia, Purba Medinipur, Pin- 721657, West Bengal

मुख्यालय: गिन्दी, चेन्नई - 600 032 Head Office: Guindy, Chennai - 600 032



फोन / Phone: 03224-255444, 255404, 255534 फैक्स / Fax: 03224-253016 ई-मेल / E-mail: haldia@cipet.gov.in/cipet.haldia@gmail.com वेबसाइट / website : https://www.cipet.gov.in

सन्दर्भ सं सिपेट - हलदिया/टेस्टिंग/2024 - 2025 /

Ref.: CIPET - HAL / Testing / 2024 - 2025 / 752

दिनांक:-09-08-2024

Date:- 09-08-2024

सेवा मे,

To,

ASSRE Plasto World International Pvt. Ltd.

Baliadanga , N.H. 34, P.O.- Baliadanga ;

P.S. - Kaliachak ; Dist - Malda, Baliadanga,

Maldah, West Bengal, 732 201

महोदय/ Dear Sir,

विशय :-परिक्षण पत्र भेजने के सन्दर्भ मे.

Sub-Testing of UPVC Window and Door Profile -reg.

आपका पत्रांक: email, दिनांक: May 13, 2024

Ref No.: email, Dated: May 13, 2024

कर्म आदेश सन्दर्भ सं: PTC/07-24/526

Our Work Order Ref . PTC/07-24/526

उपरोक्त विशय के सन्दर्भ में कृपया इस पत्र के साथ संलग्न परिक्षण पत्र संख्या: 00000729; दिनांक : 09-08-2024 प्राप्त करें.

With reference to the above cited subject, please find enclosed here Test Report No. 00000729; Date. 09-08-2024.

धन्यवाद

Thanking you,

भवदीय

Yours sincerely,

प्रधान निदेशक एवं प्रमुख

Principal Director & Head

संलग्न: उपरोक्त

Encl: As above

केन्द्र : अहमदाबाद, अमृतसर, औरंगाबाद, अगरतला, बही, बालासोर, बेंगलुरु, भोपाल, भुवनेश्वर, चंद्रपुर, चेन्नई, गुरुग्राम, देहरादून, गुवाहटी, ग्वालियर, हैदराबाद, हाजीपुर, हल्दिया, इम्फाल, जयपुर, कोच्चि, लखनऊ, मदुरई, मुरथल, मैसूरु, रायपुर, राँचि, बलसाड, एवं, विजयवाडा

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सेन्ट्रल इंस्टिट्यूट ऑफ पेट्रोसायन इंजीनियरिंग एण्ड टेक्नॉलाजी  
(रसायन एवं उर्वरक मंत्रालय, भारत सरकार)

**CENTRAL INSTITUTE OF PETROCHEMICALS ENGINEERING & TECHNOLOGY**  
(Ministry of Chemicals and Fertilizers, Govt. of India)  
City Centre, P.O.-Debhog, Haldia, PIN-721657, (W.B.)  
Phone : 03224-255534, 255404, Fax : 91-3224-253016  
E-mail : cipet.haldia@gmail.com



क्र./No. 36407

**PLASTIC TESTING CENTRE  
TEST CERTIFICATE**

Issued to : ASSRE Plasto World International Pvt. Ltd  
Baliadanga, N.H. 34, P.O.- Baliadanga ;  
P.S. - Kaliachak ; Dist - Malda, Baliadanga,  
Maldah, West Bengal, 732 201

Test Report No : 00000729  
Date : 09-08-2024  
Date (s) of Performance of test:  
01-08-2024 to 08-08-2024  
Page 1 of 2

