

QADOC5 Table of Contents

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Questions ? Contact EST Group Customer Care at one of the following locations.

EST Group
Quality Assurance Department

QADOC5 Manufacturers Certificate of Compliance EN 10204 3.1

This product meets the essential safety requirements as described in Annex I of the Pressure Equipment Directive PED 2014/68/EU.

Customer:	Customer Name	EST Sales Order:	123456
Supplier PO Ref:	123456	EST B.V. Sales Order:	123456
Manufacturer:	EST Group, Hatfield, PA, USA	Supplier:	EST Group B.V., Alphen aan den Rijn, NL

Part Number	Description			
V584S21	Pop-A-Plug® CPI/Perma Kit .584" 321/321H Stainless Steel. For Tube ID 0.585-0.649" (14.86-16.48mm).Max Pressure: 1000 PsiG (68.9 BarG). Max Temperature: 900°F (482°C). Max Hydrostatic Test Pressure:1500 PsiG (103 BarG) at ambient temperature. Kit contains (10) plugs with (1) Threaded Go/No-GoGage.			
Lot Number	Quality Inspection	Performance Testing	Pin Heat	Ring Heat
02395132	Passed	Passed	E191227	431966

Curtiss-Wright EST Group hereby certifies that the materials/items/equipment listed herein were manufactured, sampled, and inspected under our controlled Quality Management System registered to ISO-9001:2015. This document further certifies that listed equipment/service/materials are of the quality specified and conform in all respects with the listed customer purchase order requirements, including specifications, packaging, marking requirements, and physical item identification.

All documentation required by the purchase order is accurate, complete, true and is included herein.

We are committed to complying with the OECD Due Diligence Guidance for Responsible Supply Chains of Minerals from Conflict-Affected and High-Risk Areas, as well as Section 1502 of the Dodd-Frank Act.

During manufacturing, testing and inspection, the items listed did not come in contact with mercury or any of its compounds.

This document shall not be reproduced, except in full, without the prior authorization of EST Group, Quality Assurance.

Authorized by: James Daneker, QA Specialist

04-30-2024 10:40 AM

Quality Assurance, EST Group

Date

Pop-A-Plug Production Test Report

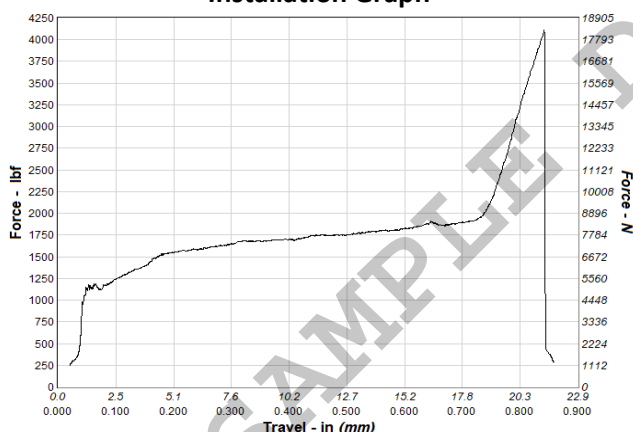
Certificate No: **02395132-Commercial**

Mfg. Date: **May 19, 2023**

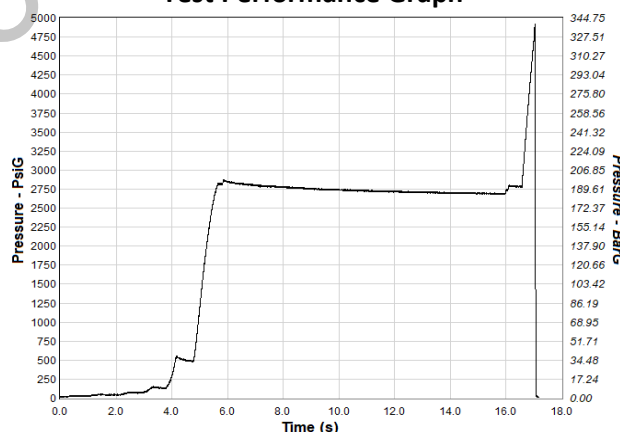
P/N	Description
V584S21	Pop-A-Plug® CPI/Perma Kit .584" 321/321H Stainless Steel. For Tube ID 0.585-0.649" (14.86-16.48mm). Max Pressure: 1000 PsiG (68.9 BarG). Max Temperature: 900°F (482°C). Max Hydrostatic Test Pressure: 1500 PsiG (103 BarG) at ambient temperature. Kit contains (10) plugs with (1) Threaded Go/No-GoGage.

