国家化学建筑材料测试中心
NATIONAL TEST CENTER OF POLYMER AND BUILDING MATERIALS

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中国认可
国际互认
检测
TESTING
CNAS L1049

National Test Center of Polymer &Building Materials

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LUMIA UPVC PROFILES, BENGALURU, INDIA 560102, Contact +91 9980063411

No.2026(C)01005

CUSTOMER: LUMIA UPVC PROFILE COMPANY

SAMPLES FOR TESTING

Name: PVC-U laminated color profiles

Manufacturer: LUMIA UPVC PROFILE COMPANY

Specification: 60 casement window frame(FM-B-I-S-1)

Brand: LUMIA

Appearance: Gold oak/White

DATE OF RECEIPT: 2026-01-15

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THIS REPORT COMPRISES 6PAGES.

DIRECTOR: 胡孝文 ***CHECK:***

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TESTING RESULTS

No.2026(C)01005

No.	Test Items		Requirements	Results	Test methods
1	Appearance		The color of the visible surface should be consistent. The surfaces should be smooth, flat and without obvious pitting, impurities. The section of the profile should be clean and no burrs. Non-obvious shrinkage marks caused by the process are allowed.	Pass	GB/T 8814-2017 7.2
2	Dimensions Tolerance, mm	Thickness	±0.3	+0.17	GB/T 8814-2017 7.3
		Width	±0.5	+0.19	
3	Wall thickness of main profile (Class B), mm	Sight surface	≥2.5	2.55	GB/T 8814-2017 7.3
		Non-sight surface	≥2.2	2.24	
4	Decorative surface thickness (laminated layer), mm		≥0.160	0.19	GB/T 8814-2017 7.3
5	Deviation from straightness of main profiles, mm		≤1	0.45	GB/T 8814-2017 7.4

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Test: 郭书超 丁树岩 苏肖群

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TESTING RESULTS

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No.	Test Items	Requirements	Results	Test methods
6	Linear weight of the main profiles,%	≥95	98.0	GB/T 8814-2017 7.5
7	Heat reversion of main sight surface,%	≤2.0	1.0,1.2	GB/T 8814-2017 7.6
8	The difference in heat reversion between these sight surfaces,%	≤0.4	0.2	GB/T 8814-2017 7.6
9	Behavior after heating at 150℃	No air bubble, crack, stain. No separation between the co-extrusion layer and the substrate.	Pass	GB/T 8814-2017 7.7
10	Resistance to impact by falling weight(main profiles),pcs	Damage number≤1 (Class II).	0	GB/T8814-2017 7.8
11	Resistance to impact by falling weight (laminated layer),pcs	No separation between the decorative layer and the substrate.	Pass	GB/T 8814-2017 7.8
12	Density(method A),kg/m³	≤1530	1503	GB/T8814-2017 7.9

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(CONTINUED FROM THE PREVIOUS PAGE)

No.	Test Items		Requirements	Results	Test methods
13	Vicat softening temperature (Bso), ℃		≥78	81.9	GB/T8814-2017 7.10
14	Tensile stress at yield, MPa		≥37	38.6	GB/T 8814-2017 7.11
15	Tensile stain at break, %		≥100	126	GB/T8814-2017 7.11
16	Flexure modulus, MPa		≥2200	2.84×10^3	GB/T8814-2017 7.12
17	Compressive bending stress of welding angle, MPa	Mean value	≥35	45.2	GB/T 8814-2017 7.17
		Minimum value	≥30	39.0	
18	Short-term coefficient of welding	Decorative surface	≥0.7	0.86	GB/T8814-2017 7.17
		Undecorative surface	≥0.8	0.89	

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19	Peel strength, N/mm	≥2.5	3.04	GB/T8814-2017 7.13

CONCLUSION:The samples of the product referred to this report have been tested in accordance with the specification GB/T 8814-2017 “Unplasticized polyvinyl chloride (PVC-U)profiles for the doors and windows”.All the items meet the requirements of the standard, the wall thickness meets the requirements of class B, resistance to impact by falling weight reaches class II.

NOTE 1:Information provided by customer:meter weight:1080g/m, I value:17.4[illegible] mm⁴, e value:34.17mm, width:58mm, thickness:60mm.

NOTE 2:The test items above were conducted at Tongzhou branch.

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Attached Table

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1.Wall thickness classification of main profile

Classification	A	B
The sight surface/mm	≥2.8	≥2.5
The non-sight surface/mm	≥2.5	≥2.2

2.Falling weight impact grade of main profile

Grade	I	II	III
Falling weight mass/g	1000		
Falling weight Height/mm	1000	1500	
Temperature/℃	-10		-20
Note:In the specific climate conditions(such as the coldest month average temperature below -10℃),the brittle damage of the profile should be fully considered.It is recommended to choose the falling weight impact level I or II in the process of design.			

3.Insulation performance classification of the main profile

Grade	1	2	3
Thermal transmittance Kr/ [W/(㎡ ·K)]	≤2.0	≤1.6	≤1.0