Your Ref : email, Dated: May 13, 2024  
Our Work Order Ref. No. PTC/07-24/526

**TEST REPORT AS PER CUSTOMER REQUEST**

**PART A : PARTICULARS OF SAMPLE SUBMITTED**

|                                           |                                                        |
|-------------------------------------------|--------------------------------------------------------|
| Nature of Sample                          | : UPVC Window and Door Profile as stated by the party. |
| Grade / Varity / type / Size / Class etc. | : Nil                                                  |
| Brand name, if any                        | : Nil                                                  |
| Declared values, if any                   | : Nil                                                  |
| Code No.                                  | : Nil                                                  |
| Batch No. and date of manufacture         | : Nil                                                  |
| Quantity                                  | : 04 nos. sample as submitted by the party.            |
| Mode of Packing                           | : Wrapped with polyethylene sheet & newspaper.         |
| Date of receipt of sample                 | : 27-07-2024                                           |
| Sealed or not                             | : Sealed.                                              |
| Any other information                     | : Nil                                                  |

**PART B: SUPPLEMENTARY INFORMATIONS**

|                                                                                                                                                                                                    |                         |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|
| a) Reference to sampling procedure                                                                                                                                                                 | : Supplied by the party |
| b) Supporting documents for the measure-<br>ments taken and results derived like<br>graphs, tables, sketches and / or photo-<br>graphs as appropriate to test report,<br>if any ( to be attached ) | : Nil                   |
| c) Deviation from the test methods as<br>prescribed in relevant ISS / Work<br>instructions, if any                                                                                                 | : Nil                   |

*Handwritten signature*

सिपेट हल्दिया  
CIPET HALDIA

Continuation Sheet



Test Report No : 00000729  
Date : 09-08-2024  
Page 2 of 2

PART C : TEST RESULTS

| Sl No. | Sample Details               | Name of the Test   | Test Method | Unit | Results Obtained |
|--------|------------------------------|--------------------|-------------|------|------------------|
| 01     | UPVC Window and Door Profile | Density            | ASTM D 792  | g/cc | 1.52             |
| 02     |                              | Hardness (Shore D) | ASTM D 2240 | ---- | 81               |

PART D: REMARKS

- NB: i) The results stated above related only to the items tested.  
ii) This Test Certificate shall not be reproduced except in full without the written approval.  
iii) Details of test subcontracted: Nil  
iv) This Test Report / Certificate is issued only for the samples submitted to CIPET.  
v) The quality of the subsequent production lot has to be ensured by the purchaser.  
vi) This Test Certificate relates only to samples / items submitted to the laboratory for test.

Reviewed by

  
Chameli Mallik  
Sr. Technical Assistant (Testing)  
प्राधिकृत हस्ताक्षरकारी  
AUTHORISED SIGNATORY

  
Mrunmayee Parua  
Sr. Technical Officer (Testing)  
प्राधिकृत हस्ताक्षरकारी  
AUTHORISED SIGNATORY





# Certificate

This is to Certify that  
**ASSRE PLASTO WORLD  
INTERNATIONAL PRIVATE LIMITED**

C/o Mahammad Rafajuddin Sekh, Baliadanga, NH-34,  
Kailachak, Malda, West Bengal - 732201, India

has been found in Compliance with requirements of

**Quality Management System**

**ISO 9001:2015**

for the following scope:

**Design, Extrusion, Fabrication & Installation and supply of UPVC profiles,  
Windows and Doors**

Certificate No. : QCC/70F4/0724

Issue Date : 06-July-2024

1st Surveillance Due : 05-June-2025

2nd Surveillance Due : 05-June-2026

Expiry Date : 05-July-2027

To check this certificate status visit:  
"<https://qccertification.com/Client.aspx>"

Authorised Signature

**Quality Control Certification**

2nd Floor, Aman Market,  
Narela Mandi, Delhi - 110 040, India  
Website: <https://qccertification.com>



**EAS is member of International Accreditation Forum (IAF)**

"Quality Control Certification (QCC)" accredited by "Ethiopian Accredited Service (EAS)".  
This certificate remains the property of "QCC" to whom it must be returned on request.