Lot Number	02395132	Performance Pressure Test	4918 PsiG / 339 BarG
Test Name	02395132-V584S21-01	Test Coupon ID	0.653 in / 16.6 mm
Test Number	01	Dimensional Inspection	PASS
Test Technician	SA312	Quality Inspection	PASS
Test Stand ID	CW1	Installation Verification	PASS
Pin Material Heat	E191227	Ring Compression Verification	PASS
Ring Material Heat	431966	High Pressure Leak Test	PASS
		Post Test Visual Inspection	PASS
		Final Inspection by Supervisor	PASS

Installation Graph



Test Performance Graph



These Pop-A-Plugs manufactured, sampled, inspected and tested in accordance with Curtiss-Wright EST Group's Quality Assurance Program registered to ISO9001-2015. This certifies that listed component(s) and/or material(s) conform / in compliance with codes, standards, test requirements and Quality Assurance requirements invoked therein.

Flouf Kerk

Manager Quality Assurance

May 19, 2023

Date (month / date / year)

North, Central & South America

EST Group Corporate Office
2701 Township Line Road
Hatfield, PA 19440-1770 USA
P: +1.215.721.1100
+1.800.355.7044
F: +1.215.721.1101
est-info@curtisswright.com

Europe / Middle East / Africa

EST Group B.V.
Hoorn 312a
2404 HL Alphen aan den Rijn
The Netherlands
P: +31.172.418841
F: +31.172.418849
est-emea@curtisswright.com

China

P +86.400.636.5077
est-china@curtisswright.cn

Singapore

P +65.3158.5052
est-asia@curtisswright.com

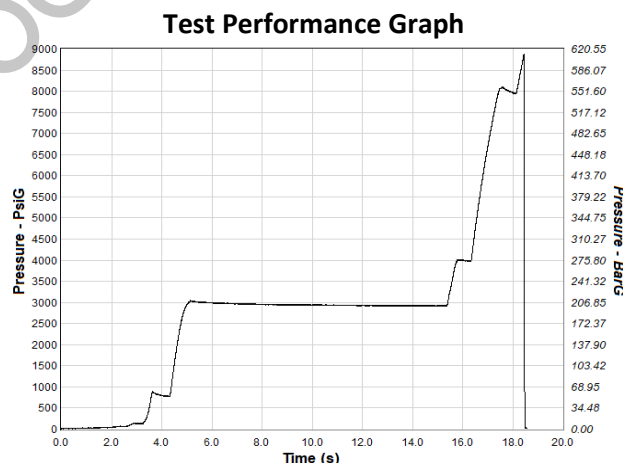
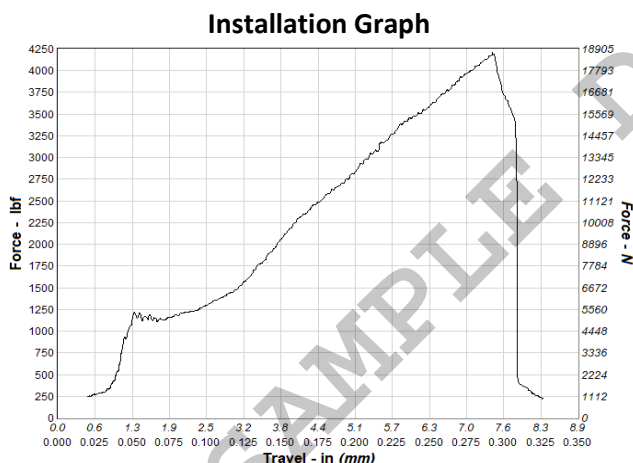
Pop-A-Plug Production Test Report

Certificate No: **02395132-Commercial**

Mfg. Date: **May 19, 2023**

P/N	Description
V584S21	Pop-A-Plug® CPI/Perma Kit .584" 321/321H Stainless Steel. For Tube ID 0.585-0.649" (14.86-16.48mm). Max Pressure: 1000 PsiG (68.9 BarG). Max Temperature: 900°F (482°C). Max Hydrostatic Test Pressure: 1500 PsiG (103 BarG) at ambient temperature. Kit contains (10) plugs with (1) Threaded Go/No-GoGage.

