Testing of the Device

FAT TESTS OF THE PASSPORT BOOKLET PRODUCTION LINE

The Client will evaluate the level of adequate quality and stability of the completely produced passport book in accordance with the requirements of the technical specification (hereinafter referred to as the “Device”).

I. Tested material:

a) 7000 pcs endpaper 100% cellulose in format 193 x 270 mm with tolerance ±0.5 110g/m2 with offset overprint SPECIMEN (2 -UPs)

b) 14000 pcs component - 70% cellulose + 30% cotton two parallel quarries in the format 193 x 270 mm with a tolerance of ±0.5, 90g /m2, paper with watermark, embedded security strip with offset print marks and numbering - 1st component: 3-10 and 27-34, 2nd component: pages 11-26 (2-UPs) with overprint SPECIMEN

c) 7000 pcs white polycarbonate pages with a chip with a fabric hinge (9 mm) in dimensions 103.5 x 270 mm.

d) 1 piece reinforcement tape size: width 268 and in a coil 250 m, core 70 mm, color white, thickness approx. 0.170 mm, surface weight approx. 110 g/m2.

e) 3 pcs current sewing threads - polyester (Corespun Polyester thread T-50 (50/3)), top white with UV red reflection / bottom white, 4000m on a spool.

f) 7000 pcs canvas cover material - thickness 0.35 mm, basis weight 280 ± 20 g/m² in a format of 186 x 268 mm with a tolerance of ±0.5.

g) 1 piece current embossing die / format - CR – PASSPORT

h) 8 pcs current embossing foil - width 110 mm (embossing from 2 foils at once), roll 122 m, core 1".

- Material to be delivered by Contractor:

  a) supply of hot melt adhesive in the quantity needed for FAT tests

  b) supply of tape for letterpress numbering in the quantity needed for FAT tests.

II. Test progress

PRODUCTION OF A PASSPORT BOOKLET INCLUDING NUMBERING:

2-UPs: collating two 16-page layers and endpaper, applying a reinforcement tape, inserting a polycarbonate data page, interlock stitching, gluing (laminating) the canvas cover to the sewn sets, applying gold embossing to the outer cover of the booklet,

Test continuous in SINGLE PRODUCTION : cutting for single production , creasing in at the point of the fold, folding the booklet in the place of the crease , heat treatment of the spine of the booklet to prevent opening, shaped cut 88x125 ±0.75 mm , laser perforation of booklet and booklet including the PC data page (L+T format), engraving into a polycarbonate card,

letterpress numbering ±0.2 mm on the front or back endpaper and on the first visa page behind the PC data page , quantitative delivery from the Device.

III. Test supervision progress:

- Production of a complete passport booklet including numbering from the material supplied by the Client.
- The Client will require the presence of the Contractor's technician throughout the testing period.
- Representatives of the Client will be present at the testing. The Client has a right to invite a third person to Device factory acceptance tests (FAT) as an advisor or consultant.
- A protocol will be drawn up by the Client's representative about the performed tests, which will be signed by the Contractor’s technician and the Client's representative. As part of the tests, the representative of the Client will also take the necessary photo documentation or videos.
- The tested device will be put into operation by the Contractor’s representative (technician). Before the test, a sample of the tested material will be provided to the technician to perform the optimal setting of the device. For the impartiality of the test, the tested device will be operated by the Contractor’s representative (technician) in the presence of the Client's representatives.