# Certificate

This is to Certify that  
**ASSRE PLASTO WORLD  
INTERNATIONAL PRIVATE LIMITED**

C/o Mahammad Rafajuddin Sekh, Baliadanga, NH-34,  
Kailachak, Malda, West Bengal - 732201, India

has been found in Compliance with requirements of  
**Environmental Management System  
ISO 14001:2015**

for the following scope:

**Design, Extrusion, Fabrication & Installation and supply of UPVC profiles,  
Windows and Doors**

Certificate No. : QCC/70F6/0724

Issue Date : 06-July-2024

1st Surveillance Due : 05-June-2025

2nd Surveillance Due : 05-June-2026

Expiry Date : 05-July-2027

To check this certificate status visit:  
"<https://qccertification.com/Client.aspx>"

Authorised Signature

**Quality Control Certification**

2nd Floor, Aman Market,  
Narela Mandi, Delhi - 110 040, India

Website: <https://qccertification.com>



Certification Body EMS 0002



**EAS is member of International Accreditation Forum (IAF)**

"Quality Control Certification (QCC)" accredited by "Ethiopian Accredited Service (EAS)".  
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# SHRIRAM INSTITUTE FOR INDUSTRIAL RESEARCH

(A unit of Shriram Scientific and Industrial Research Foundation)

19, University Road, Delhi - 110007 (India)  
An ISO - 9001, 14001 & 45001 Certified Institute

Website : [www.shriraminstitute.org](http://www.shriraminstitute.org)  
E-mail id : [customercare@shriraminstitute.org](mailto:customercare@shriraminstitute.org)  
[qad@shriraminstitute.org](mailto:qad@shriraminstitute.org)

## TEST REPORT

NO : C1/0000362644

### Issued To :

Client Code : (MALD01A3202)  
ASSRE PLASTO WORLD INTERNATIONAL  
PRIVATE LIMITED,  
C/O MAHAMMAD RAFAJUDDIN SEKH,  
BALIADANGA NH-34, KAILACHAK,  
MALDA  
MALDA DISTT  
WEST BENGAL-732201  
Kind Attn: MD. ARIF

Date of issue : 19-06-2024  
Job No : 2405-1-141-2363  
Booking No : RG2425/1/1950  
Booking Date : 29-05-2024  
Customer Ref No. : E MAIL  
Customer Ref Dt. : 20-05-2024  
Location : Laboratory

Job No- 2405-1-141-2363

ONE SAMPLE (QUANTITY- 10 NO.) DESCRIBED AS UPVC WINDOW AND DOOR PROFILE, MAKE ASSRE PLASTO, WAS RECEIVED.

"THE SAMPLING WAS NOT CARRIED OUT BY SHRIRAM INSTITUTE FOR INDUSTRIAL RESEARCH. THE SAMPLE DESCRIPTION PROVIDED IN THE TEST CERTIFICATE ARE BASED ON DECLARATION BY THE CUSTOMER."