Lot Number	02395132	Performance Pressure Test	8876 PsiG / 612 BarG
Test Name	02395132-V584S21-02	Test Coupon ID	0.589 in / 15.0 mm
Test Number	02	Dimensional Inspection	PASS
Test Technician	SA312	Quality Inspection	PASS
Test Stand ID	CW1	Installation Verification	PASS
Pin Material Heat	E191227	Ring Compression Verification	PASS
Ring Material Heat	431966	High Pressure Leak Test	PASS
		Post Test Visual Inspection	PASS
		Final Inspection by Supervisor	PASS



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Manager Quality Assurance

May 19, 2023

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Hatfield, PA 19440-1770 USA
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est-info@curtisswright.com

Europe / Middle East / Africa

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Pop-A-Plug Production Test Report

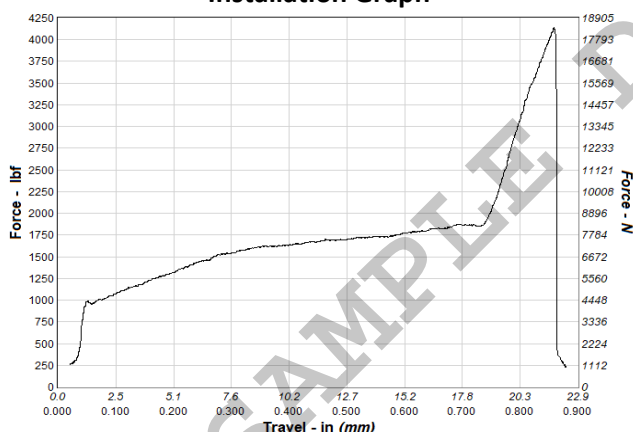
Certificate No: **02395132-Commercial**

Mfg. Date: **May 19, 2023**

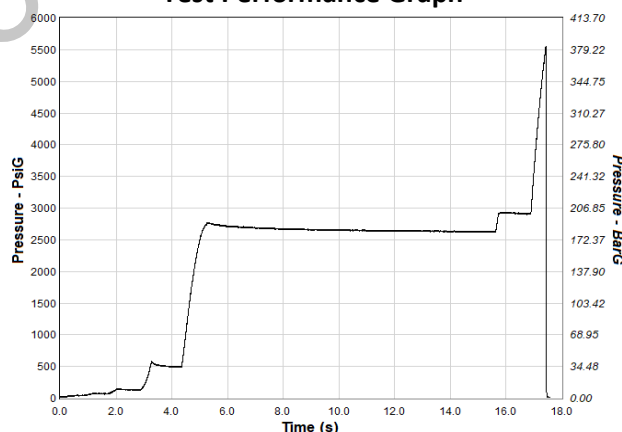
P/N	Description
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Lot Number	02395132	Performance Pressure Test	5559 PsiG / 383 BarG
Test Name	02395132-V584S21-03	Test Coupon ID	0.653 in / 16.6 mm
Test Number	03	Dimensional Inspection	PASS
Test Technician	SA312	Quality Inspection	PASS
Test Stand ID	CW1	Installation Verification	PASS
Pin Material Heat	E191227	Ring Compression Verification	PASS
Ring Material Heat	431966	High Pressure Leak Test	PASS
		Post Test Visual Inspection	PASS
		Final Inspection by Supervisor	PASS

Installation Graph



Test Performance Graph



These Pop-A-Plugs manufactured, sampled, inspected and tested in accordance with Curtiss-Wright EST Group's Quality Assurance Program registered to ISO9001-2015. This certifies that listed component(s) and/or material(s) conform / in compliance with codes, standards, test requirements and Quality Assurance requirements invoked therein.

