
TEST REPORT n. 4915/2020/I

CERAMIC TILES - DETERMINATION OF DIMENSION

UNI EN ISO 10545-2: 2018

Date of report: 12/03/2020

Customer: **NUOVOCORSO S.p.A.**
Via Mulini Valle Tresinaro, 11
42033 ZOCCADELLO DI ONFIANO - CARPINETI (RE)

Requested on: 11/04/2020

Our ref.number: 28787

Execution place of tests: Scandiano (RE)

Description of the sample: "Ceramic tiles glazed 160x320 cm
marked:GLAZED PORCELAIN TILES RECTIFIED"

Sampling: carried out by the customer

Receipt date of samples: 11/04/2020

Execution date of tests: start: 11/27/2020 end: 11/27/2020

Test specification: UNI EN ISO 10545-2:2018
Determination of dimensional characteristics

Warnings: *This test report can not be reproduced in part, without our written consent.
The reported results relate only to the samples tested.
The information included in quotation marks was provided by the customer.*

N. samples tested: 5

Work sizes: "Side (L) 1195 mm"
"Thickness 10,5 mm"

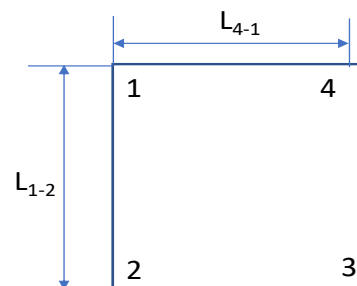
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Measure the length and width

Average size of samples:

Lm
mm
1194,0

Individual measurements:

	L1-2	L2-3	L3-4	L4-1	L
N.	mm	mm	mm	mm	mm
1	1193,7	1194,3	1193,5	1194,6	1194,0
2	1193,7	1194,3	1193,5	1194,6	1194,0
3	1193,7	1194,3	1193,5	1194,6	1194,0
4	1193,5	1194,6	1193,7	1194,3	1194,0
5	1193,5	1194,6	1193,7	1194,3	1194,0
6	-	-	-	-	-
7	-	-	-	-	-
8	-	-	-	-	-
9	-	-	-	-	-
10	-	-	-	-	-



Legend:

L = Average size of individual samples

Deviations of the average size of each tile from the work size and the average sample size (*):

	ΔL	ΔL	ΔLm	ΔLm
N.	mm	%	mm	%
1	-1,0	-0,1	0,0	0,0
2	-1,0	-0,1	0,0	0,0
3	-1,0	-0,1	0,0	0,0
4	-1,0	-0,1	0,0	0,0
5	-1,0	-0,1	0,0	0,0
6	-	-	-	-
7	-	-	-	-
8	-	-	-	-
9	-	-	-	-
10	-	-	-	-

Legend:

 ΔL = Deviations from the work sizes

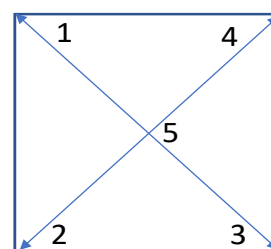
 ΔLm = Deviations from the average sample size

(*) The percentage values are for the corresponding work sizes.

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Thickness Measurement

Single thickness measurements (*):

	1-5	2-5	3-5	4-5	T	ΔT	
N.	mm	mm	mm	mm	mm	%	mm
1	10,0	10,0	9,9	9,9	10,0	-5,0	-0,5
2	10,0	9,9	10,0	10,0	10,0	-5,0	-0,5
3	10,0	10,2	10,0	10,2	10,1	-4,0	-0,4
4	10,1	10,2	10,0	10,0	10,1	-4,0	-0,4
5	10,1	10,2	10,1	10,1	10,1	-4,0	-0,4
6	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-



Legend:

T= Average thickness of each tile

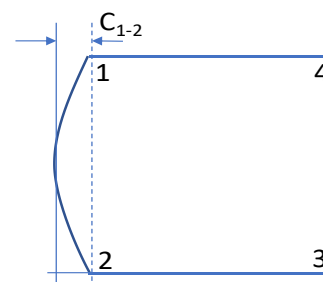
 ΔT = Deviation of the average thickness of each tile from the work size thickness

(*) The percentages are for the corresponding average thicknesses.

Measurement of straightness of edges

Individual measures straightness of the edges (*):

	C1-2	C2-3	C3-4	C4-1	C1-2	C2-3	C3-4	C4-1
N.	mm	mm	mm	mm	%	%	%	%
1	0,2	-0,1	0,1	0,1	0,0	0,0	0,0	0,0
2	0,1	-0,2	0,1	0,2	0,0	0,0	0,0	0,0
3	0,2	-0,2	0,1	0,2	0,0	0,0	0,0	0,0
4	0,1	0,1	0,2	-0,1	0,0	0,0	0,0	0,0
5	0,1	0,1	0,1	-0,1	0,0	0,0	0,0	0,0
6	-	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-



Example:

Maximum deviation from straightness (*):

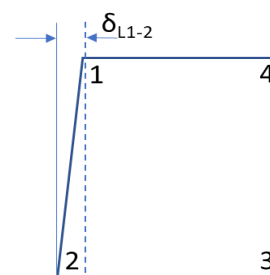
C_{maxL}	
mm	%
$\pm 0,2$	$\pm 0,0$

(*) The percentage values are for the corresponding work sizes.

