



FIBRE LINING



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PRESS ON

The PRESS ON anchor system is used to anchor multilayers fiber linings from the shell / casing to the hot face. Washers can be positioned very accurately to within one millimeter.

The PRESS ON system prevents the hot face washer being removed (under the effect of vibrations for example).

It is used when the last hot face layer is either:

- A fiber blanket,
- A steel sheet,
- A rigid fiber board,
- Another rigid material which does not have the resilience (spring effect) of a blanket.

The PRESS ON system is made up of:

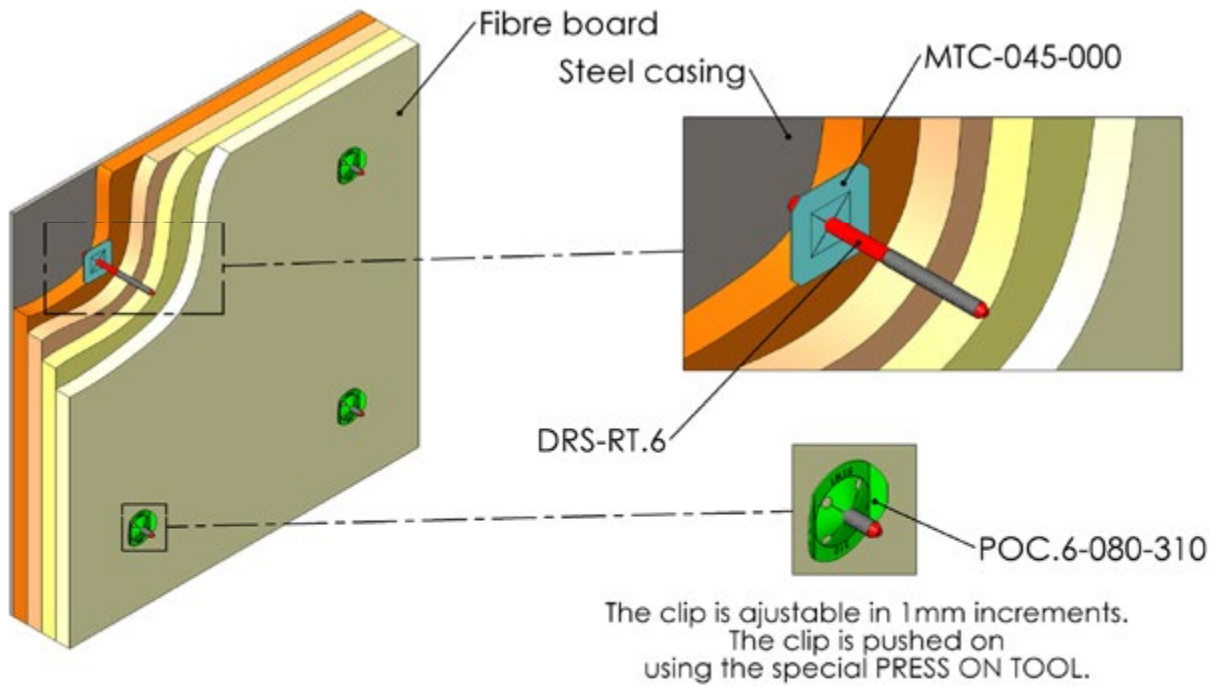
- A round threaded M6 or M8 stud,
- A hot face lockwasher POC or LPC (to be pushed on with the special "PRESS ON" TOOL, it cannot be screwed on)
- One (or more) mounting clip in spring carbon steel, in order to hold the intermediary layers during installation.

Studs are fixed by:

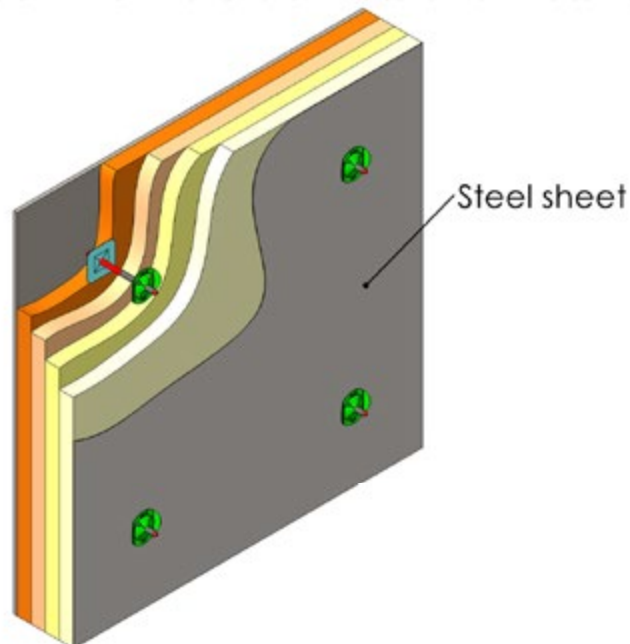
- Stud welding: a ceramic ferrule is applied with the stud (to form the welding ring).
- Hand welding : the cold face end is bent to 90°; this facilitates the welding.

"PRESS ON" CLIP SYSTEM

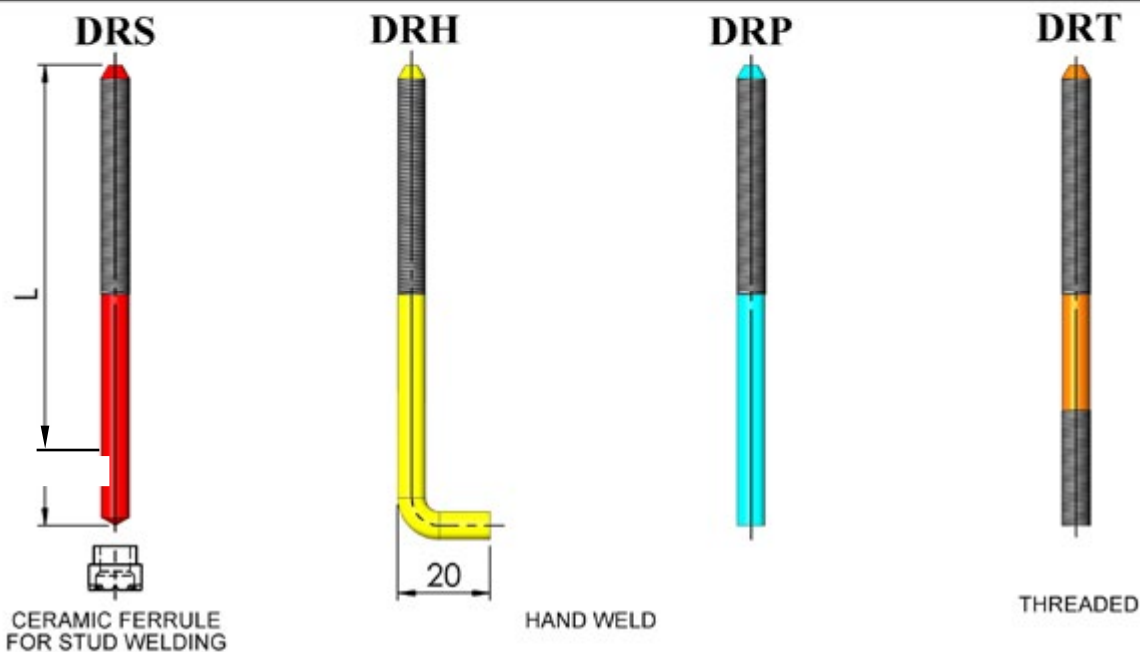
Application with fibre boards or fibre blankets



Application with fibre blankets and metal sheet



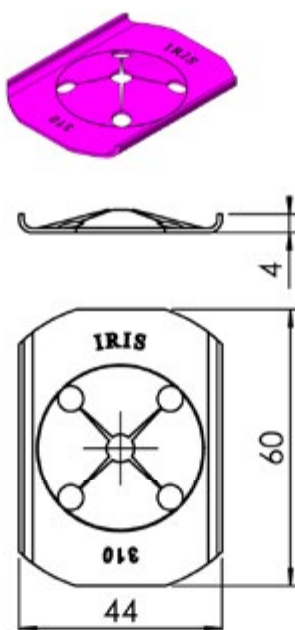
"PRESS ON" CLIP SYSTEM



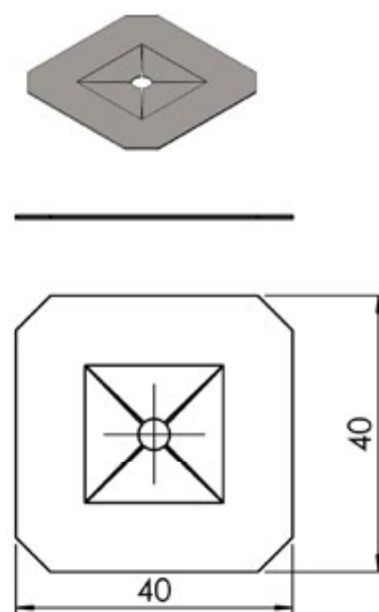
POC
(Press on clip)



LPC
(Press on clip)



MTC
(Mounting clip)



DESIGNATION EXAMPLE

DRS - RT or CT .6 - 125 - 310

Anchor type Diameter D Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

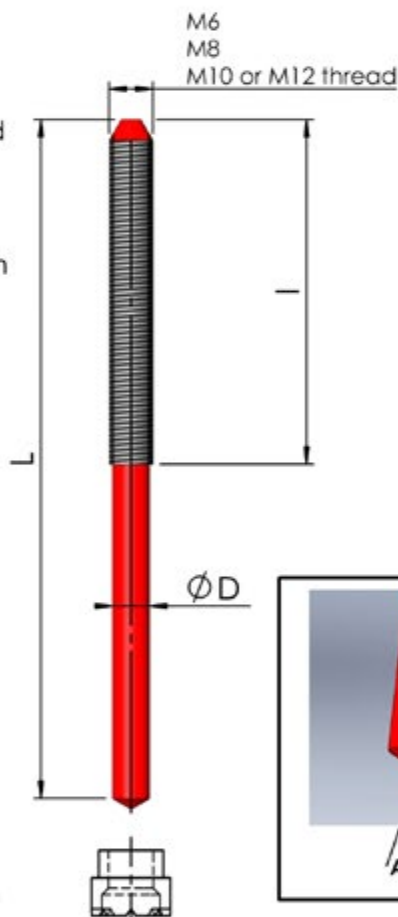
"L" ≤ 50mm l = 20mm
"L" = 51-≤100mm l = 25mm
"L" ≥ 101mm l = 50mm

DRS - RT

NOTE :

RT = Rolled thread

M6 D= ±5.35mm
M8 D= ±7.18mm
M10 D= ±9.02mm
M12 D= ±10.86mm



Alu Ball (option "AB")
requested from
M8 and more.
Makes gun welding
easier

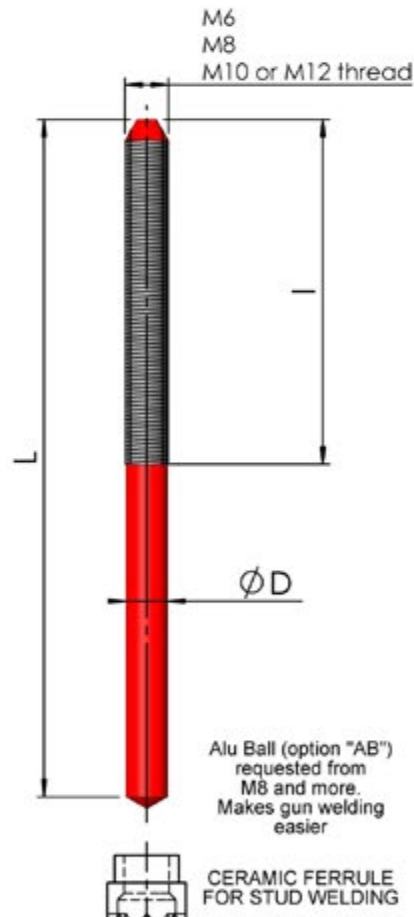
CERAMIC FERRULE
FOR STUD WELDING

DRS - CT

NOTE :

CT = Cut thread

M6 D= 6mm
M8 D= 8mm
M10 D= 10mm
M12 D= 12mm



Alu Ball (option "AB")
requested from
M8 and more.
Makes gun welding
easier

CERAMIC FERRULE
FOR STUD WELDING

OPTIONS :

- Intermediate washer : MTC
- Final washer : POC or LPC
- Final ceramic washer : Cerafix n°1 or n°9

DESIGNATION EXAMPLE

DRH - RT or CT .6 - 125 - 310

Anchor type Diameter D Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

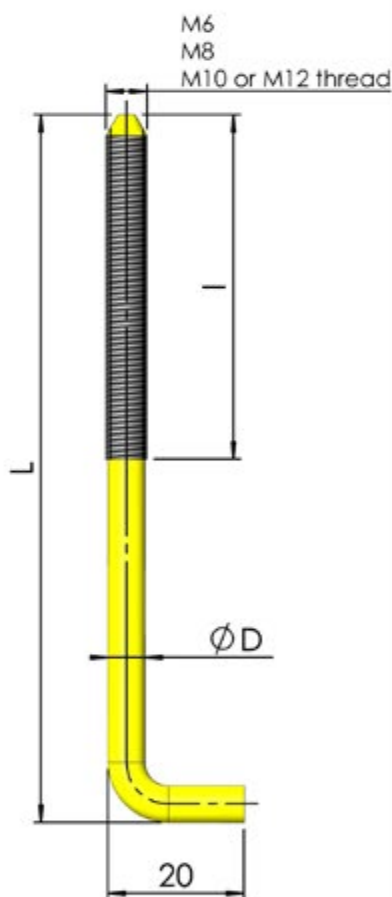
"L" ≤ 50mm l = 20mm
"L" = 51-≤100mm l = 25mm
"L" ≥ 101mm l = 50mm

DRH - RT

NOTE :