Flouy Kerk

Manager Quality Assurance

May 19, 2023

Date (month / date / year)

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Singapore

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est-asia@curtisswright.com

**BAR STOCK
SPECIALTIES, INC.****BAR STOCK SPECIALTIES INC.**11710 CHARLES RD
HOUSTON, TX 77041**CERTIFICATE
OF TEST**

Customer Name:	EST GROUP INC (DIV OF CURTIS WRIGHT) 2701 TOWNSHIP LINE ROAD HATFIELD, PA 19440-1770 UNITED STATES	Customer PO #:	253453
		PO Line #:	
		Our Order #:	100437
		Specification Date:	20

Line	Qty	UOM	Customer Part #:	Description
1	240.00	LB		.781 DIA. x 12 FT. ROUND BAR 321 CD CG

LOT:	100113-HT#E191227=B	Heat #:	E191227	Country of Melt:	ENGLAND
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Chemical Analysis (ASTM A751-21)							
Specification:	C	Cr	Mn	Mo	Ni	P	Si
Min:	0.000	17.000	0.000	0.000	9.000	0.000	0.000
Max:	0.080	19.000	2.000	0.000	12.000	0.045	1.000
Value:	0.050	17.230	1.410	0.480	9.130	0.030	0.475

Mechanical Properties and Tests (ASTM A370-21)							
SPECIFICATION:	TENSILE	YIELD	ELONG	R/A	CHARPY IMPACTS (ft-lbf):	Proof (lbf) (ASTM A370-21)	Hardness Test:
	PSI	PSI	%	%		0.000	HBW
Min:	0	0	0.00	0.00			Min: 0
Max:	0	0	0.00	0.000		Decarb (ASTM F2328-22)	Max: 321
Actual:	145,100	122,700	22.20	63.80		0.0000	Actual: 319

Additional Mechanical Properties and Tests:	Heat Treatment:
Specification:	Specification:
Min:	Tempering
Max:	Temp (F)
Value:	Min: 0.00
	Max: 0.00
	Value: 0.00

Dimensional:
Min:
Max:
Value:

Meets the following additional requirements:
EN10204 3.1
- ** Certificate of Compliance ** The item listed meets all of the requirements of the Purchase Order and complies with all testing requirements of the specification listed on Sales Order.
- The following document shall not be re-produced except in full without written permission from the company listed in the header above.
- The recording of , fictitious or fraudulent statements or entries on this document may be punishable as a felony under Federal statutes including Federal law Title 18,Chapter 488

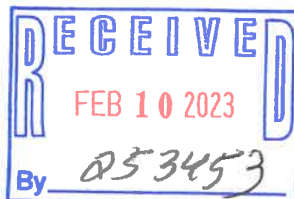
We certify that the material or the fasteners, or both, were manufactured, sampled, tested, and inspected in accordance with the specification listed above and any supplementary requirements or other requirements designated in the purchase/sales order and was found to meet those requirements.

Ship Date: 2/8/2023

By Certification Custodian:

Print Date: 2/8/2023 2:25 PM

MICHAEL LARRISON





Acciaierie Valbruna S.p.A.

36100 VICENZA (Italia) - Viale della scienza, 25 z.i.
Telefono 0444.968211 - Fax 0444.963836
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4/37
Telefono 0471.924111 - Fax 0471.924497

CERTIFICATO DI COLLAUDO - ABNAHMEPRUEFZEUGNIS - INSPECTION CERTIFICATE - CERTIFICAT DE RECEPTION

In conformità a: **EN 10204 (2004), 3.1 / ISO 10474 (2013), 3.1**

Certificato nr. **MEST417266 / 2019 /**
Prüfung/Test/Essai

Cliente / Besteller/Purchaser/Client
VALBRUNA STAINLESS INC.
2400 TAYLOR STREET WEST
46801 - FORT WAYNE, IN 46801 - US

Stato di fornitura : **Hot rolled - Annealed COLD PROCESSED**
Lieferzustand
Delivery state
Etat de livraison

Produttore :
Hersteller/Usine productrice

ACCIAIERIE VALBRUNA S.P.A.

