



Best Management Products, Inc.

Quality Control Procedures and Warranty

A. Raw Materials and Components

All raw materials and components receive two inspections prior to assembly. All raw materials arrive from vendors with certified dates and batch codes for all resin compounds which are checked with delivery manifest upon receipt. Raw materials receive a second check prior to manufacturing processes. All finished component subassemblies are inspected by the receiving department upon arrival from vendors. Subassembly components are checked again for size, fit, finish and quality upon assembly of installation kits and prior to assembly of finished product.

B. Manufacturing

1. Molding- All molds have individual numbers and are inspected and cleaned prior to each molding cycle. Ongoing part quality inspections can be traced to individual molds for quality assurance.
2. Inspection- Prior to finishing, all parts are inspected for voids, weight, thickness, and finish compliance.
 - a. Correctable defects are sent back for correction to build part weight and thickness, or receive cosmetic repairs to finish.
 - b. Any part found with a void or cure problem, or can not be repaired to meet 100% finished product standards is scrapped.
3. Composite Component Standards
"SNOUT" composite components are hand and chopper gun laminations of these properties:

Physical Properties of Unsaturated Polyester Resin Reinforced Laminates (33 / 66 Glass / Resin 1.5 oz mat Laminates .125 in.)

Flexural Strength (psi) ASTM D-790	27,100
Flexural Modulus (psi) ASTM D-790	1,157,000
Tensile Strength (psi) ASTM D-638	16,700
Tensile Modulus (psi) ASTM D-638	1,457,000
Tensile Elongation (%) ASTM D-638	1.54
Hardness, Barcol 934.1 ASTM D-2583	55 - 60

Physical Properties of ISO Gel Coat

	<u>Room Temperature Cured for 45 hours</u>	<u>Post Cured at 50° for 24 hours</u>
Tensile Strength	6,218	6,581
Elongation, %	2.70	1.90
Flexural Strength, psi	11,363	11,329
Heat Distortion, °F	0.544 x 10 ⁶	0.713 x 10 ⁶
Mandrel Flex, Mandrel diameter in Inches	--	1.0

4. Finishing- After molding and passing inspection, parts move to trimming and finishing.
 - a. Molding flash is trimmed around perimeter of part to a uniform and smooth surface free of projections or fibers.
 - b. Holes are cut for hatches and vents. All cuts are checked for uniform circularity, size, and absence of protrusions.
 - c. Hatch is installed and tested for ease of opening and closure.
5. Final Check- Prior to packing, each part receives an additional inspection for fit, finish, and overall quality. Rejected parts are sent back to production for correction, passed parts move to packing and shipping.

C. Packing and Shipping

Most parts are packed into containers in a nested state according to size to prevent damage in shipping. Larger parts are strapped to a custom skid for shipping and delivery. All parts receive a final inspection for correct order execution and part quality prior to delivery to customer.

D. Warranty

Best Management Products, Inc. warrants for a period of one year from date of delivery to the original purchaser that the product is free from defects in material and workmanship. BMP, Inc. makes no other warrant of any kind, expressed or implied, in fact or in law, including without limitation, the warranty of merchantability or the warranty of fitness for a particular purpose other than the warranty set forth above. Failure to follow the instructions for installation provided by BMP, Inc. will void this warranty.

E. Contacts

Key Manufacturing Contact: T. J. Mullen, President, 800-504-8008, tjm@bmpinc.com