RT = Rolled thread

M6 D= ±5.35mm
M8 D= ±7.18mm
M10 D= ±9.02mm
M12 D= ±10.86mm

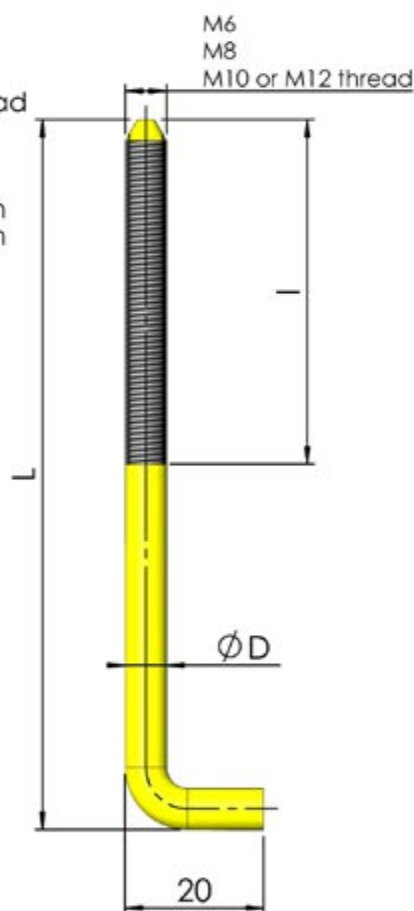


DRH - CT

NOTE :

CT = Cut thread

M6 D= 6mm
M8 D= 8mm
M10 D= 10mm
M12 D= 12mm



OPTIONS :

- Intermediate washer : MTC
- Final washer : POC or LPC
- Final ceramic washer : Cerafix n°1 or n°9

DESIGNATION EXAMPLE

DRT - ^{RT} or ^{CT} .6 - 125 - 310

↑ ↑ ↑ ↑
Anchor type Diameter D Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

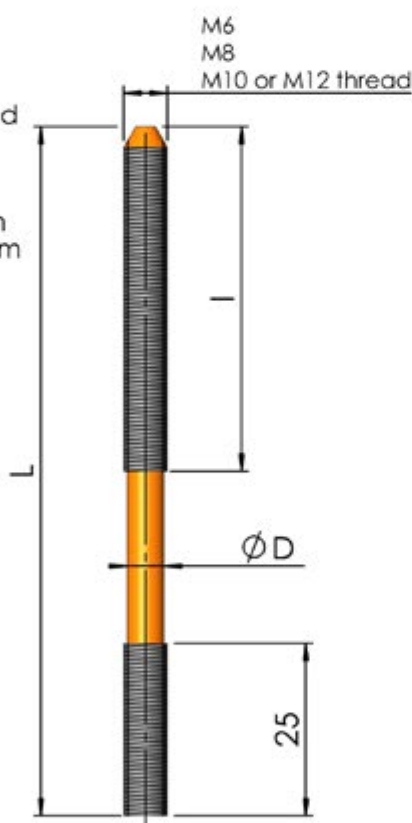
"L" ≤ 50mm l = 20mm
"L" = 51-≤100mm l = 25mm
"L" ≥ 101mm l = 50mm

DRT - RT

NOTE :

RT = Rolled thread

M6 D= ±5.35mm
M8 D= ±7.18mm
M10 D= ±9.02mm
M12 D= ±10.86mm

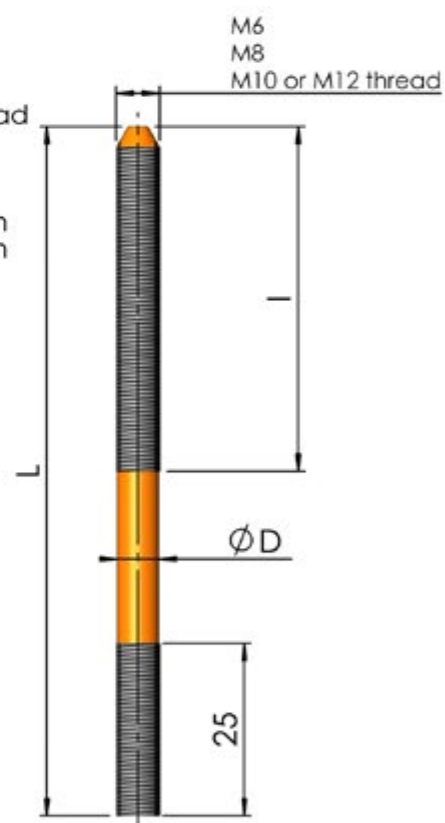


DRT - CT

NOTE :

CT = Cut thread

M6 D= 6mm
M8 D= 8mm
M10 D= 10mm
M12 D= 12mm



OPTIONS :

- Intermediate washer : MTC
- Final washer : POC or LPC
- Final ceramic washer : Cerafix n°1 or n°9

DESIGNATION EXAMPLE

DRP - RT or CT .6 - 125 - 310

Anchor type

Diameter D

Length L

Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

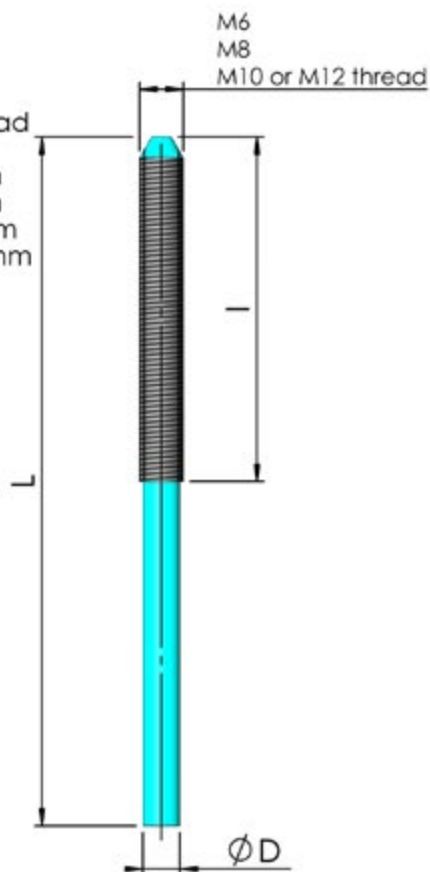
"L" ≤ 50mm l = 20mm
"L" = 51-≤100mm l = 25mm
"L" ≥ 101mm l = 50mm

DRP - RT

NOTE :

RT = Rolled thread

M6 D= ±5.35mm
M8 D= ±7.18mm
M10 D= ±9.02mm
M12 D= ±10.86mm

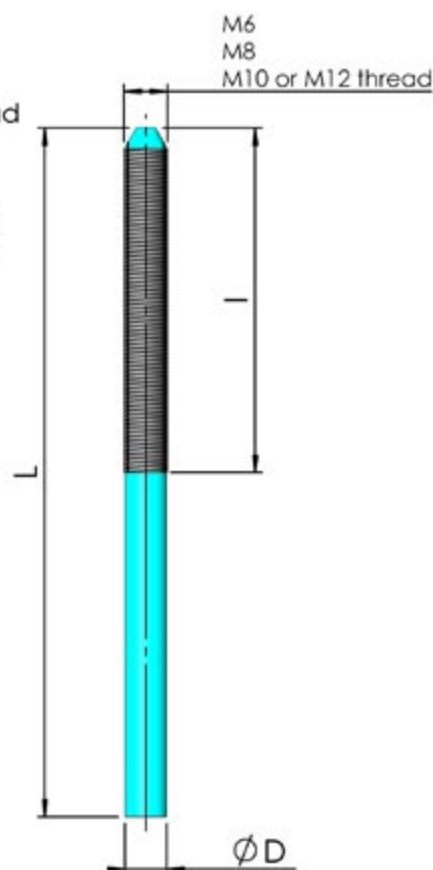


DRP - CT

NOTE :

CT = Cut thread

M6 D= 6mm
M8 D= 8mm
M10 D= 10mm
M12 D= 12mm



OPTIONS :

- Intermediate washer : MTC
- Final washer : POC or LPC
- Final ceramic washer : Cerafix n°1 or n°9

DESIGNATION EXAMPLE

POC.6 - 080 - 310

↑ ↑ ↑ ↑
 Press On Clip Stud Ø Thickness Alloy

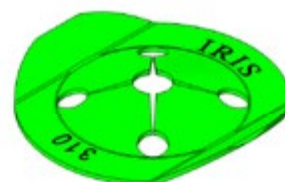
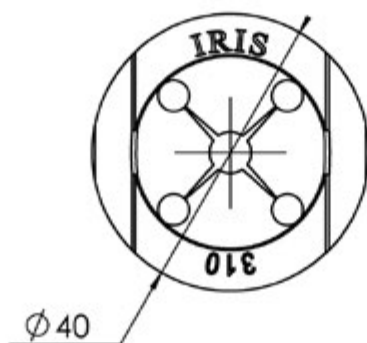
Standard thickness: 0.8 mm

Standard alloys

AISI 310
AISI 330

Other alloys on request.

POC



DESIGNATION EXAMPLE

LPC.8 - 100 - 310

↑ ↑ ↑ ↑
 Press On Clip Stud Ø Thickness Alloy

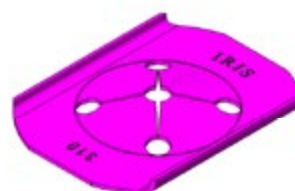
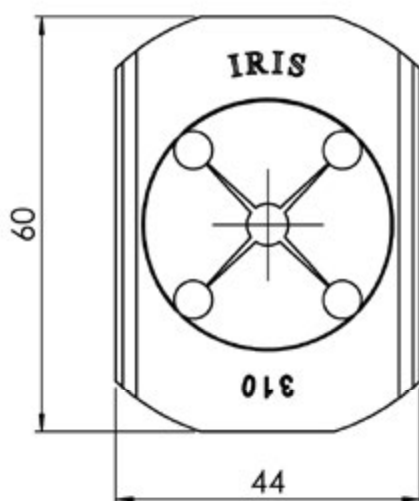
Standard alloys

AISI 310
AISI 330

Other alloys on request.

LPC

Standard thickness: 1.0 mm



DESIGNATION EXAMPLE

MTC - 045 - 000

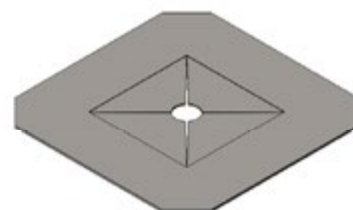
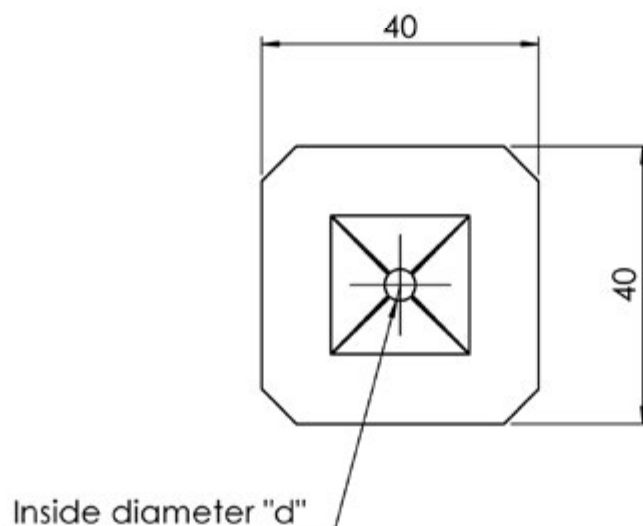
↑ ↑ ↑
 Mounting clip Diameter Alloy

MTC-045 (d=4.5mm) for studs Ø5.0 - 6.0
 MTC-065 (d=6.5mm) for studs Ø7.0 - 8.0

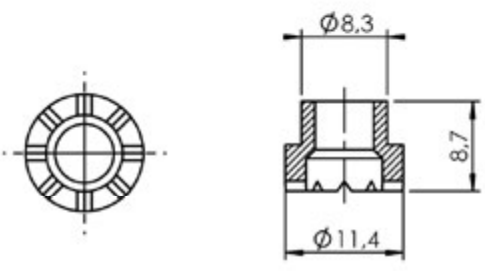
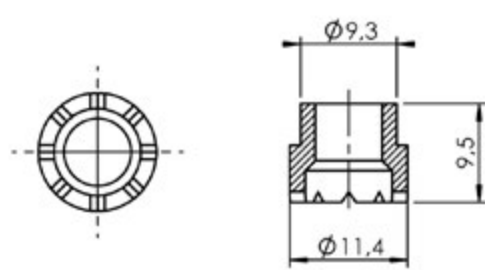
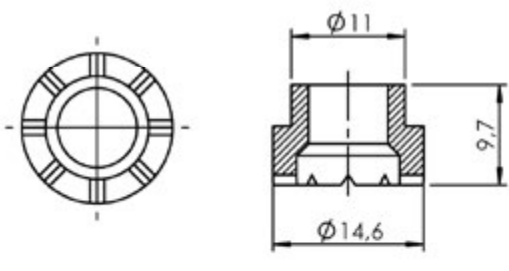
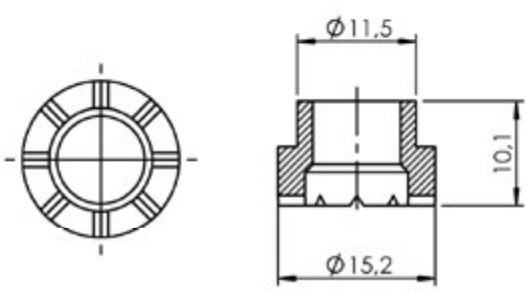
Standard Alloys :

000 = Spring carbon steel
 301 = 18/8 (0.4% C)

MTC Mounting Clip



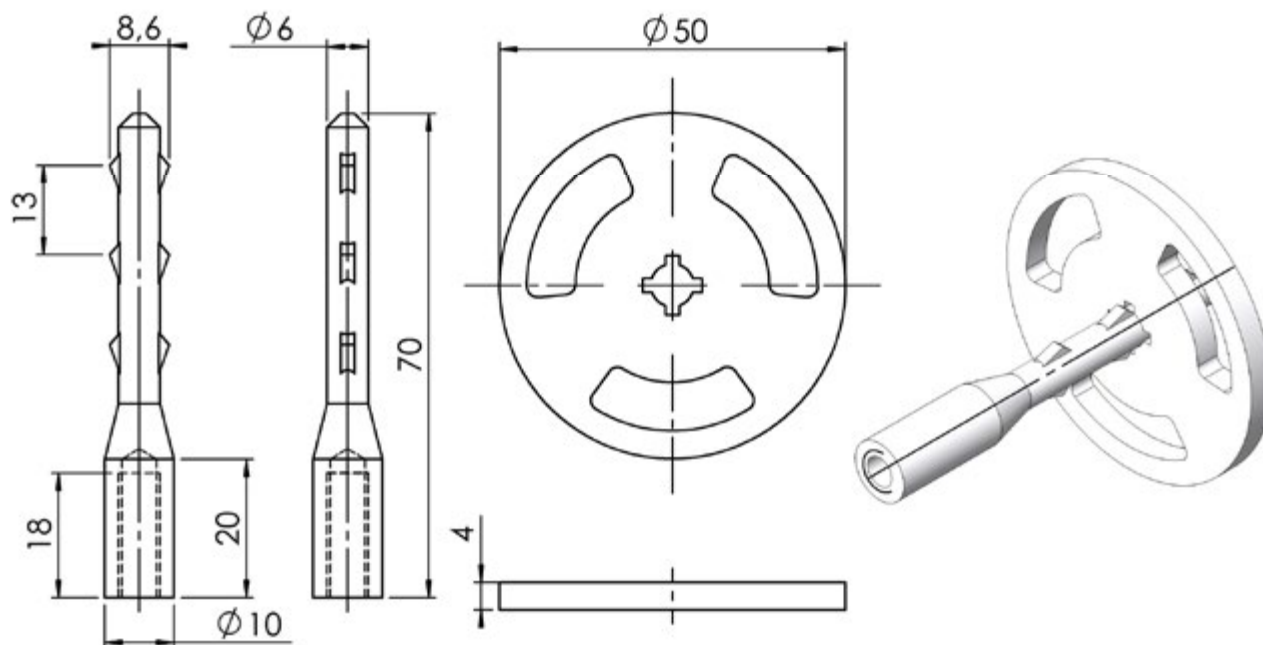
FERRULES FOR STUD WELDING

		ORDER CODE	TO BE USED WITH
		FER 052	DRS 6 RT Ø5.35 stud
		FER 062	DRS 6 CT Ø6 stud
		FER 072	DRS 8 RT Ø7.1 stud
		FER 080	DRS 8 CT Ø8 stud

Typical designs and sizes can be changed without prior notice.