| S. No. | Tests                                                                                    | Results                                                                                                                                                      | Protocol Adopted        |
|--------|------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|
| 1      | Tensile Strength, MPa                                                                    | 43                                                                                                                                                           | ASTM D 638-14           |
| 2      | Elongation at break, %                                                                   | 128                                                                                                                                                          | ASTM D 638-14           |
| 3      | Vicat Softening temperature, °C                                                          | 79                                                                                                                                                           | ASTM D 1525-17          |
| 4      | Heat reversion, %                                                                        | 0.5                                                                                                                                                          | EN 12608 : 16           |
| 5      | Density at 27°C, g/cc                                                                    | 1.50                                                                                                                                                         | ASTM D 792-20           |
| 6      | Flexural Strength, MPa                                                                   | 49                                                                                                                                                           | ASTM D 790-17           |
| 7      | Flexural Modulus of Elasticity, Mpa                                                      | 2524                                                                                                                                                         | ASTM D 790-17           |
| 8      | Heat ageing at 150°C for 30 minutes                                                      | Sample does not show any blisters, cavities or cracks on any of the surfaces (inner and outer ) of the profile and of any delamination in the cross section. | EN 12608 : 16           |
| 9      | Resistance to impact by falling mass @ - 10°C for 1 hr Falling mas- 1Kg & from Height-1m | No brittle failure observed                                                                                                                                  | EN 12608 : 16           |
| 10     | Izod Impact Strength, J/m                                                                | 1010                                                                                                                                                         | ASTM D 256-18           |
| 11     | Hardness Shore D                                                                         | 81                                                                                                                                                           | ASTM D 2240-20          |
| 12     | Limiting Oxygen Index, %                                                                 | 45                                                                                                                                                           | ASTM D 2863-19          |
| 13     | Thermal Conductivity, W/mK                                                               | 0.234                                                                                                                                                        | ISO 22007 (Part -II):15 |
| 14     | Lead Content, %                                                                          | Nil                                                                                                                                                          | SRI/SOP/004             |
| 15     | Colour fastness (Artificial weathering with blue wool standard), Rating                  | 6                                                                                                                                                            | ASTM G 155 : 21         |

Reviewed and Authorized by  
EMPLOYEE CODE: ( 1159 )

GC-01(Rev-05)  
Note: The results relate only to the items tested / calibrated above.  
Scanned copies/photocopies or any other copies should be authenticated by reference to the original report.

SRI-C1 (Rev. 05)

Phone : 91-11-35200445, 35200499

Fax : 91-11-35200455

See overleaf for terms & conditions





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(A unit of Shriram Scientific and Industrial Research Foundation)

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E-mail id : [customercare@shriraminstitute.org](mailto:customercare@shriraminstitute.org)  
[qad@shriraminstitute.org](mailto:qad@shriraminstitute.org)

## TEST REPORT

NO : C1/0000362644

|    |                                                      |      |                      |
|----|------------------------------------------------------|------|----------------------|
| 16 | Resistance to sulphuric acid<br>(Weight increase, g) | 0.12 | IS 12235-Part-7 : 19 |
| 17 | Flammability, Grade<br>(Vertical burning)            | V0   | UL-94                |

Note: Charpy Impact test result will be reported later.

Date of Receipt: 29.05.2024

Date of Start: 30.05.2024

Date of Completion: 19.06.2024

End of report



Reviewed and Authorized by  
EMPLOYEE CODE: ( 2157 )

GC-01(Rcv-05)

2/2

Note: The results relate only to the items tested / calibrated above.  
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SRI-C1 (Rev. 05)

Phone : 91-11-35200445, 35200499

Fax : 91-11-35200455

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E-mail id : [customercare@shriraminstitute.org](mailto:customercare@shriraminstitute.org)  
[qad@shriraminstitute.org](mailto:qad@shriraminstitute.org)

## TEST REPORT

NO : C1/0000364431

### Issued To :

Client Code : (MALD01A3202)  
ASSRE PLASTO WORLD INTERNATIONAL  
PRIVATE LIMITED,  
C/O MAHAMMAD RAFAJUDDIN SEKH,  
BALIADANGA NH-34, KAILACHAK,  
MALDA  
MALDA DISTT  
WEST BENGAL-732201  
Kind Attn: MD. ARIF

Date of issue : 08-07-2024  
Job No : 2405-1-141-2363  
Booking No : RG2425/1/1950  
Booking Date : 29-05-2024  
Customer Ref No. : E MAIL  
Customer Ref Dt. : 20-05-2024  
Location : Laboratory

Job No- 2405-1-141-2363

ONE SAMPLE (QUANTITY- 10 NO.) DESCRIBED AS UPVC WINDOW AND DOOR PROFILE, MAKE ASSRE PLASTO, WAS RECEIVED.