Ordine nr: **63281 STOCK POMPTON**
Bestell
Your order
Commande

Tipo di Elaborazione: **E+AOD**
Erzeugnisart
Making process
Mode d'élaboration

Marchi di Fabbrica:
Zeichen des Lieferwerkes
Trade marks
Sigles de l'usine productrice



Conferma ordine nr: **EI19004333**
Works/Our OrderRef nr.

Qualità: **321/321H**
Werkstoff/Grade/Alliance

Punzione del Collaudatore:
Stempel des Werksachverständigen
Inspector's stamp/Pointeur de l'essayeur

MR

Avviso di Spedizione: **D-VI19015864**
Lieferanweisung/Packing list/B.L.

Marca: **AISTH**
Markenbezeichnung
Brand / Marque

Punzioneura: **321/321H**
Kennzeichnung
Marking
Marquage

SPECIFICHE :

Nota:

Anforderungen / Requirements / Exigences

Anforderungen / Notes / Notes

VSI 0 321/321H A,CF
AISI 321
AMS 5645 S S32100 A
AMS-QQ-S-763 D 321 A,CF
ASME SA182 2017 S32100 A (0)
ASME SA182 2017 S32109 A (1)
ASME SA193 2017 B8T (2)
ASME SA276 2017 S32100 A,CF (3)
ASME SA479 2017 S32100 A (4)
ASME SA479 2017 S32109 A (5)
ASTM A182 2018 S32100 A (6)
ASTM A182 2018 S32109 A (7)
ASTM A193 2017 B8T (8)
ASTM A262 2015 PRACTICE E
ASTM A276 2017 S32100 A,CF
ASTM A370 2017
ASTM A479 2018 S32100 A
ASTM A479 2018 S32109 A
NACE MR0175 2015 S32100 A (9)

- (0)Section II Part A 2017 EDITION For products machined directly from bar refer to ASME SA479.
(1)Section II Part A 2017 EDITION For products machined directly from bar refer to ASME SA479.
(2)Section II Part A 2017 EDITION Chemical analysis only.
(3)Section II Part A 2017 EDITION
(4)Section II Part A 2017 EDITION
(5)Section II Part A 2017 EDITION
(6)For products machined directly from bar refer also to ASTM A479.
(7)For products machined directly from bar refer also to ASTM A479.
(8)Chemical analysis only.

(9)ANSI/NACE MR0175/ISO 15156-3, third edition November 23,2015

Tolleranza: ASTM A484-18A TABLE 7

Tolerance/Allowance/Tolérance

Pos. nr. Pos. nr. Nr. du poste	Oggetto Objet Product description Contenu du produit	Dimensioni - in Abmessungen Dimensions Dimensions	Lunghezza - in Länge Length Longueur	Colata Schmelze Heat Coulée	Pezzi Stückzahl Pieces Pièces	Peso - LB Gewicht Weight Poids	Lotto nr. Losnr. Lot nr. Lot nr.
0110	Round	0.8750	144/ 150	431966		1.889	828910720

RECEIVED
APR 16 2020
BY: JB

QUALITY MANAGEMENT SYSTEM CERTIFIED BY LLOYD'S REGISTER ACCORDING TO ISO 9001 : 2015, IATF 16949 : 2016, AS 9100D					Pagina 1 di 3
Vicenza, 31/05/19 VC0008 - MEST417266	Il collaudatore di stabilimento der Werksachverständige / Works Inspector / L'agent d'usine M.RIZZOTTO	Direzione Qualità Qualitätsmanagement/Quality Management/Qualité R.BERTELLI	Direzione Prodotto Produktmanagement/Product Management/Direction Produit P.MESSORI		



Acciaierie Valbruna S.p.A.