CERAFIX N°1

CERAFIX anchors in alumina



The CERAFIX anchor is suitable for fixing fiber blankets, boards or fibre blocks. The CERAFIX is screwed on a M6 threaded steel stud (AISI 310, AISI 330, Inc 601). It can be used in atmospheres where refractory steel fasteners don't resist.

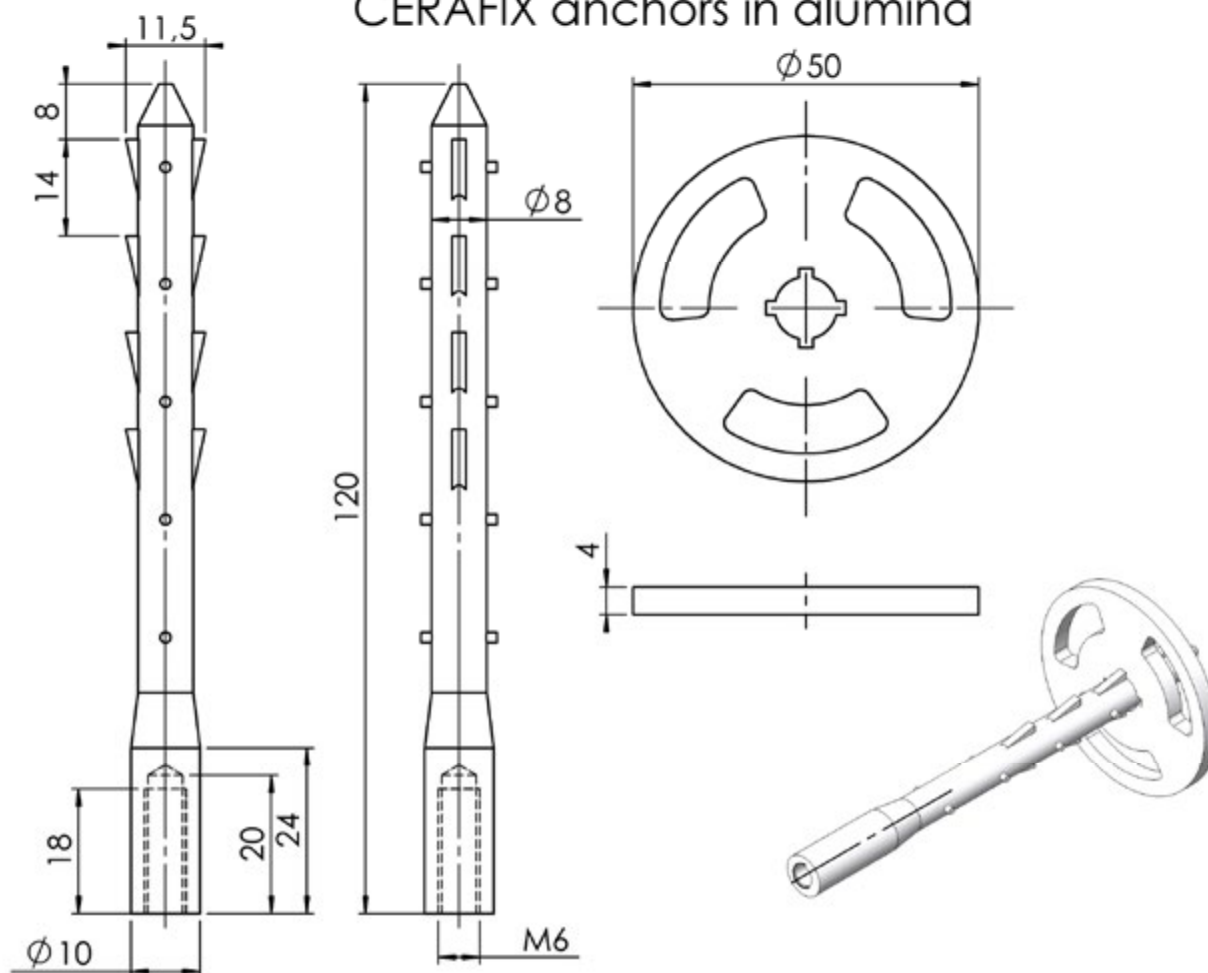
CERAFIX CAN ONLY BE ORDERED AS A COMPLETE SET (ceramic stud + washer)

Technical Specifications :

- To be attached using M6 stud DRS-RT or DRH-RT (page n° F2-05 / F2-06) (not on cut thread)

CERAFIX N°9

CERAFIX anchors in alumina



The CERAFIX anchor is suitable for fixing fiber blankets, boards or fibre blocks. The CERAFIX is screwed on a M6 threaded steel stud (AISI 310, AISI 330, Inc 601). It can be used in atmospheres where refractory steel fasteners don't resist.

CERAFIX CAN ONLY BE ORDERED AS A COMPLETE SET (ceramic stud + washer)

Technical Specifications :

- To be attached using M6 stud DRS-RT or DRH-RT (page n° F2-05 / F2-06)
(not on cut thread)

CERAFIX N°1 or N°9 TECHNICAL DATA SHEET WHITE VERSION

Physical Characteristics :	
Color	white
Bending strenght	307 ± 18 MPa
Compressive strenght	375 ± 73 MPa
Average of crystal bulk	5,5 µm
Dielectric strenght	20.4 kV/mm
Bulk density	3.32 g/cm ³
Moisture capacity	0,68 m %
Heat Resistance	ca. 1500 C°
Open porosity	2,25%
Micro hardness	8229 ± 1992 MPa
Hardness (Vickers)	769 HV15 (vickers)

Coefficients of the linear thermal expansion :	
600°C	7,08 * 10 ⁻⁶ 1/°C
800°C	7,40 * 10 ⁻⁶ 1/°C
1000°C	7,69 * 10 ⁻⁶ 1/°C
1100°C	7,79 * 10 ⁻⁶ 1/°C
1200°C	7,80 * 10 ⁻⁶ 1/°C
1300°C	7,95 * 10 ⁻⁶ 1/°C
1400°C	7,41 * 10 ⁻⁶ 1/°C
1500°C	6,09 * 10 ⁻⁶ 1/°C

Mentionned datas are average values and not guaranteed values.
They can be modified without prior notice.

CERAFIX N°1 or N°9 TECHNICAL DATA SHEET PINK VERSION

Physical Characteristics :	
Color	pink
Bending strenght	298 ± 16 MPa
Compressive strenght	603 ± 144 MPa
Average of crystal bulk	4,5 µm
Dielectric strenght	22.0 kV/mm
Bulk density	3.40 g/cm ³
Moisture capacity	0,66 m %
Heat Resistance	ca. 1500 C°
Open porosity	2,24%
Micro hardness	7225 ± 1165 MPa
Hardness (Vickers)	999 HV15 (vickers)

Coefficients of the linear thermal expansion :	
600°C	7,06 * 10 ⁻⁶ 1/°C
800°C	7,34 * 10 ⁻⁶ 1/°C
1000°C	7,57 * 10 ⁻⁶ 1/°C
1100°C	7,69 * 10 ⁻⁶ 1/°C
1200°C	7,78 * 10 ⁻⁶ 1/°C
1300°C	7,92 * 10 ⁻⁶ 1/°C
1400°C	7,75 * 10 ⁻⁶ 1/°C
1500°C	7,09 * 10 ⁻⁶ 1/°C

Mentionned datas are average values and not guaranteed values.
They can be modified without prior notice.



FIBERFIX

The FIBERFIX anchor system is used to anchor multilayer fiber linings from the shell / casing to the hot face. It consists of :

- A round diameter 5mm stud,
- A large or medium size hot face lockwasher (LFF-060 or 040),
- In some cases, a ceramic cuplock IRI-050;

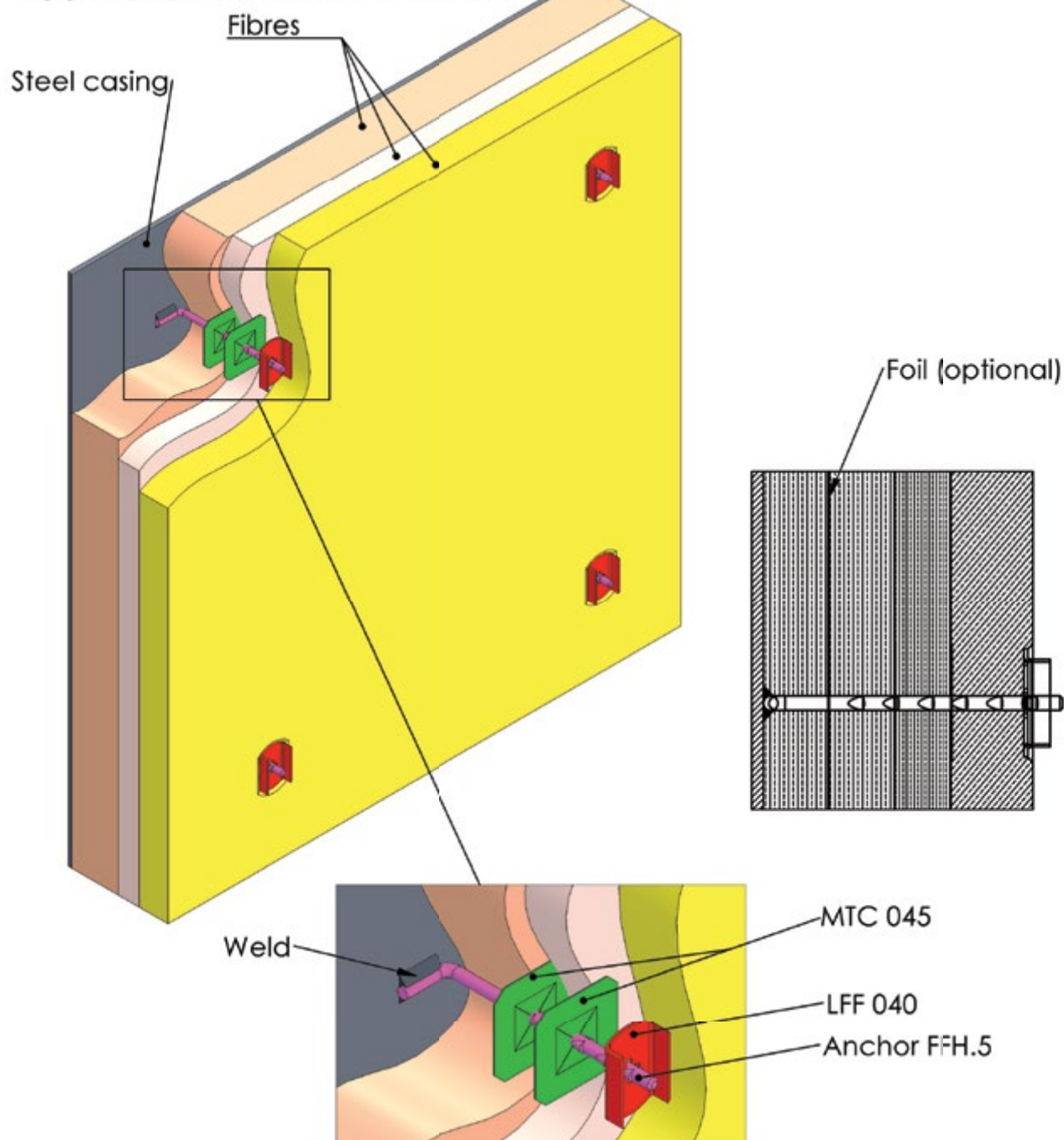
One (or more) mounting clips (MTC), in order to hold the intermediary layers during installation.