IV. Range of tests:

As part of the tests, the following indicators will be evaluated:

a) Complete collating of the passport booklet including insertion polycarbonate data page with mechanical alignment of the set and completeness control of the final binding.

b) Application of reinforcement tape with assessment of adhesion strength.

c) Checking the readability of the chip.

d) Sewing the set with a lock stitch with a stitch tightening and UV fluorescence of upper thread control.

e) Lamination of the canvas cover on the sewn set with control of the gluing position. Sorting out of defective production with the possibility of taking out the samples.

f) Pressure pressing from a laminated set.

g) Applied gold embossing on the cover of the passport book.

h) Center creasing with subsequent break bindings at point of crease.

i) Pressing the spine of the passport book preventing the opening of the binding.

j) Shape cut in the size 88x125 with a tolerance of max.±0.75 mm and a subsequent check of the skewness and position of the embossing in the finished passport book.

k) Printing variable letterpress numbering or barcode on the front or back of the cover and on the page behind the polycarbonate insert of the passport book.

l) Laser numbering in any adjustable position with an open book binding in L or T format.

m) Laser engraving into data polycarbonate page.

n) Camera control of the complete numbering in the passport book with subsequent electronic records.

o) Quantitatively adjustable delivery from the device.

p) Reliability and stability of the equipment will be assessed according to the number of device failures, device stops during the production process, the occurrence of defects and device necessary repairs during the production process.

q) Checking of the required performance (thruput) of the equipment

In the event that, as part of the tests, the Client's representative discovers that the offered device does not meet the technical requirements of the contracting authority or the parameters specified in the Contractor's written offer, the contracting authority will demand immediate rectification at the Contractor's expense.

V. Test conditions:

Device tests will take place based on an invitation to carry out the tests, the contracting authority will send, at its own expense, at the place designated by the applicant, a set of test material (according to the above-mentioned scope).

see point I.). Due to Device preparation and acclimatization, the test material will be sent 3 months before the date of the FAT tests at latest. The Contractor will store the test material at the place where the tests are carried out, or in a warehouse with the same climatic conditions as at the place where the tests are carried out. The Contractor is obliged to handle the test material (with the character of a valuable) in accordance with usual security standards throughout the whole period of testing, respectively for the entire time he is in possession of the test material. When the material is not in use, it must be stored in a secured area. At least the half of sent test material must not be used earlier than for FAT tests with the participation of representatives of the contracting authority.

After the tests have been completed, representatives of the Contracting Authority will take samples from the test material for evaluation, or they may take all the test material. The Contractor is in this case obliged to dispose (physically destroy) of the rest of test material at his own expense with drawing up stamped protocol of disposal of the test material.The protocol of the acceptance tests (FAT) will contain the material specification and number of test material that will be returned to the Contracting Authority, way of transport, and which material will be eventually destroyed by the Contractor.

The possible disposal of the material must be attended by at least three people, who will after then sign a protocol of disposal stating the place and date of disposal and the exact specification of the destroyed material and its quantity.

SAT TESTS OF THE PASSPORT BOOKLET PRODUCTION LINE

The Client will evaluate the level of adequate quality and stability of the completely produced passport book in accordance with the requirements of the technical specification.

I. Tested material:

a) 5000 pcs endpaper 100% cellulose in format 193 x 270 mm with tolerance ±0.5 110g/m2 with offset overprint SPECIMEN (2 -UPs)

b) 10000 pcs component - 70% cellulose + 30% cotton two parallel breaks in the format 193 x 270 mm with a tolerance of ±0.5, 90g /m2, paper with watermark, embedded security strip with offset signature marking and numbering - 1st folder: 3-10 and 27-34, 2nd folder: pages 11-26 (2-UPs) with overprint SPECIMEN

c) 5000 pcs white polycarbonate pages with a chip with a fabric hinge (9 mm) in dimensions 103.5 x 270 mm.

d) 1 piece reinforcement tape size: width 268 and in a coil 250 m, tube 70 mm, color white, thickness approx. 0.170 mm, surface weight approx. 110 g/m2.

e) 3 pcs current sewing threads - polyester (Corespun Polyester thread T-50 (50/3)), top white with UV red reflection / bottom white, 4000m on a spool.

f) 5000 pcs canvas blank (covering material) - thickness 0.35 mm, basis weight 280 ± 20 g/m² in a format of 186 x 268 mm with a tolerance of ±0.5.

g) 1 piece current brass stamp / format - CR – PASSPORT

h) 6 pcs current embossing foil - width 110 mm (embossing from 2 foils at once), roll 122 m, sleeve 1".