36100 VICENZA (Italia) - Viale della scienza, 25 z.i.
Telefono 0444.968211 - Fax 0444.963836
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4/37
Telefono 0471.924111 - Fax 0471.924497

CERTIFICATO DI COLLAUDO - ABNAHMEPRUEFEZEUGNIS - INSPECTION CERTIFICATE - CERTIFICAT DE RECEPTION

In conformità a: EN 10204 (2004), 3.1 / ISO 10474 (2013), 3.1

Certificato nr. MEST417266 / 2019 /
Prüfung/Test/Essai

Cliente / Besteller/Purchaser/Client
VALBRUNA STAINLESS INC.
2400 TAYLOR STREET WEST
46801 - FORT WAYNE, IN 46801 - US

Stato di fornitura : Hot rolled - Annealed COLD PROCESSED
Lieferzustand
Delivery state
Etat de livraison

Produttore :
Herstellert/Kom/Usine productrice

ACCIAIERIE VALBRUNA S.P.A.

Ordine nr: 63281 **STOCK POMPTON**
Bestell
Your order
Commande

Tipo di Elaborazione: E+AOD
Erzeugungsart
Making process
Méthode d'élaboration

Marchi di Fabbrica:
Zeichen des Lieferwerkes
Trade marks
Signes de l'usine productrice



Conferma ordine nr: EI19004333
Werk/Our Order/Ref. nr.

Qualità: 321/321H
Werkstoff/Grade/Qualité

Punzone del Collaudatore:
Stempel des Werksachverständigen
Inspector's stamp/Plaque de l'essayeur

MR

Avviso di Spedizione: D-VI19015864
Lieferanfrage/Packing list/V.L.

Marca: AISTH
Markenbezeichnung
Brand / Marque

Punzonatura: 321/321H
Kenzeichnung
Marking
Marquage

TEST ALLO STATO DI FORNITURA										
Test on delivery condition Prüfung auf lieferbarem produkt test a l'état de fourniture Prueba sobre el material así como entregado										
TEST	Prova/Prüfung Specimen/Probierstück Long. diam. Spec. diam. Diam. Circle Width Diam. Thickness Long. diam. Spoke mm	°F	Posiz. Saggio Position Lagepunkt mm	Snervamento Streckgrenze Yield Stress Limite élastique Rp 0,2% k.s.l	Snervamento Streckgrenze Yield Stress Limite élastique k.s.l	Resistenza Zugfestigkeit Tensile strength Résistance à traction Rm k.s.l	Allungamento Bruchdehnung Elongation Allongement E 4d %	Strizione Einziehdehnung Reduction of area Striction RA %	Resilienza Kerbschlagarbeit Impact Value Resilience	Durezza Härte Hardness Dureté HB
Valori richiesti Anforderungen/Required values Valores solicitados		min max		30	-	75	-	30	50	140 235
A	12,5	68	L	66		91	49	75		233

TEST ALLO STATO DI FORNITURA			
Test on delivery condition / Prüfung auf lieferbarem produkt / Test a l'état de fourniture / Prueba sobre el material así como entregado			
TEST	min	max	
A Grain size for ASTM E112		7	6

Mechanical properties according to ASTM A370.

Analisi chimica												
Chemische Zusammensetzung/Chemical Analysis/Analyse chimique												
Content / Anteil Schnitzteil/Conteúdo	min	0,040	max	0,050	1,00	2,00	17,00	19,00	3,75	0,75	9,00	5(C+N)
	C %	Si %	Mn %	Cr %	Mo %	Cu %	Ni %	Ti %	P %	S %	N %	
431966	0,044	0,72	1,65	17,37	0,39	0,36	9,29	0,65	0,030	0,001	0,013	

Corrosion test in 16% sulfuric acid and copper sulfate solutions							
Test standard: ASTM A262-Practice E							
Test	Heat treatment before test	Length of Period (h)	Test temp (°C)	Bend Angle (°)	Ø spindle (mm)	Result of visual inspection at 20 x magnification after bend test	Result
Intergranular corrosion	Sensitization	15	boil	180	5	Absence of cracks	SATISFACTORY

Produced without class I-II Ozone depleting substances.
Solution heat treated free from continuous carbide network.
Micro and macro etch test : OK
Reduction ratio = 626,3 : 1
Annealing temperature : 2005° F for 1h/H2O.
Material is DFARS Compliant

Sono state soddisfatte tutte le condizioni richieste
Die geordneten Anforderungen sind lt. Anlage erfüllt
The material has been furnished in accordance with the requirements
Le matériel a été fourni conforme aux exigences

Controllo antimescolanza: OK
Verwechslungsprüfung: spezialanalytisch durchgeführt
Antimixing testing performed: OK
Contrôle antimeslange test: r.s.s.