STUDS ARE FIXED ON THE VESSEL SHEEL BY:

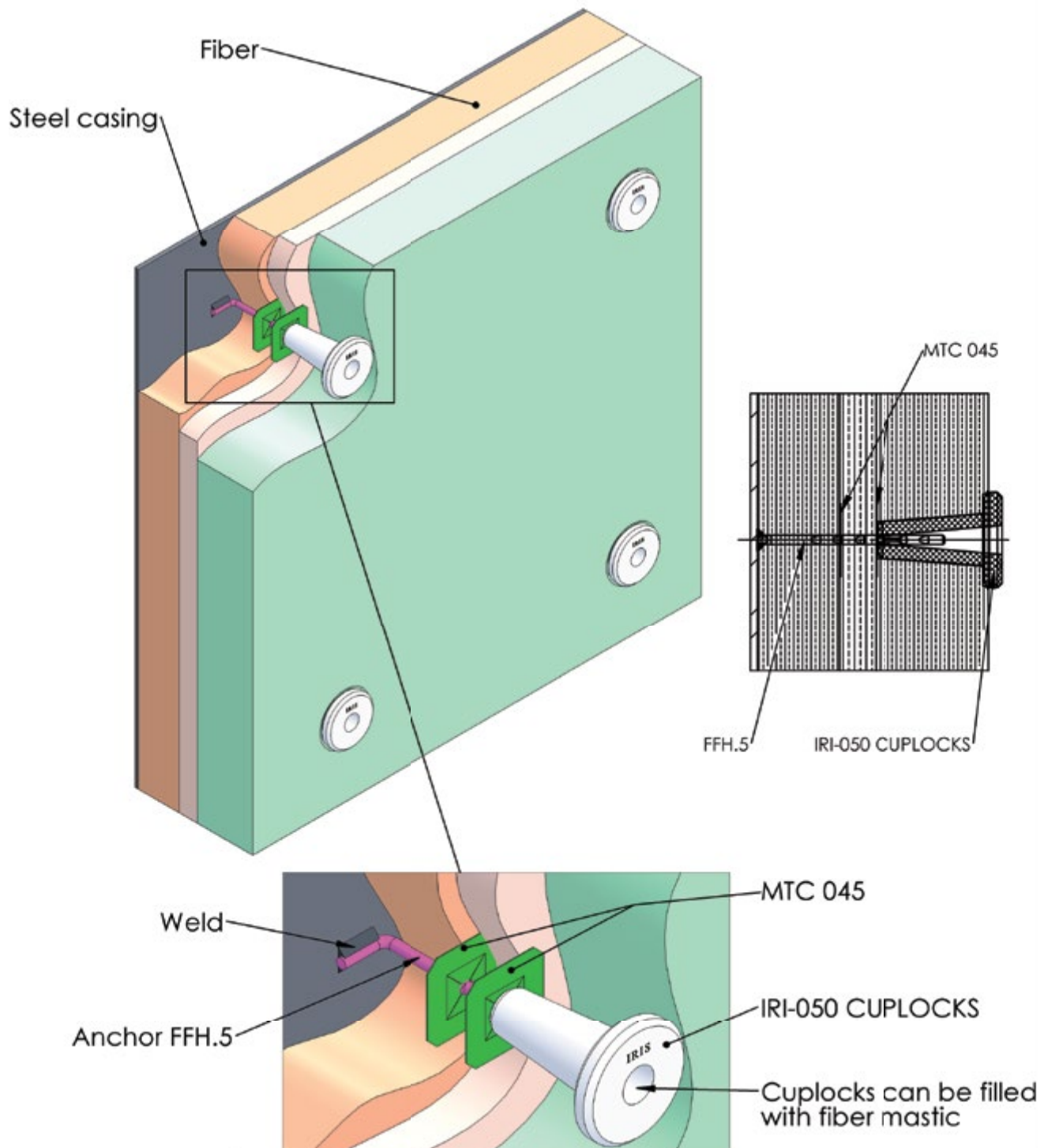
- Stud welding: a ceramic ferrule is supplied with stud,
- Hand welding : the cold face end is bent to 90°, this facilitates the welding,
- Screwing on an inside-threaded stud (stud BDB), which has been welded to the steel casing.

The FIBERFIX System

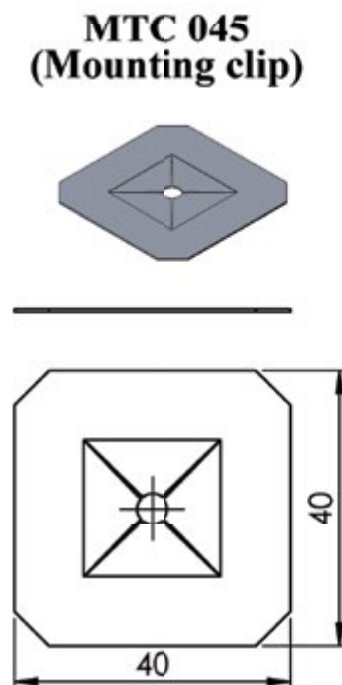
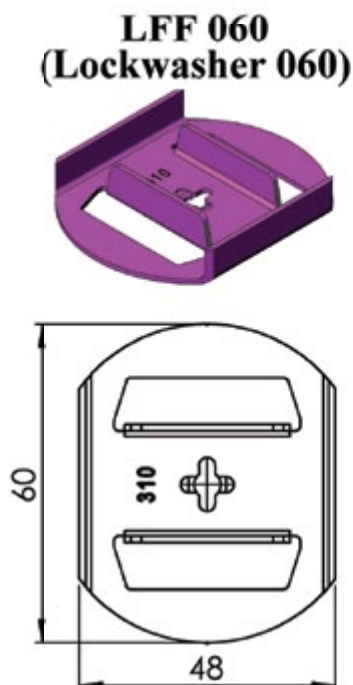
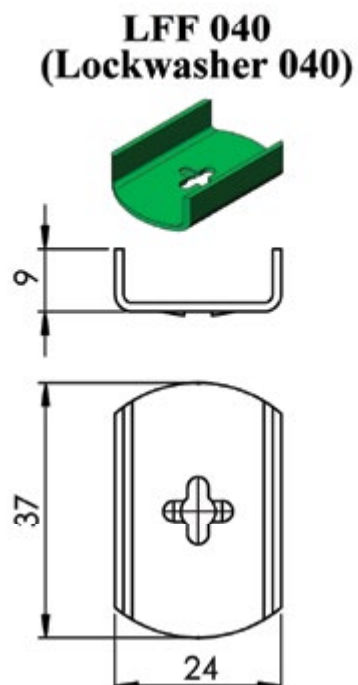
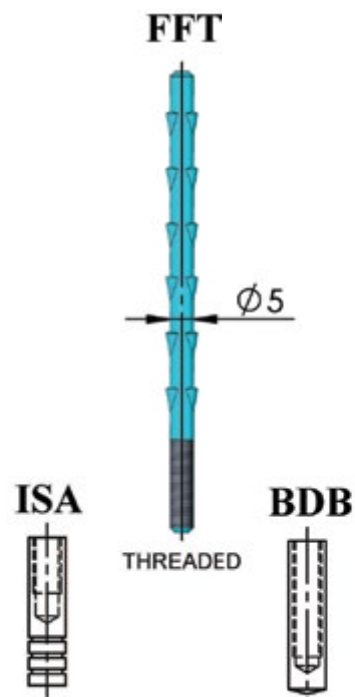
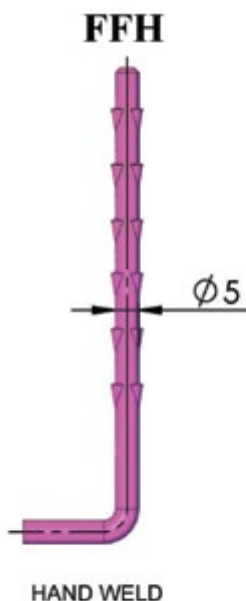
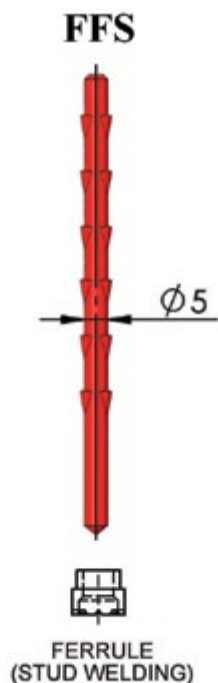
Application with fibre blankets.



The FIBERFIX System with ceramic CUPLOCKS



The FIBERFIX System



DESIGNATION EXAMPLE

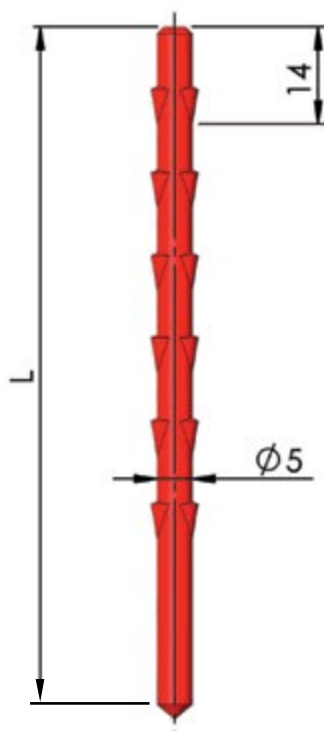
FFS.5 - 200 - 310

↑ ↑ ↑ ↑
Anchor type Diameter D Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

FFS



CERAMIC FERRULE: FER - 052
FOR STUD WELDING

OPTIONS :

- Intermediate washer : MTC - 045
- Final washer : CFF 040 or LFF 060
- Final ceramic washer : IRI 025 or IRI 050 with IRI 100

DESIGNATION EXAMPLE

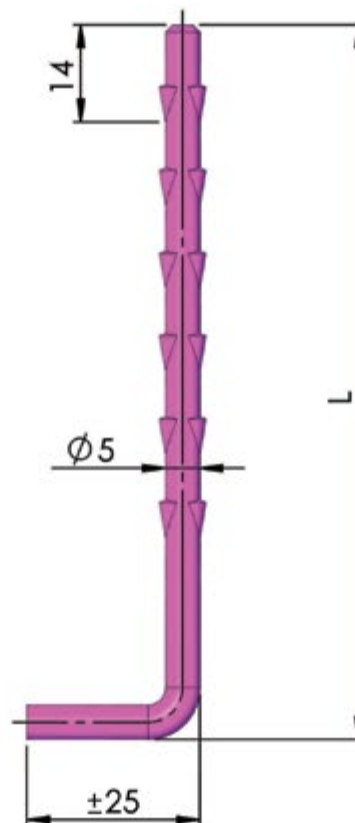
FFH.5 - 200 - 304

↑ ↑ ↑ ↑
Anchor type Diameter D Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

FFH



OPTIONS :

- Intermediate washer : MTC - 045
- Final washer : CFF 040 or LFF 060
- Final ceramic washer : IRI 025 or IRI 050 with IRI 100

DESIGNATION EXAMPLE

FFT.5.25 - 250 - 310

Anchor type
Diameter D
Length L
Alloy

BDB.6 - 030 - 316

Thread M diameter

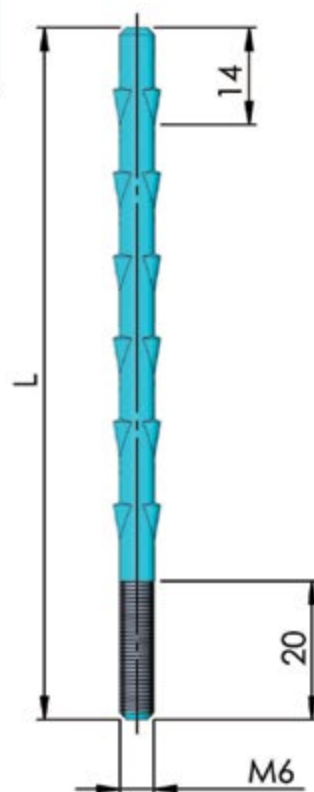
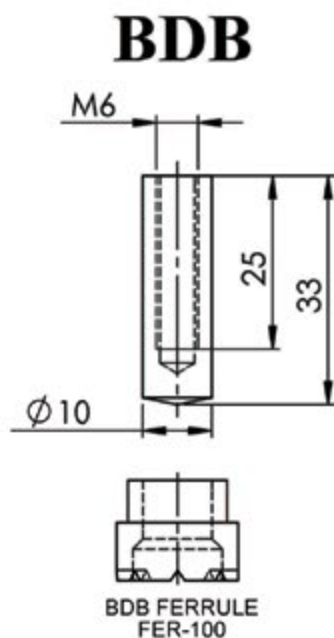
Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

FFT

NOTES :

- BDB dowels are only suitable for FFT.5.25



OPTIONS :

- Intermediate washer : MTC - 045
- Final washer : CFF 040 or LFF 060
- Final ceramic washer : IRI 025 or IRI 050 with IRI 100

DESIGNATION EXAMPLE

LFF - 040 - 310

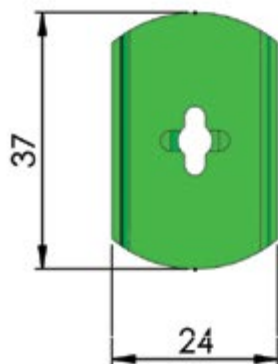
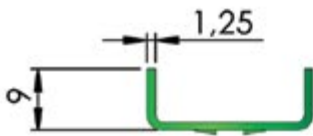
↑ ↑ ↑
 Lockwasher Thickness Alloy

Standard alloys

AISI 304 L
 AISI 310 S
 Inconel 601

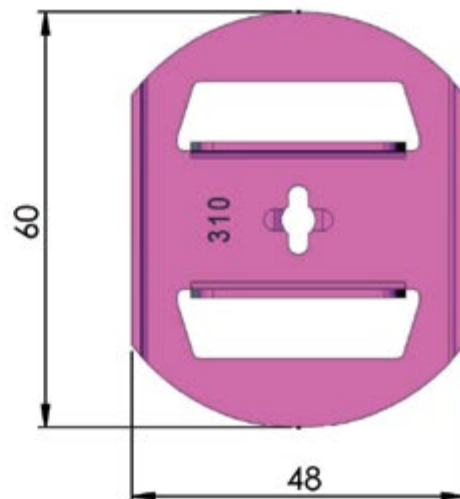
LFF 040

Lockwasher 040



LFF 060

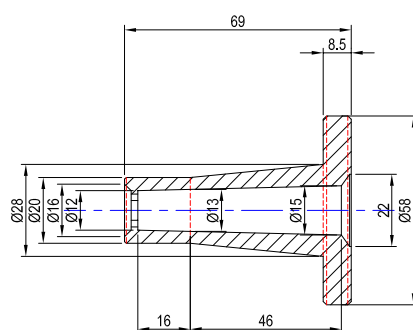
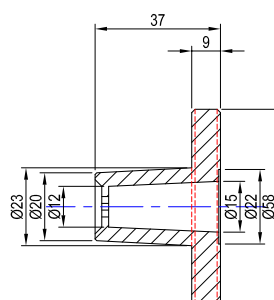
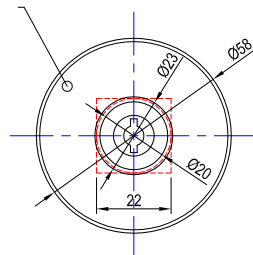
Lockwasher 060



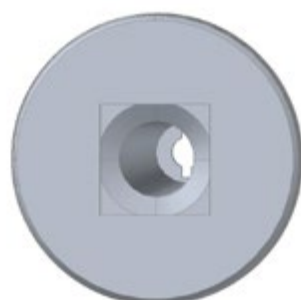
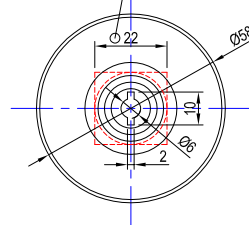
DESIGNATION EXAMPLE