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Measurement of squareness

Individual squareness measures (*):

	δ_{L1-2}	δ_{L2-3}	δ_{L3-4}	δ_{L4-1}	δ_{L1-2}	δ_{L2-3}	δ_{L3-4}	δ_{L4-1}
N.	mm	mm	mm	mm	%	%	%	%
1	0,5	-0,2	0,4	-0,6	0,0	0,0	0,0	-0,1
2	0,5	-0,3	0,4	-0,7	0,0	0,0	0,0	-0,1
3	-0,1	0,4	-0,2	0,0	0,0	0,0	0,0	0,0
4	-0,1	-0,3	0,1	0,3	0,0	0,0	0,0	0,0
5	0,0	-0,2	0,1	0,2	0,0	0,0	0,0	0,0
6	-	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-



Example:

Maximum deviation from the squareness (*):

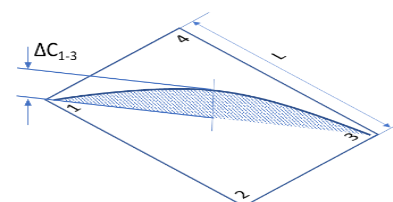
δ_{maxL}	
mm	%
-0,7	-0,1

(*) The percentage values are for the corresponding work sizes.

Flatness measurements - Curvature of the center

Individual measures of the center of curvature (**):

	ΔC_{1-3}	ΔC_{2-4}	ΔC_{3-1}	ΔC_{4-2}	ΔC_{1-3}	ΔC_{2-4}	ΔC_{3-1}	ΔC_{4-2}
N.	mm	mm	mm	mm	%	%	%	%
1	1,8	1,8	1,8	1,9	0,1	0,1	0,1	0,1
2	1,9	1,8	1,8	1,8	0,1	0,1	0,1	0,1
3	1,7	1,7	1,7	1,8	0,1	0,1	0,1	0,1
4	1,8	1,8	1,8	1,8	0,1	0,1	0,1	0,1
5	1,7	1,7	1,7	1,7	0,1	0,1	0,1	0,1
6	-	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-



Example:

Maximum center of curvature (**):

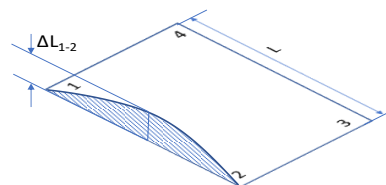
ΔC_{max}	
mm	%
1,9	0,1

(**) The percentage values are relative to the diagonal referred to the work sizes.

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Flatness measurements - Edge curvature

Individual edge curvature measurements (*):

N.	$\Delta L1-2$	$\Delta L2-3$	$\Delta L3-4$	$\Delta L4-1$	$\Delta L1-2$	$\Delta L2-3$	$\Delta L3-4$	$\Delta L4-1$
	mm	mm	mm	mm	%	%	%	%
1	0,7	1,8	0,5	1,6	0,1	0,2	0,0	0,1
2	0,7	1,8	0,5	1,5	0,1	0,2	0,0	0,1
3	0,7	1,7	0,5	1,5	0,1	0,1	0,0	0,1
4	0,5	1,5	0,7	1,7	0,0	0,1	0,1	0,1
5	0,4	1,5	0,6	1,8	0,0	0,1	0,1	0,2
6	-	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-



Example:

The maximum curvature of the edge (*):

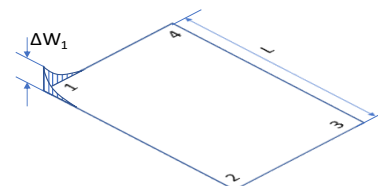
ΔL_{max}	
mm	%
1,8	0,2

(*) The percentage values are for the corresponding work sizes.

Flatness measurements - Warpage of the vertex

Individual measures warpage of the vertex (**):

N.	$\Delta W1$	$\Delta W2$	$\Delta W3$	$\Delta W4$	$\Delta W1$	$\Delta W2$	$\Delta W3$	$\Delta W4$
	mm	mm	mm	mm	%	%	%	%
1	0,1	-0,2	0,2	-0,1	0,0	0,0	0,0	0,0
2	-0,1	0,1	-0,1	0,1	0,0	0,0	0,0	0,0
3	0,0	0,0	0,0	-0,1	0,0	0,0	0,0	0,0
4	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
5	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
6	-	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-



Example:

Warpage maximum of the center (**):

ΔW_{max}	
mm	%
±0,2	±0,0

(**) The percentage values are relative to the diagonal referred to the work sizes.

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Overview of the measures

Highest identified deviations:

	L	
	mm	%
Dimensions	-1,0	-0,1
Straightness of edges	±0,2	±0,0
Squareness	-0,7	-0,1
Edge curvature	1,8	0,2
	D	
	mm	%
Curvature of the center	1,9	0,1
Warpage of the vertex	±0,2	±0,0
Thickness	-0,5	-5,0



The Director
Giulia Gaido

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