Controllo visivo e dimensionale: soddisfa le esigenze
Beckichtig und Ausmessung: ohne Beanstandung
Visual inspection and dimensional check:satisfactory
Contrôle visuel et dimension: satisfaisant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury contamination
We declare that the finished product is checked for radioactive contamination through Portal System when it leaves the production plant.

QUALITY MANAGEMENT SYSTEM CERTIFIED BY LLOYD'S REGISTER ACCORDING TO ISO 9001 : 2015, IATF 16949 : 2016, AS 9100D			
Vicenza, 31/05/19 VCQ008 - MEST417266	Il collaudatore di stabilimento der Werksachverständige / Works Inspector / L'expert d'usine M.RIZZOTTO	Direzione Qualità Qualitätsmanagement/Quality Management/Gestion Qualité R.BERTELLI	Direzione Prodotto Produktmanagement/Product Management/Direction Produit P.MESSORI
			Pagina 2 di 3



Acciaierie Valbruna S.p.A.

38100 VICENZA (Italia) - Viale della scienza, 26 z.i.
Telefono 0444.968211 - Fax 0444.963836
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4/37
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2400 TAYLOR STREET WEST
46801 - FORT WAYNE, IN 46801 - US

Stato di fornitura: Hot rolled - Annealed COLD PROCESSED
Lieferzustand
Delivery state
Etat de livraison

Produttore:
Hersteller/Hersteller productrice

ACCIAIERIE VALBRUNA S.P.A.

Marchi di Fabbrica:
Zeichen des Lieferwerkes
Trade marks
Sigles de l'usine productrice



Ordine nr: 63281 **STOCK POMPTON**
Bestell
Your order
Commande

Tipo di Elaborazione: E+AOD
Erweiterungsart
Metting process
Mode d'elaboration

Punzone del Collaudatore:
Stempel des Werksachverständigen
Inspector's stamp/Plombon de l'inspecteur

MR

Conferma ordine nr: EI19004333
Werkst/Our Order/Ref nr.

Qualità: 321/321H
Werkstoff/Grade/Nuance

Avviso di Spedizione: D-VI19015864
Lieferanzeige/Packing list/B.L.

Marca: AISTH
Markenbezeichnung
Brand / Nuance

Punzonatura: 321/321H
Kopfschraube
Marking
Marquage

The Quality Management System is also Certified according Pressure Equipment Directive 2014/68/EU Annex 1, chapt.4.3 by TÜV and LLOYD'S
Any act of tampering, modification, alteration, counterfeiting and/or falsification and/or any other action which modifies the contents of this test certificate shall constitute a violation of applicable civil and criminal laws. Acciaierie Valbruna shall protect its rights and interests before any competent court, authority and jurisdiction.
Maximal and/or Valplus grades/products are manufactured with ladle techniques to control composition, distribution, size and shape of non-metallic inclusions for improved machinability.
The supplied product conforms to requirements expressly requested by the purchaser and conforms to requirements specified by certified norms and standards. Should the product be used for more severe, critical and/or in any case different applications than those the material is generally intended for, any different and/or supplementary requirements shall be specifically demanded, at least, upon order of the Product by the Purchaser. Acciaierie Valbruna SpA shall not be responsible for any improper use of the Products.

SAMPLE DOCUMENT

QUALITY MANAGEMENT SYSTEM CERTIFIED BY LLOYD'S REGISTER ACCORDING TO ISO 9001 : 2015, IATF 16949 : 2016, AS 9100D				
Vicenza, 31/05/19 VCC008 - MEST417266	Il collaudatore di stabilimento der Werksachverständige / Works Inspector / L'expert d'usine M.RIZZOTTO	Direzione Qualità Qualitätsmanagement/Quality Management/Gestion Qualité R.BERTELO	Direzione Produzione Produktmanagement/Product Management/Direction Product P.MESSORI	Pagina 3 di 3

YARDE METALS Inc