IRI-025 / IRI-050 Ceramic Cuplocks

IRI - 025



IRI - 050



IRI-025 / IRI-050 / IRI-100 TECHNICAL DATA SHEET

STANDARD DIN 40685 CLASSIFICATION : **KER 510**

COMMERCIAL DENOMINATION : **TERMoeLETTICO**

NOMINAL COMPOSITION : **MgO.Al₂O₃.SiO₂**

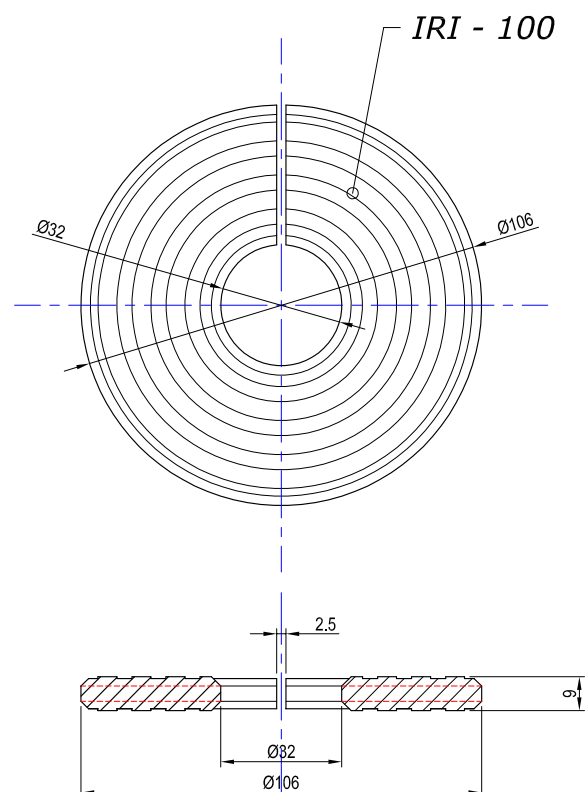
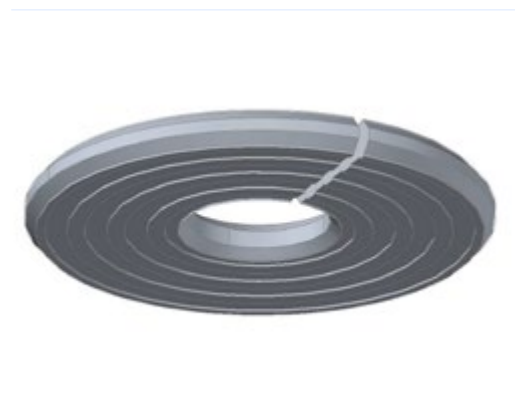
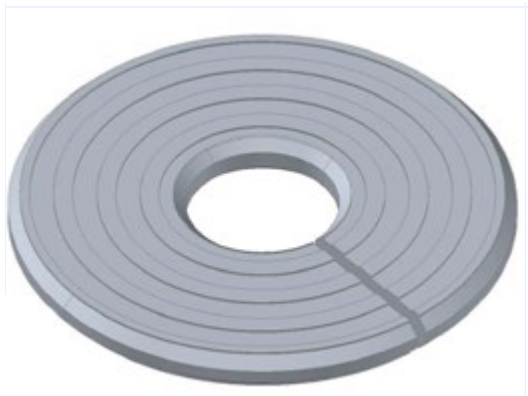
COLOUR : **SAND**

MATERIAL DATA	
Bulk density	1,9 kg/dm ³
Open porosity	10% Vol%
Bending strenght 20°	25 MN / m ² (MPa)
Compressive strenght 20°	230 MN / m ² (MPa)
Specific Head	850 J /Kg° K
Thermal expansion (20°-800°C)	4,5 x 10 ⁻⁶ / °C
Thermal conductivity	1,6 W / m°K
Volume resistivity 20°C 50Hz	10 ^{9 w} cm
Volume resistivity 600°C 50Hz	10 ^{5 w} cm

**Mentionned datas are average values and not guaranteed values.
They can be modified without prior notice.**

DESIGNATION EXAMPLE

IRI-100 Slotted Ceramic Rings



SUITABLE FOR IRI-025 AND IRI-050
THE SLOT IMPROVES TEMPERATURE CHANGES RESISTANCE AND LIFE TIME.



The INSULTWIST anchor system is used to anchor multiple fiber linings. It consists of:

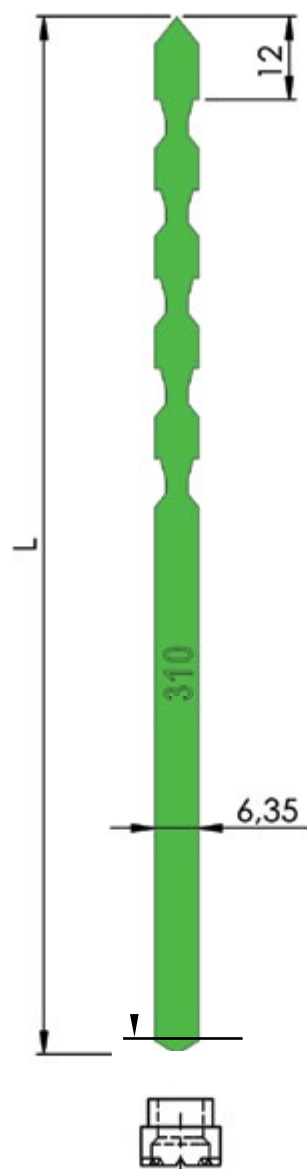
- A flat rectangular stud, section $\pm 6.35 \times 3.17$ mm,
- A hot face lockwasher (LWI),
- In some cases, a ceramic cuplock,
- One (or more) mounting clips (MTC), in order to hold the intermediary layers during installation.

THE STUDS ARE FIXED ON THE STEEL SHELL BY:

- Stud welding: a ceramic ferrule is supplied with the stud,
- Hand welding: the cold face end is bent to 90° , this facilitates the welding.

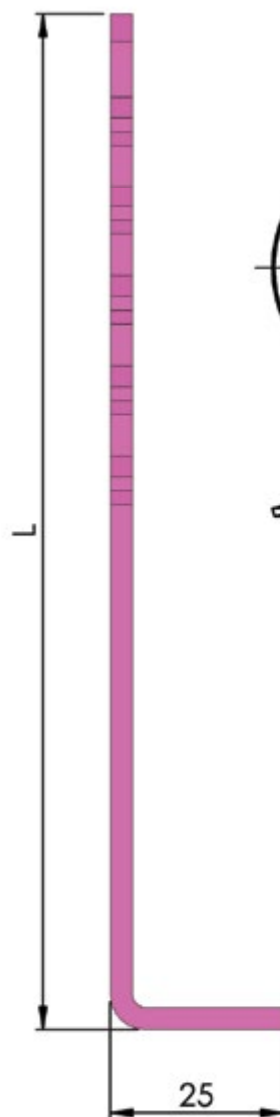
INSULTWIST SYSTEM

Stud Insultwist



Stud Welding

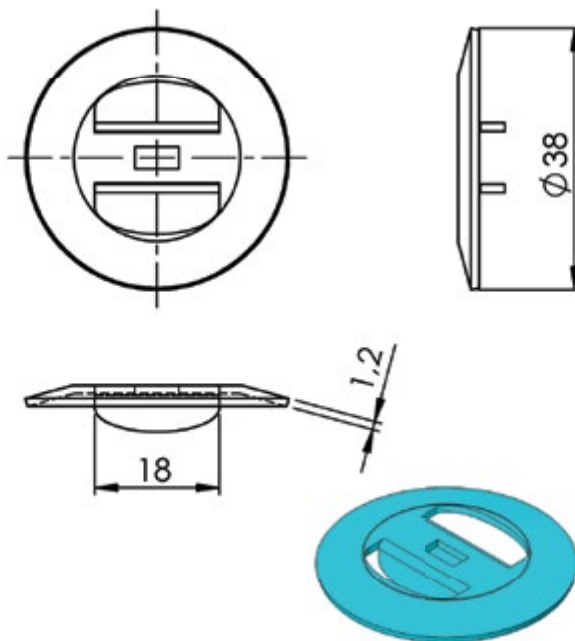
INS



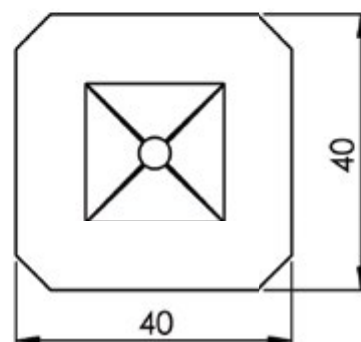
Hand Welding

INH

LWI-038 Round Lockwasher 038



MTC-045 Mounting clip



DESIGNATION EXAMPLE

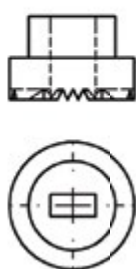
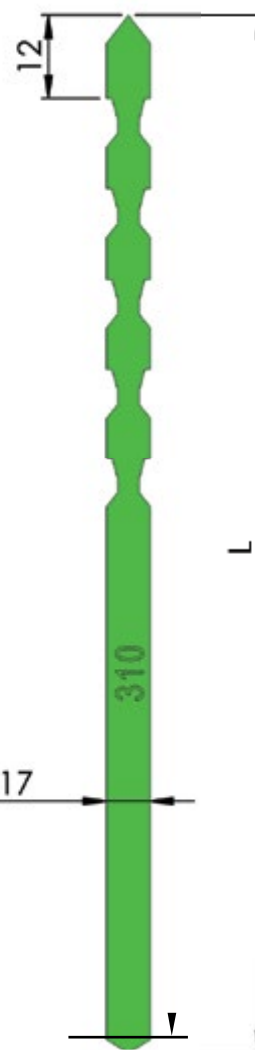
INS - 150 - 310

Anchor type Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

INS



Ceramic Ferrule type FER-603
for stud welding

OPTIONS :

- Intermediate washer : MTC 045
- Final washer : LWI 038

DESIGNATION EXAMPLE

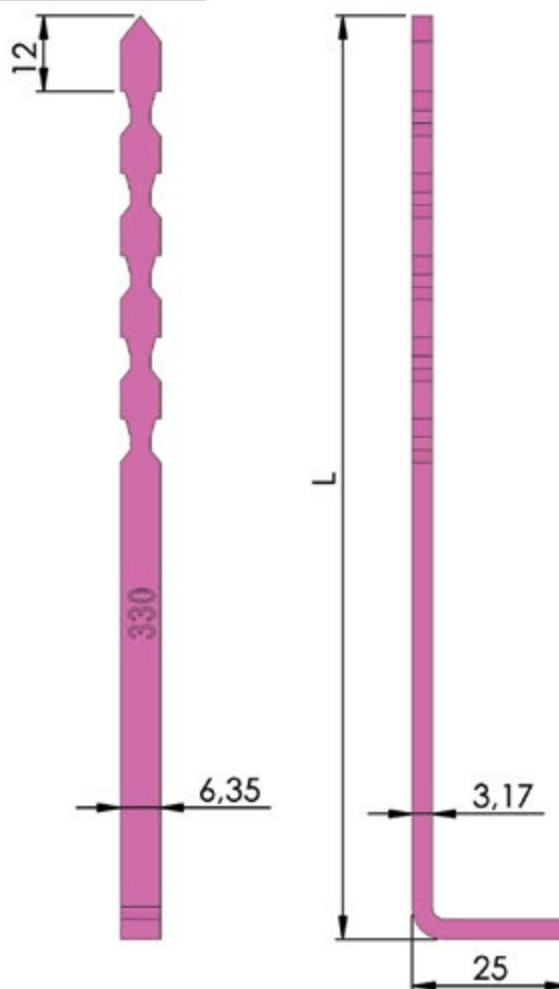
INH - 200 - 330

↑ ↑ ↑
Anchor type Length L Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

INH



OPTIONS :

- Intermediate washer : MTC 045
- Final washer : LWI 038

DESIGNATION EXAMPLE

LWI - 038 - 310

↑
Anchor type

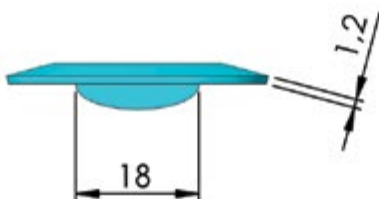
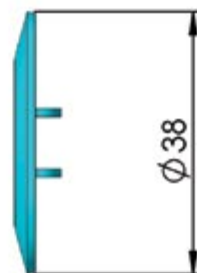
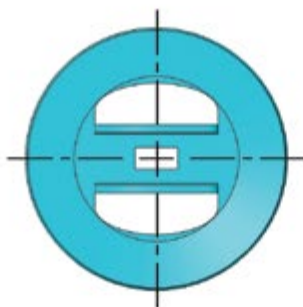
↑
Length L