"THE SAMPLING WAS NOT CARRIED OUT BY SHRIRAM INSTITUTE FOR INDUSTRIAL RESEARCH. THE SAMPLE DESCRIPTION PROVIDED IN THE TEST CERTIFICATE ARE BASED ON DECLARATION BY THE CUSTOMER."

Supplementary report of report no. C1/0000362644 dated on 19.06.2024.

| S. No. | Tests                                            | Results | Protocol Adopted |
|--------|--------------------------------------------------|---------|------------------|
| 1      | Charpy Impact test, $\text{kJ/m}^2$<br>(Notched) | 73.37   | ISO 179-1:2023   |

Date of Receipt: 29.05.2024

Date of Start: 30.05.2024

Date of Completion: 08.07.2024

End of report

Reviewed and Authorized by  
EMPLOYEE CODE: ( 2159 )

GC-01(Rev-05)

1/1

Note: The results relate only to the items tested / calibrated above.

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SRI-C1 (Rev. 05)

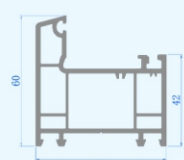
Phone : 91-11-35200445, 35200499

Fax : 91-11-35200455

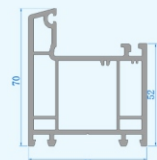
See overleaf for terms & conditions



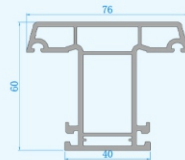
UPVC (Unplasticized Polyvinyl Chloride) profiles high-quality raw materials, including PVC resin, calcium carbonate, stabilizers, and other additives. These ingredients are mixed and melted at high temperatures in an extruder to form a uniform compound. The molten material is then shaped into the desired profile using precision molds, ensuring accuracy and durability. After cooling, the profiles are cut to size and undergo quality checks for strength, color, and finish. Finally, they are packed and distributed to fabricators for manufacturing windows and doors.



