Amendment Sheet BRL-K537

Processing of plastic foils xx-xx-2024

Adoption
Adopted by the Board of Experts KGWW d.d. xx-xx-2024

Binding declaration
This amendment has been declared binding by Kiwa as of xx-xx-2024

Validity of quality declarations
This amendment belongs to BRL-K537 dated 21-06-2019.
In any case, the quality declarations issued on the basis of that evaluation guideline will cease to be valid on xx-xx-2025.

Usage rights

Description of the amendment
Modifications to articles (4.4.2, 4.4.4, 4.4.7) as explained below:

4.4.2 Test welds

Proposal for amendment sheet

Test welds are necessary to check whether the conditions are correct prior to the start of welding.
Requirements:

- Dimensions of a test weld:
  - length and width of a test weld: should be in such a way that the part to be examined is sufficient to test (e.g. excluding influences such as start/stop effects);
  - Overlap: sufficient overlap to allow for the tests to be carried out;
- Frequency of tests should be done according to Table 2.

Tabel 2: Frequency of tests

Property	conform	Frequency (minimum)	
		On-site	In the factory
Visual	4.4.3	continuous	continuous
Peeling	4.4.4	at the start of work and at change of conditions	at the start of work
Tensile impact	4.4.5	at the start of work and at	at the start of work
Elongation at break	4.4.6	change of conditions	at the start of work
Tensile strength	4.4.7	at the start of work and at	at the start of work
Leak tightness	4.4.8	Channel welds – 100% Constructions of type X,I,.IA,IB: 100% (incl. repairs) Other: in accordance with the implementation plan	Not applicable

- The peel test is carried out on site with an adjustable constant tensile unit;
- The tensile impact test can be carried out both "on site" and "in the factory";
- Constructions with a type IIB or higher (Annex I): test welds and used test pieces should be marked and stored for a min of 1 week after completion of the project.

Original:
Test welds are necessary to check whether the conditions are correct prior to the start of welding.
Requirements:

- length of a test weld: ≥ 2 m;
- Length of qualification weld (equipment, method) : ≥ 4 m;
- Appearance of test weld: Regular;
- Dimensions in accordance with this chapter;
- Overlap: parallel foil, enclosed angle ≤ 10°;
- Mechanical properties in accordance with this chapter;
- Frequency of tests should be done according to Table 2.

Tabel 2: Frequency of tests

property	conform	frequency (minimum)
visueel	4.4.3	continuous
peeling	4.4.4	start of work; change of circumstances; completion of work; and at least 1x every 4 hours
Tensile impact t	4.4.5	1x every 4 hours
Elongation at break	4.4.6	1x every 4 hours
Tensile strength	4.4.7	1x every 4 hours
Leak tightness	4.4.8	Channel welds – 100% Constructions of the type X,I,. IA,IB (see Annex I): 100% (incl. repairs) Other: in accordance with the implementation plan 4.4.2

- The peel test is carried out on site with an adjustable constant tensile unit;
- The tensile impact test can be carried out both "on site" and "in the factory";
- Constructions with a type IIB or higher (Annex I): test welds and used test pieces should be marked and stored for a min of 1 week after completion of the project.
- If multiple types of film and/or multiple welding machines are used, the tests mentioned here applies to each of the combinations used.

4.4.4 Peeling properties

Proposal for the amendment sheet	*Original*
Method of determination All materials: • in accordance with NEN-EN 12316-2 and • Test piece: perpendicular to the weld length • Test piece width: 50 mm • Test Piece Length: > 100 + Weld Width • Clamping length between the clamps: 70 mm • Test speed: 100 mm/min • weld overlap with a length of 20 to 40 mm • Number of test pieces: ≥ 5	**Method of determination** All materials: • in accordance with NEN-EN 12316-2 and • Test piece: perpendicular to the weld length • Test piece width: 50 mm • Test Piece Length: > 100 + Weld Width • Clamping length between the clamps: 70 mm • Test speed: 100 mm/min • weld overlap with a length of 20 to 40 mm • Number of test pieces: > 5

4.4.7 Tensile strength

Proposal for the amendment sheet	*Original*

Method of determination
• See 4.4.6
  ○ If desired, a test piece may be "dissected" to a fixed number of tissue threads
  ○ The results are reduced to a tensile strength per 50 mm test piece width
• Test piece length: > 200 mm
• test piece perpendicular to the length of the weld
• Clamping length unwelded material: 200 mm
• Welding material clamping length: 200 mm + welding width
• Test speed: 100 mm/min
• Number of test pieces per weld : ≥ 5
• tensile strength specification in N / 50 mm test piece width.
	Method of determination
	• See 4.4.6
	  ○ If desired, a test piece may be "dissected" to a fixed number of tissue threads
	  ○ The results are reduced to a tensile strength per 50 mm test piece width
	• Test piece length: > 200 mm
	• test piece perpendicular to the length of the weld
	• Clamping length unwelded material: 200 mm
	• Welding material clamping length: 200 mm + welding width
	• Test speed: 100 mm/min
	• Number of test pieces per weld : > 5
	• tensile strength specification in N / 50 mm test piece width.