↑
Alloy

Standard alloys

AISI 304 L
AISI 310 S
Inconel 601

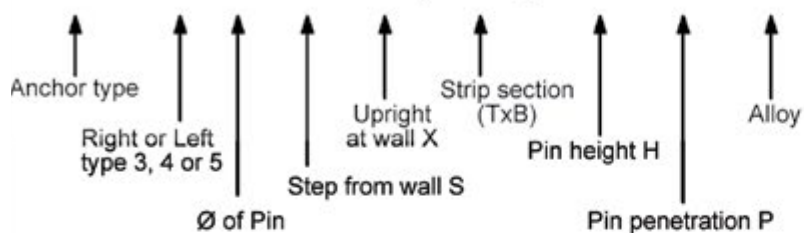
LWI-038
Round Lockwasher 038



LOCKING WASHER

DESIGNATION EXAMPLE

MPU4R.6.075.25(30/3)-350/25-310



Standard alloys

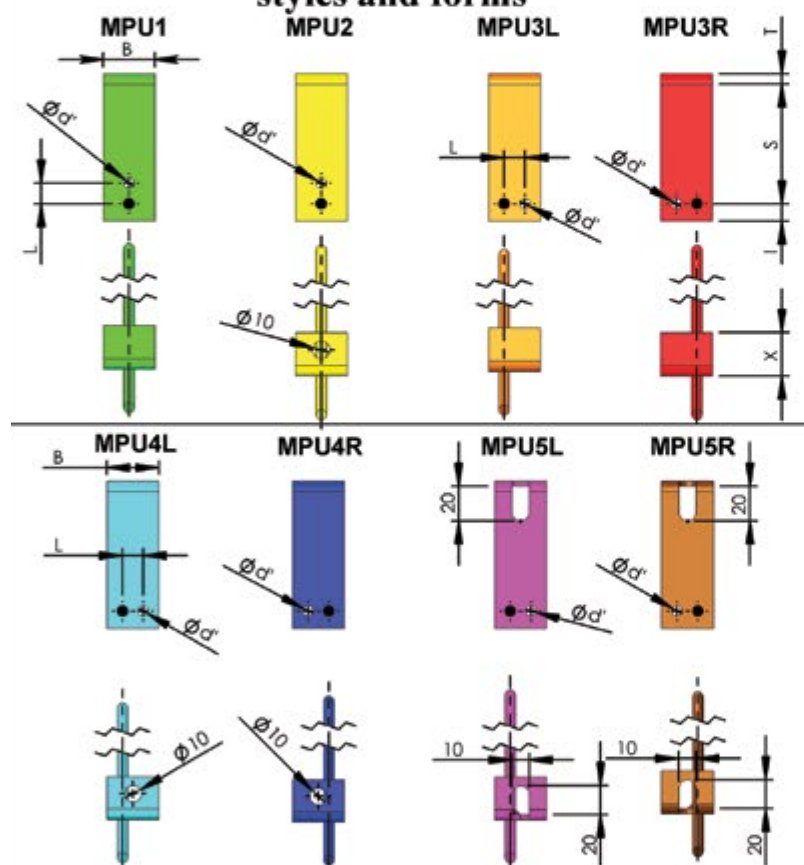
AISI 304 L

AISI 310 S

Ø 5 or 6 mm

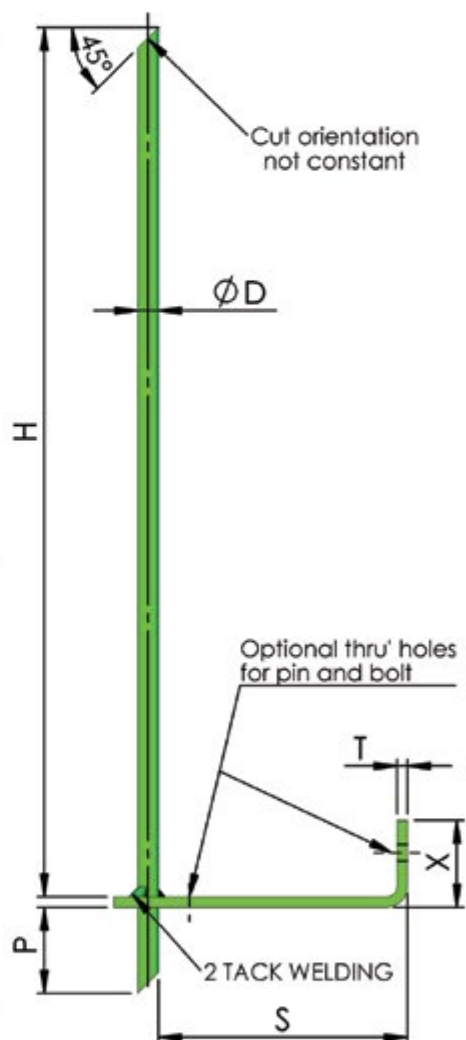
MPU

styles and forms



MPU STANDARD : MPU 3 (R & L) .6.060.25(30/3)-330/20-310

MPU





ANCHORS FOR MODULE LININGS AND “STACK BOND”

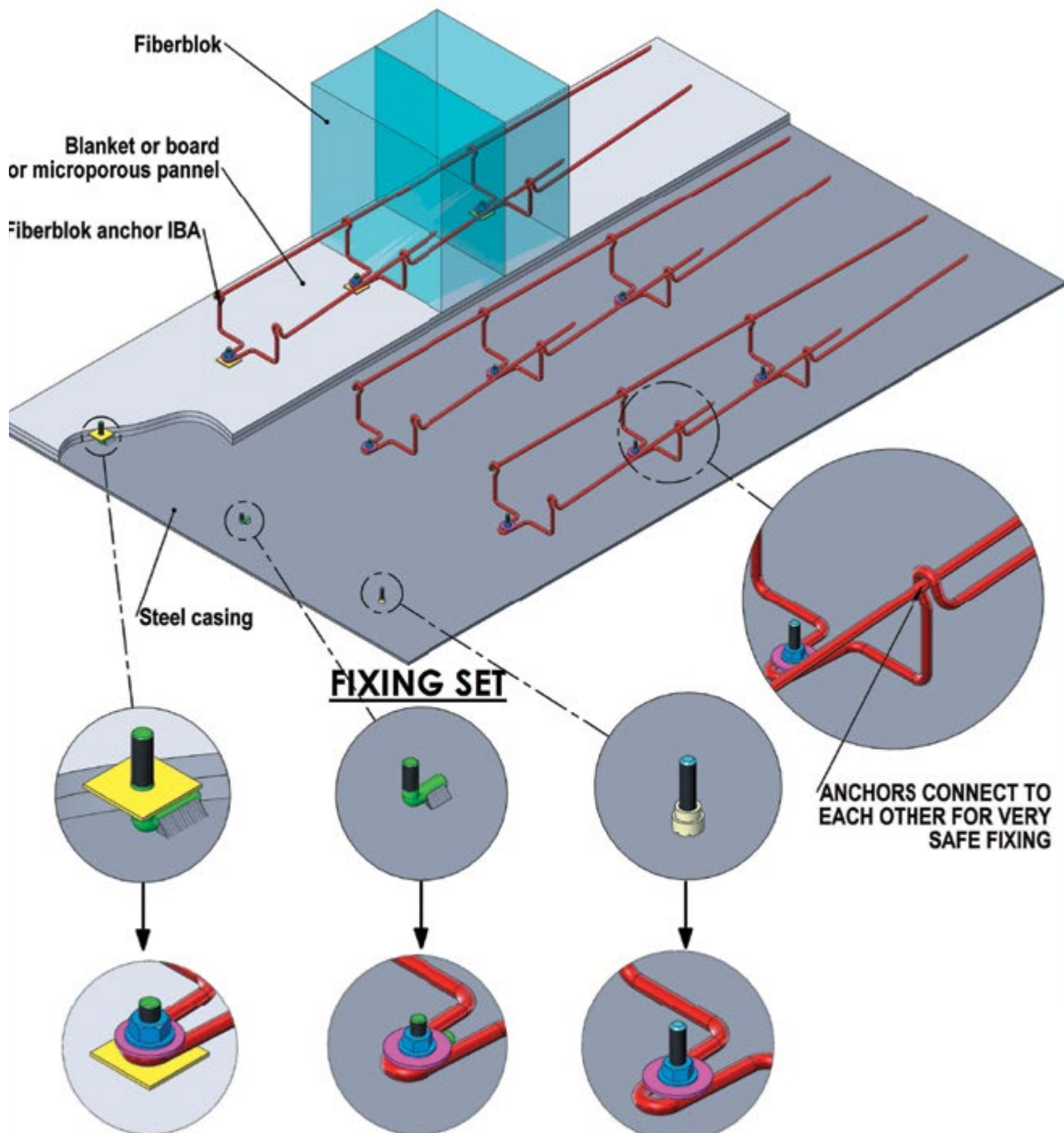
Many systems are available:

- To be involved in a module during manufacturing,
- On site compressed fiber strips or cut pyrologs are impaled over the MPU's round bar forming a block to the desired thickness (STACK BOND).

Those anchors can be welded, bolted or screwed on.

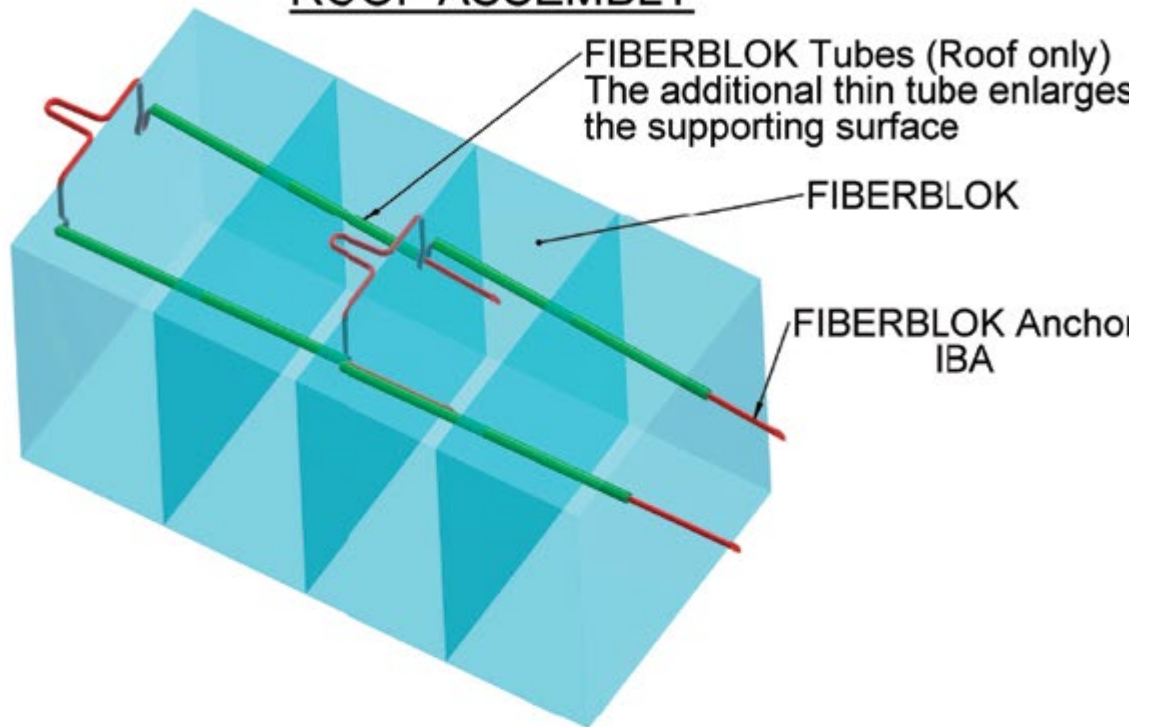
Few sketches are published as most of them are patented by our customers.