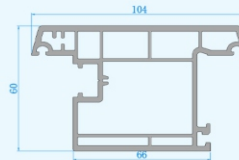
Casement outer Frame 60x60  
CSC101



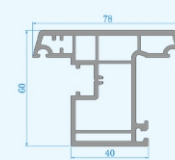
Casement outer Frame 60x70  
CSC102



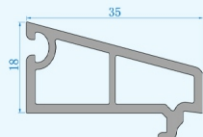
Casement T Mullion 60x76  
CSC103



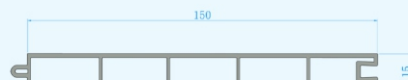
Casement Door sash 60x104  
CSC104



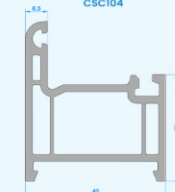
Casement window Sash 60x78  
CSC105



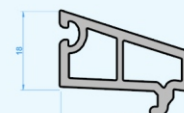
Casement Bead 35x18  
CSC106



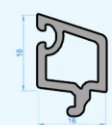
Pannel profile 15x150  
CSC107



Casement small frame 42x45  
CSC108



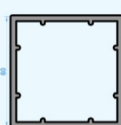
Casement Bead 29.5x18  
CSC109



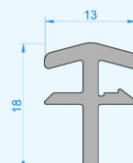
Casement Bead 16x18  
CSC110



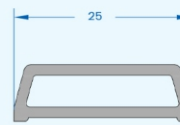
Connector- 25 track  
casement  
CSC111



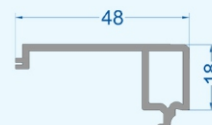
SQ Bay pole 60x60  
CSC112



T coupler 13x18  
CSC113

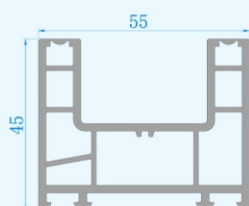


Georgian bar (25x8)  
CSC114

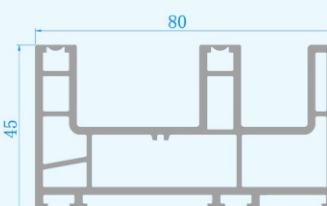


Louver Bead (48x18)  
CSC115

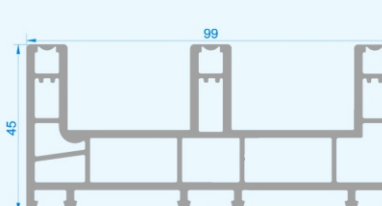
## CASEMENT PREMIUM SERIES



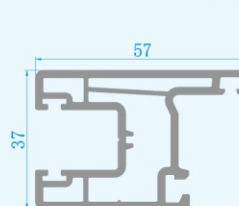
Sliding 2 track outer Frame 55x45  
CSS301



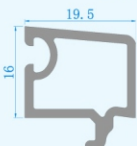
Sliding 2.5 track outer Frame 80x45  
CSS302



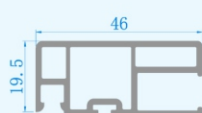
Sliding 3 track outer Frame 99x45  
CSS303



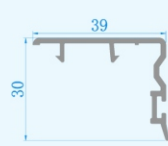
Sliding window sash 57x37  
CSS304



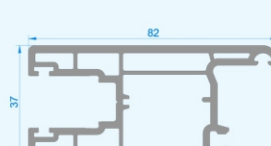
Sliding Bead 19.5 x 16  
CSS305



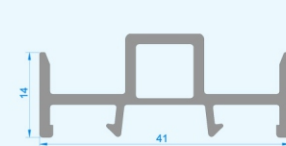
Sliding Mesh 46 x 20.5  
CSS306



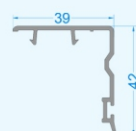
Sliding Interlock 39x30  
CSS307



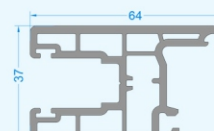
Sliding Door Sash 82x37  
CSS308



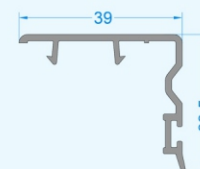
Sliding Inline adaptor 41x14  
CSS309



Sliding Interlock 39x42  
CSS310



Sliding Door Sash 64x37  
CSS311

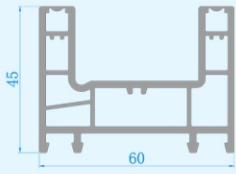


Sliding Interlock 39x33.5  
CSS312

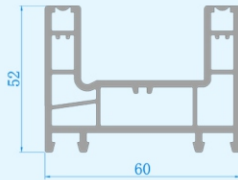
## SLIDING PREMIUM SERIES (55)



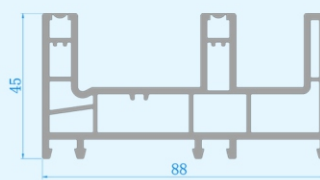
## SLIDING ROYAL SERIES (60)



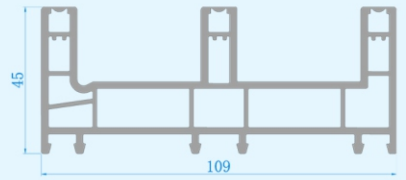
Sliding 2 track outer rame 60x45  
CSS201



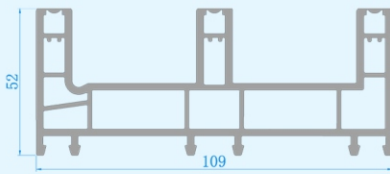
Sliding 2 track outer rame 60x52  
CSS201A



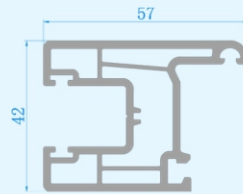
Sliding 2.5 track outer rame 88x45  
CSS202