- Material to be delivered by Contractor:

a) supply of hot-melt glue in the quantity required for SAT tests

b) supply of tape for letterpress numbering in the quantity needed for SAT tests.

II. Test progress

PRODUCTION OF A PASSPORT BOOKLET INCLUDING NUMBERING:

2-UPs: collating two 16-page layers and endpaper, applying a reinforcement tape, inserting a polycarbonate data page, interlock stitching, gluing (laminating) the canvas cover to the sewn sets, applying gold embossing to the outer cover of the booklet,

Test continuous in SINGLE PRODUCTION : cutting for single production , creasing in at the point of the fold, folding the booklet in the place of the crease , heat treatment of the spine of the booklet to prevent opening, shaped cut 88x125 ±0.75 mm , laser perforation of booklet and booklet including the PC data page (L+T format), engraving into a polycarbonate card, letterpress numbering ±0.2 mm on the front or back endpaper and on the first visa page behind the PC data page , quantitative delivery from the Device. Reading the number of chips and writing in the excel file or databases.

III. Test supervision progress:

- Production of a complete passport booklet including numbering from the material supplied by the Client.
- The Client will require the presence of the Contractor's technician throughout the testing period.
- Representatives of the Client will be present at the testing. The Client has a right to invite a third person to the site acceptance tests (SAT) as an advisor or consultant.
- A protocol will be drawn up by the Client's representative about the performed tests, which will be signed by the Contractor’s technician and the Client's representative. As part of the tests, the representative of the Client will also take the necessary photo documentation.
- The tested device will be put into operation by the Contractor’s representative (technician). Before the test, a sample of the tested material will be provided to the technician to perform the optimal setting of the device. For the impartiality of the test, the tested device will be operated by the Contractor’s representative (technician) in the presence of the Client's representatives.

IV. Range of tests:

As part of the tests, the following indicators will be evaluated:

a) Complete collating of the passport booklet including insertion polycarbonate data page with mechanical alignment of the set and completeness control of the final binding.

b) Application of reinforcement tape with assessment of adhesion strength.

c) Checking the readability of the chip and possibility to write this in the excel file or databases.

d) Sewing the set with a lock stitch with a stitch tightening and UV fluorescence of upper thread control.

e) Lamination of the canvas cover on the sewn set with control of the gluing position. Sorting out of defective production with the possibility of taking out the samples.

f) Pressure pressing from a laminated set.

g) Applied gold embossing on the cover of the passport book.

h) Center creasing with subsequent break bindings at point of crease.

i) Pressing the spine of the passport book preventing the opening of the binding.

j) Shape cut in the size 88x125 with a tolerance of max.±0.75 mm and a subsequent check of the skewness and position of the embossing in the finished passport book.

k) Printing variable letterpress numbering or barcode on the front or back of the cover and on the page behind the polycarbonate insert of the passport book.

l) Laser numbering in any adjustable position with an open book binding in L or T format.

m) Laser engraving into data polycarbonate page.

n) Camera control of the complete numbering in the passport book with subsequent electronic records.

o) Quantitatively adjustable delivery from the device.

p) Reliability and stability of the equipment will be assessed according to the number of device failures, device stops during the production process, the occurrence of defects and device necessary repairs during the production process.

q) Checking of the required performance (thruput) of the equipment

In the event that, as part of the tests, the Client's representative discovers that the offered device does not meet the technical requirements of the contracting authority or the parameters specified in the Contractor's written offer, the contracting authority will demand immediate rectification at the Contractor’s expense.

V. Test conditions:

Device tests will take place based on an invitation to carry out the tests, the contracting authority will send, at its own expense, at the place designated by the applicant, a set of test material (according to the above-mentioned scope).