FIBERBLOK & FIBERBLOK ANCHOR

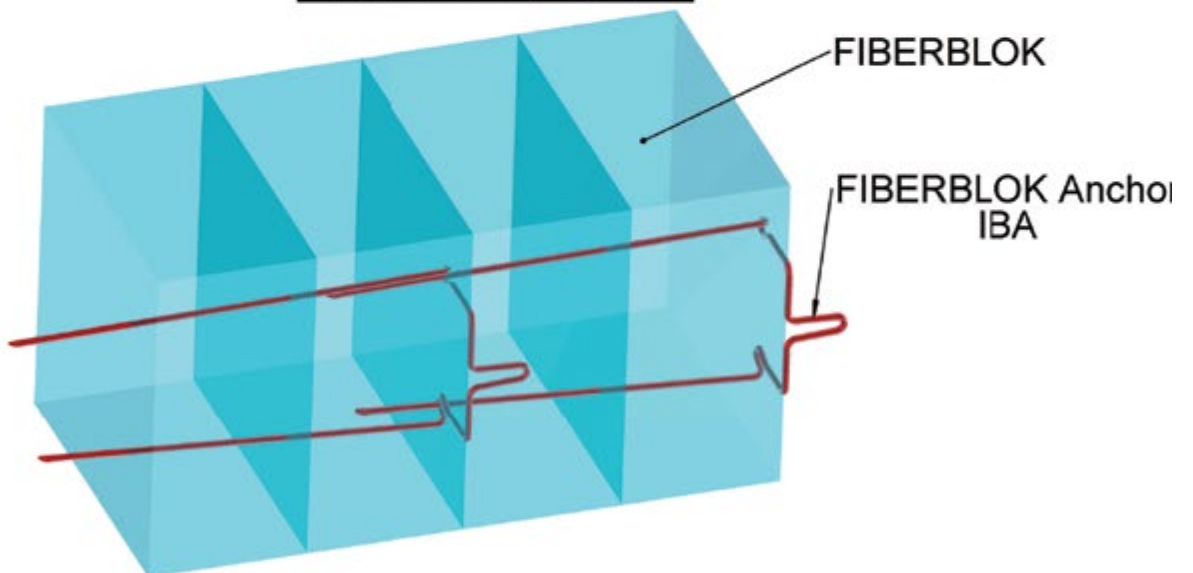


FIBERBLOK & FIBERBLOK ANCHOR

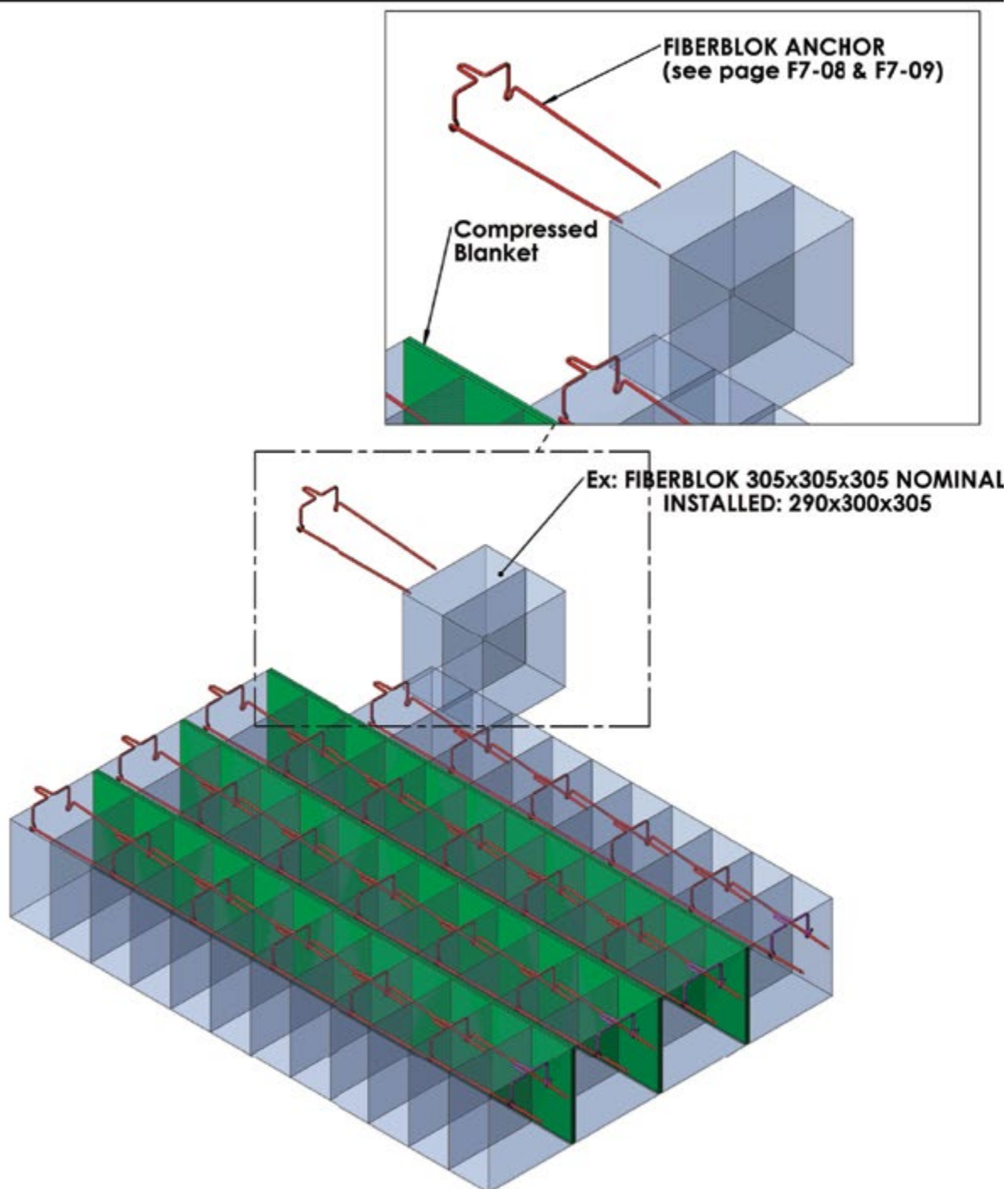
ROOF ASSEMBLY



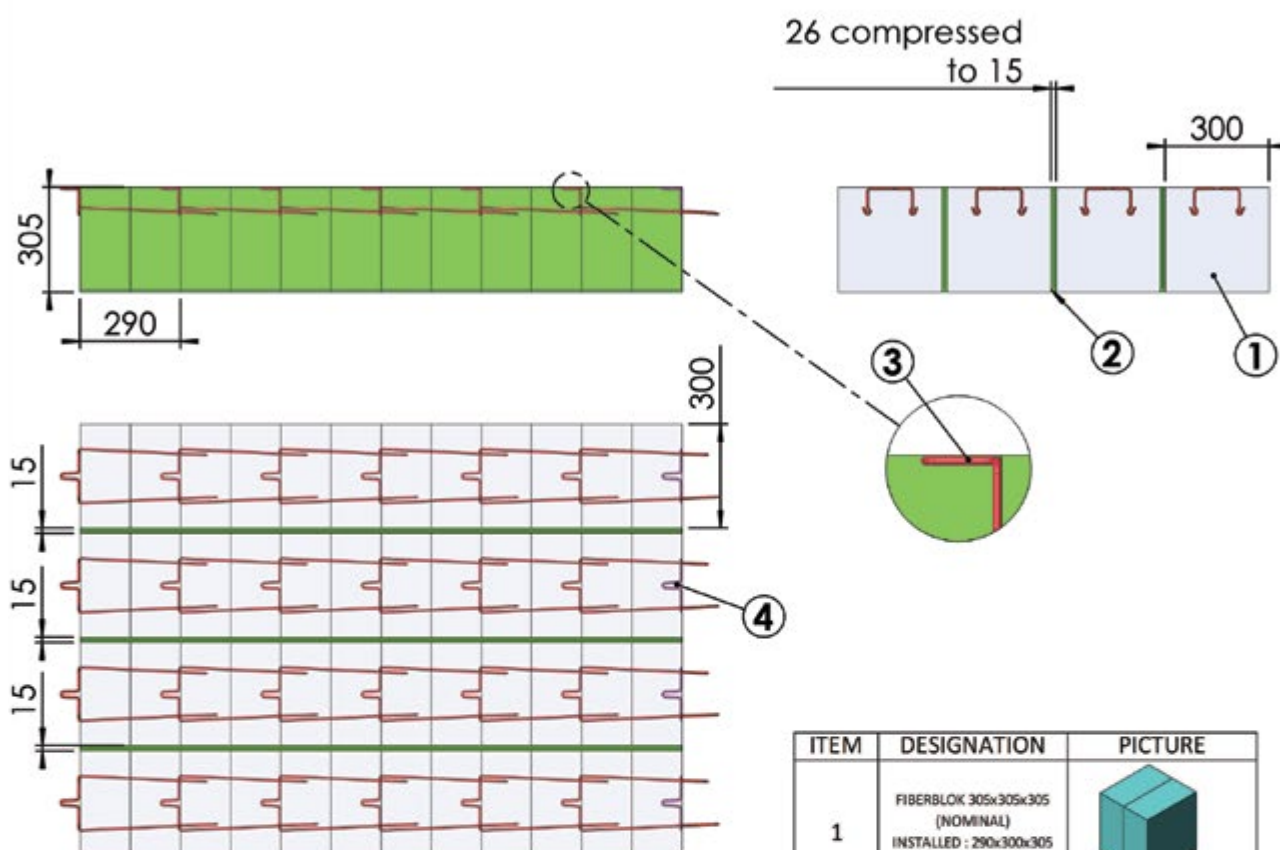
WALL ASSEMBLY



FIBERBLOK & FIBERBLOK ANCHOR



FIBERBLOK & FIBERBLOK ANCHOR



FOR 1 SQUARE METER:

- 11 FIBERBLOKS
- 0.2 Blanket density 96Kg/m³
- thk: 13mm, length 14.6m, width 0.61m.
- 11 Fixing Sets
- 11 IBA

Optional:

- 22 tubes for roof
- 5% of total quantity of IBA in STARTIBA (page F7-10)

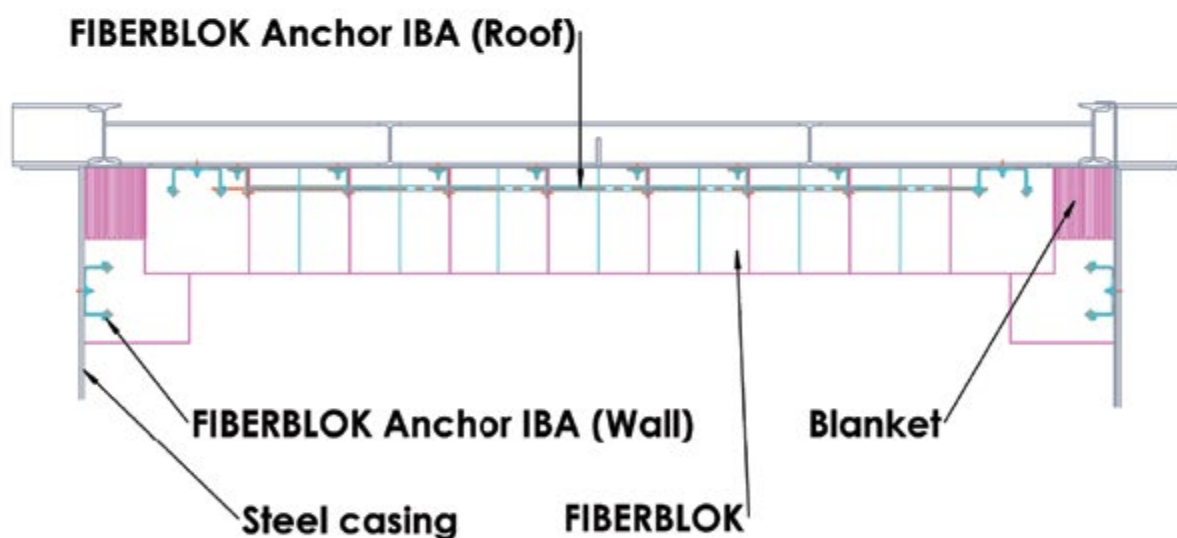
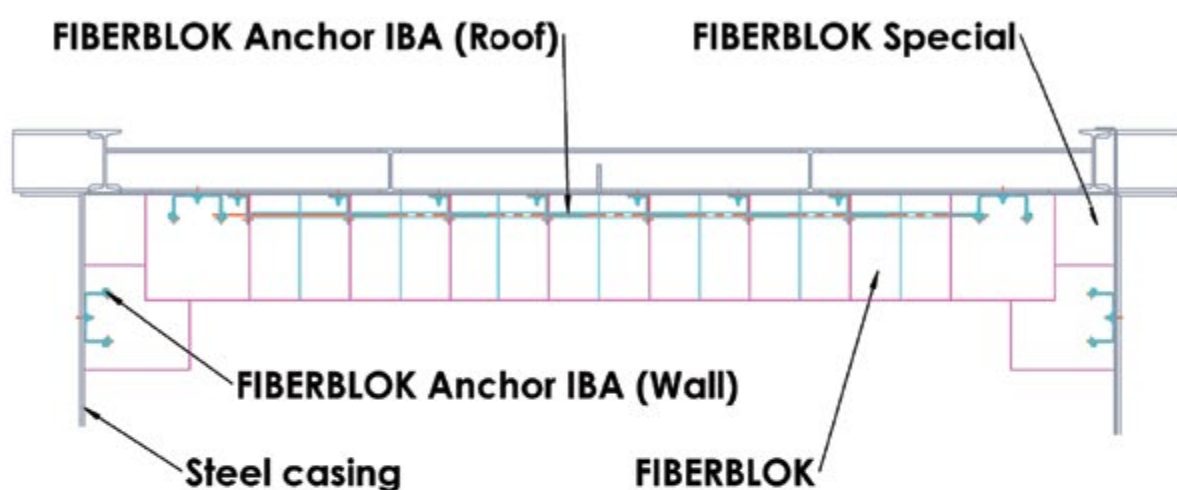
SPARES TO BE ADDED

THEORICAL QUANTITIES TO ADAPT ACCORDING TO SPECIAL LAY OUT.

ITEM	DESIGNATION	PICTURE
1	FIBERBLOK 305x305x305 (NOMINAL) INSTALLED : 290x300x305	
2	BLANKET PACKING 2 x 13 mm = 26 COMPRESSED TO 15 mm	
3	FIBERBLOK ANCHOR IBA	
4	FIBERBLOK STARTING ANCHOR STARTIBA	

FIBERBLOK & FIBERBLOK ANCHOR

INSTALLATION EXAMPLE



FIXING SET FOR FIBERBLOK

NO BACK UP material between FIBERBLOK and STEEL CASING

STUD WELDING EQUIPMENT and SKILED WELDERS AVAILABLE



NUT HM6 or HM8 -DIN934 - AISI 304 or AISI 310



WASHER M8-DIN 125 - AISI 304 or AISI 310



**DRS.6 or 8.RT.040.304 - AB (FULLY THREADED)
(other alloys on request)**

Alu Ball (option "AB") requested from
M8 and more. Makes gun welding easier

Aluminium ball



CERAMIC FERRULE FOR STUD WELDING

1 FIXING SET includes :

1 DRS length 30mm

1 FERRULE

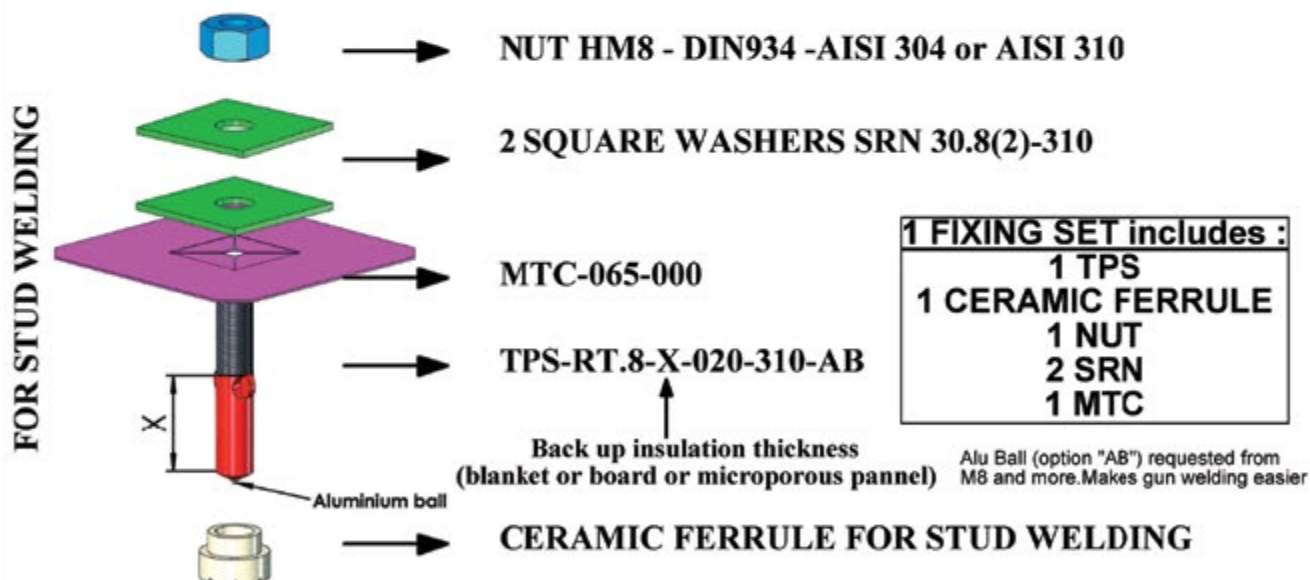
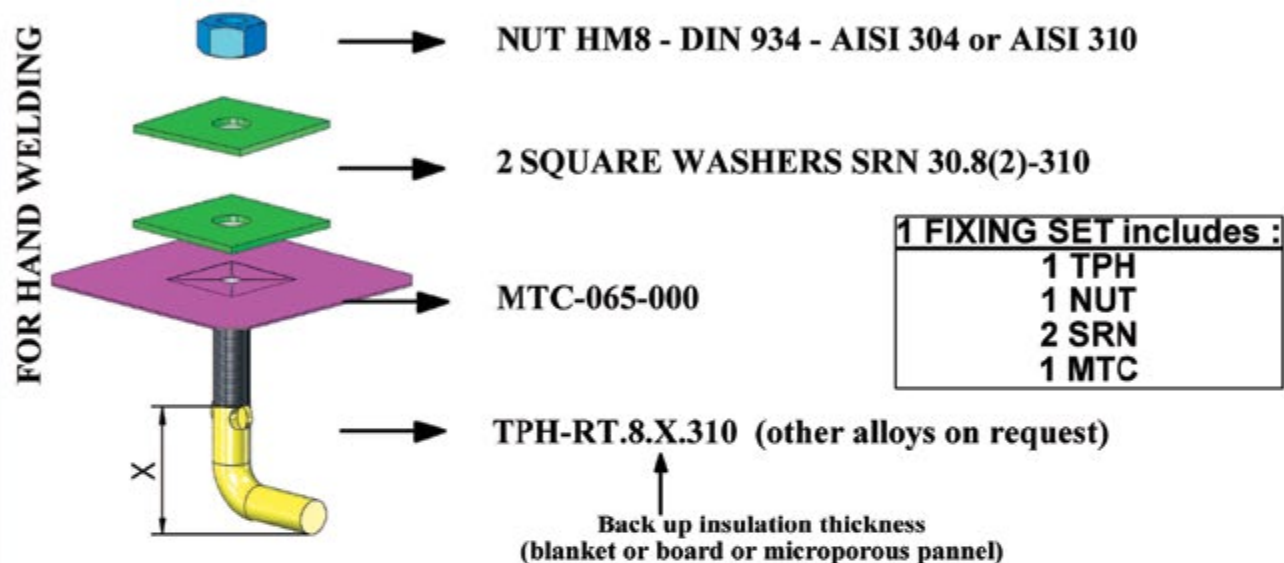
1 WASHER