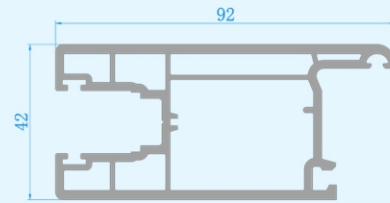
Sliding 3 track outer rame 109x45  
CSS203



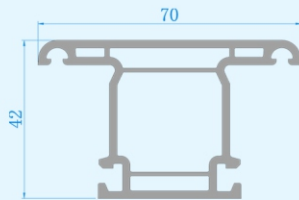
Sliding 3A track outer rame 109x52  
CSS203A



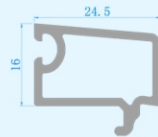
Sliding window Sash 57x42  
CSS204



Sliding window Sash 92x42  
CSS205



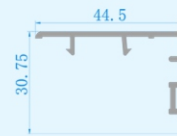
Sliding T Mullion 70x42  
CSS206



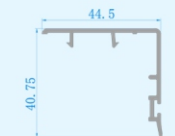
Sliding Bead 24.5x16  
CSS207



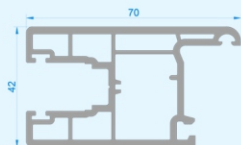
Sliding Bead 14.5x16  
(15mm Panel)  
CSS208



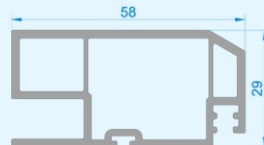
Sliding Interlock 44.5x30.75  
CSS209



Sliding Interlock 44.5x40.75  
CSS210



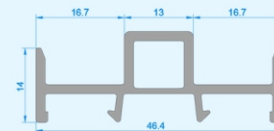
Sliding Intermediate Sash 70x42  
CSS211



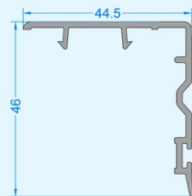
Sliding Mesh sash 58x29  
CSS212



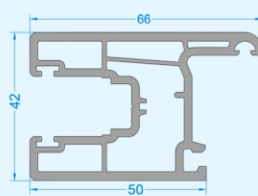
Sliding DG Bead 11.5x16  
CSS213



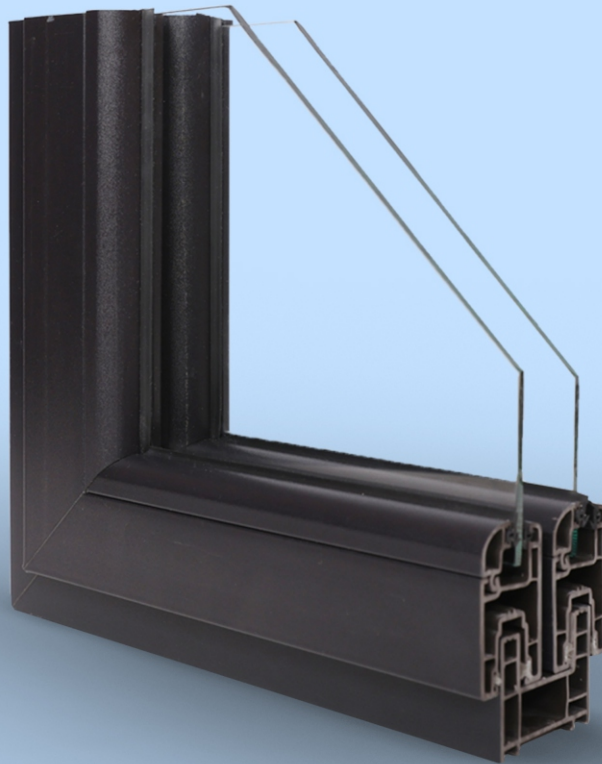
Inline Adaptor 14x46  
CSS214



Sliding Interlock 44.5x46  
CSS215



Sliding Intermediate Sash 42x66  
CSS216



" Strive not to be a **SUCCESS**,  
but rather to be of **VALUE**".

-Albert Einstein

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