1 NUT

FIXING SET FOR FIBERBLOK

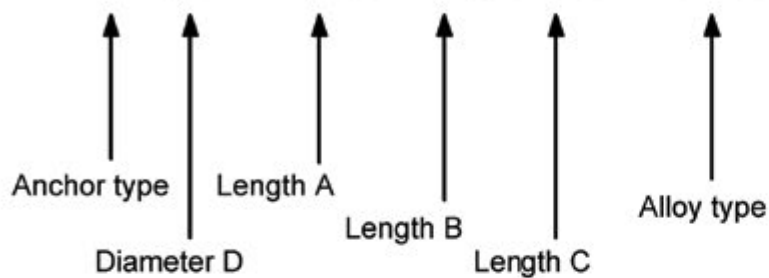
WITH BACK UP BEHIND FIBERBLOK (recommended)

A 25mm blanket is sometimes used but a rigid board 25 or 30mm is much better.
Microporous panel gives much lower heat loss, much better insulation



DESIGNATION EXAMPLE

IBA.6 - 400/155/060 - 310



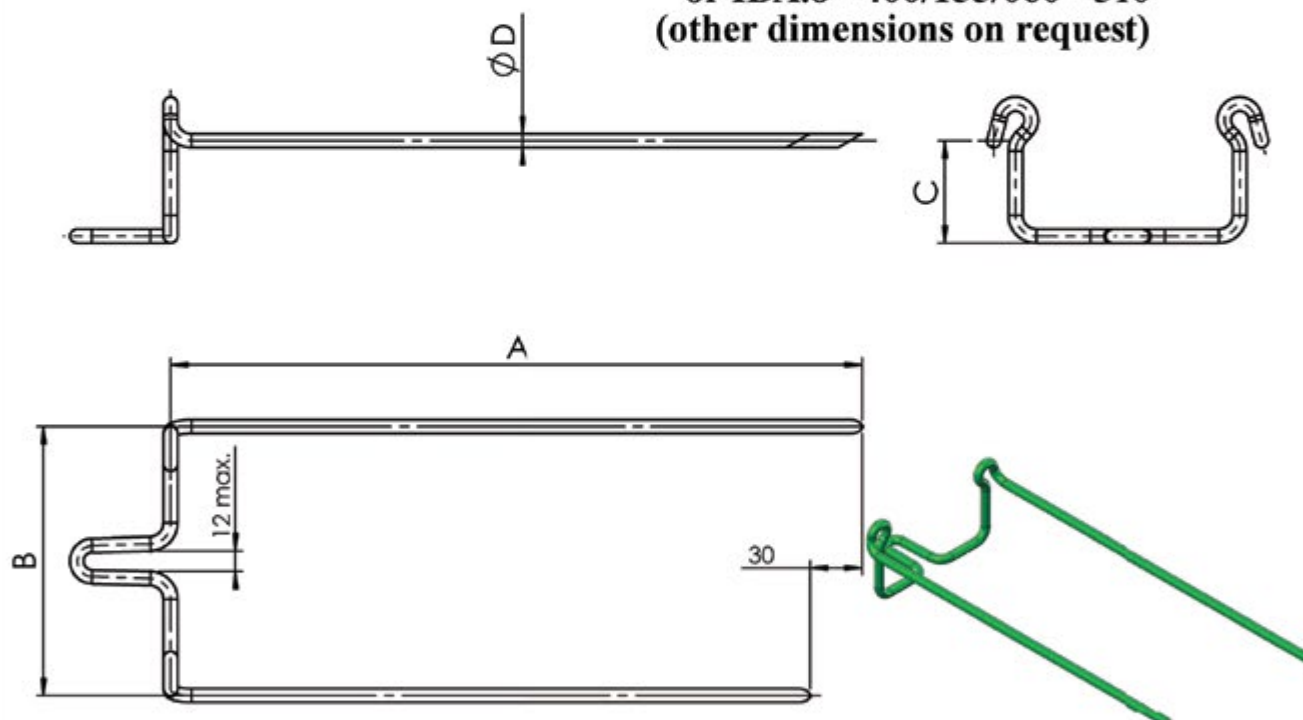
Standard alloys and sizes

AISI 304 L
AISI 310 S

Ø 5 or 6 mm

FIBERBLOK ANCHOR

**STANDARD DESIGNATION : IBA.6 - 400/155/060 - 310
or IBA.8 - 400/155/060 - 310
(other dimensions on request)**

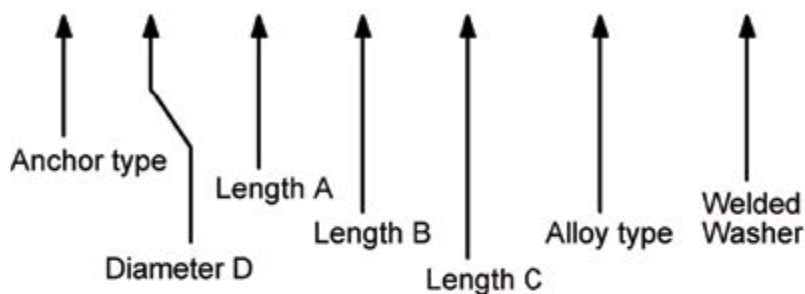


IRIS manufactures anchors from cold drawn wires, with a specific tensile strength, using a "soft bending technique", utilizing robotic machines. This "in house" developed technology, reduces mechanical stress in the steel structure and avoids the formation of micro cracks, through which corrosion can accelerate; and damage the anchors.

Due to the advanced bending methods developed by IRIS, there are mostly no bending marks in our metal anchors

DESIGNATION EXAMPLE

IBA.6 - 400/155/059 - 310 - WW



Standard alloys and sizes

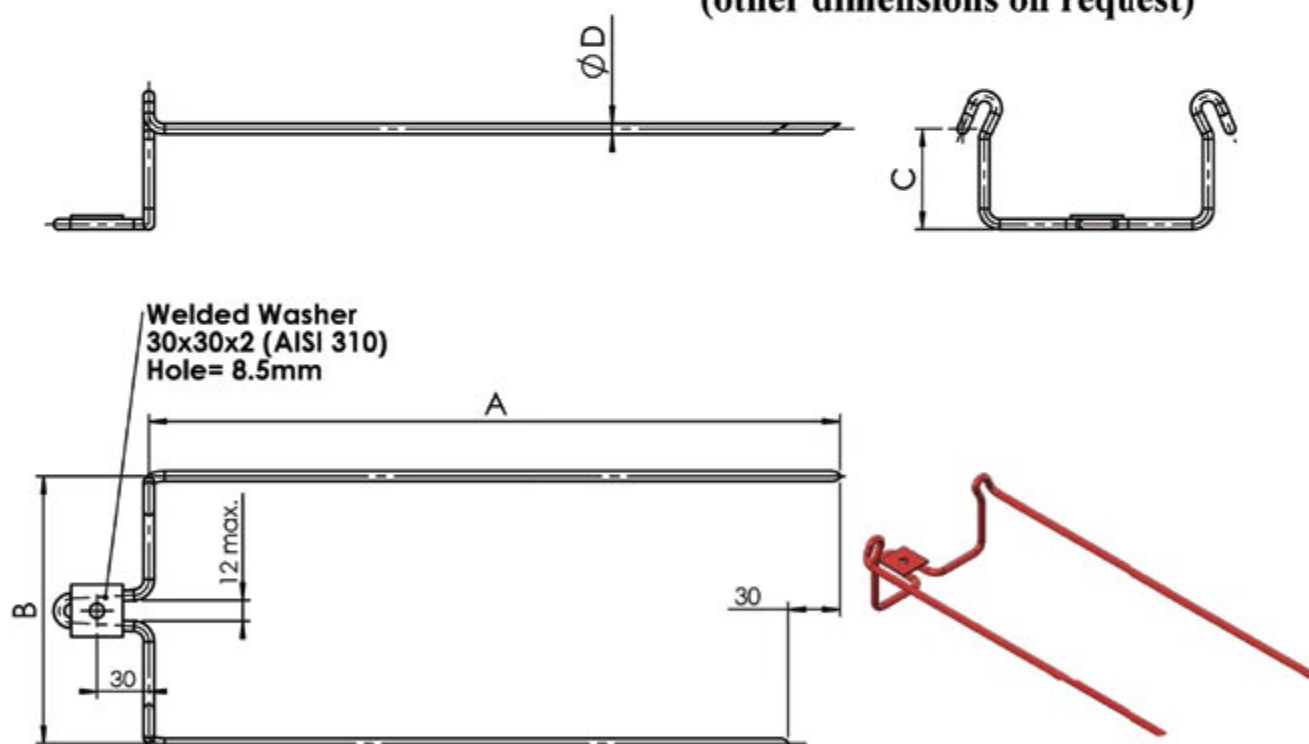
AISI 304 L

AISI 310 S

Ø 5 or 6 mm

FIBERBLOK ANCHOR WELDED WASHER

**STANDARD DESIGNATION : IBA.6 - 400/155/059 - 310 - WW
or IBA.8 - 400/155/060 - 310 - WW
(other dimensions on request)**

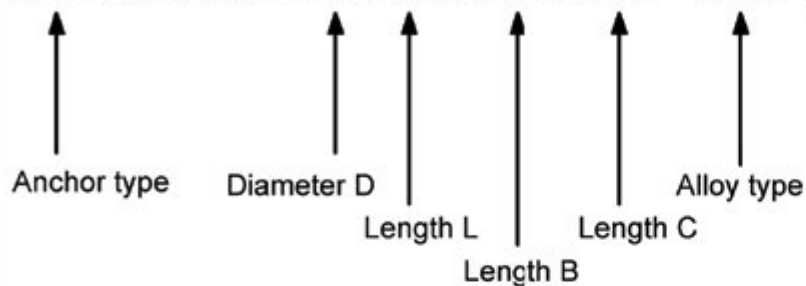


IRIS manufactures anchors from cold drawn wires, with a specific tensile strength, using a "soft bending technique", utilizing robotic machines. This "in house" developed technology, reduces mechanical stress in the steel structure and avoids the formation of micro cracks, through which corrosion can accelerate; and damage the anchors.

Due to the advanced bending methods developed by IRIS, there are mostly no bending marks in our metal anchors.

DESIGNATION EXAMPLE

STARTIBA.6.050.155.059 - 310



Standard alloys and sizes

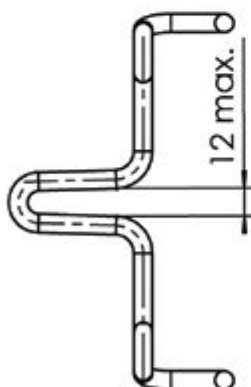
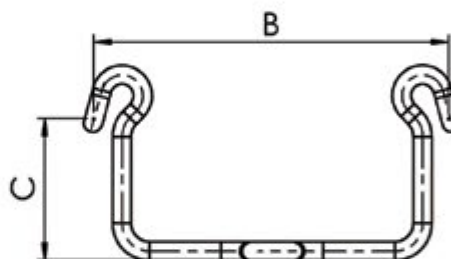
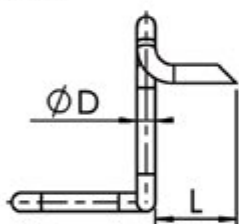
AISI 304 L

AISI 310 S

Ø 5 or 6 mm

STARTING ANCHOR

L mini = 35mm



IRIS manufactures anchors from cold drawn wires, with a specific tensile strength, using a "soft bending technique", utilizing robotic machines. This "in house" developed technology, reduces mechanical stress in the steel structure and avoids the formation of micro cracks, through which corrosion can accelerate; and damage the anchors.
Due to the advanced bending methods developed by IRIS, there are mostly no bending marks in our metal anchors.



TOLERANCES :

Our anchors are submitted to normal manufacturing tolerances. In general, dimensional tolerance average is :

1. $\pm 5^\circ$ on angles
2. ± 2 mm for height ≤ 200 mm
3. ± 5 mm for height > 200 mm

If you need a specific dimensional tolerance for a particular order, please contact us.

SPECIFIC REQUEST :

We use to manufacture customized anchoring systems according to your sketches and specifications. Considering the very high influence of service conditions in many different applications, the data included in our brochures are typical and not specific.

REMARKS :

The values mentionned correspond to production averages, they can be modified without notice. The anchor systems and types can also be improved and modified without prior notice.



Certificat

Certificate

N° 1995/20462.5

AFNOR Certification certifie que le système de management mis en place par :
AFNOR Certification certifies that the management system implemented by:

IRIS SAS

pour les activités suivantes :
for the following activities:

**VENTE ET NEGOCE DE PRODUITS REFRACTAIRES INDUSTRIELS.
FABRICATION D'ANCRAGES EN ACIER REFRACTAIRE.**

**SALE AND TRADE OF INDUSTRIAL REFRACTORIES.
MANUFACTURING OF HEAT-RESISTANT STEEL ANCHORS.**

**VERKAUF UND HANDEL VON FEUERFESTEN INDUSTRIERZEUGNISSEN. HERSTELLUNG
VON VERANKERUNGEN AUS HITZEBESTÄNDIGEM STAHL.**

a été évalué et jugé conforme aux exigences requises par :
has been assessed and found to meet the requirements of:

ISO 9001 : 2008

et est déployé sur les sites suivants :
and is developed on the following locations:

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FR-59328 VALENCIENNES CEDEX**

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This certificate is valid from (year/month/day)

2016-03-07

Jusqu'au
until

2018-09-14

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Managing Director of AFNOR Certification

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THE HIGH TEMP RESPONSE



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