

WITNESS STATEMENT

Criminal Procedure Rules, r27.2; Criminal Justice Act 1967, s.9; Magistrates' Courts Act 1980, s.5b

Statement of: ALLSOP, CLIVE

Age if under 18: OVER 18 (if over 18 insert 'over 18')

Occupation: SECTION LEADER

This statement (consisting of 4 page(s) each signed by me) is true to the best of my knowledge and belief and I make it knowing that, if it is tendered in evidence, I shall be liable to prosecution if I have wilfully stated in it anything which I know to be false, or do not believe to be true.

Signature: C ALLSOP

Date: 29/03/2018

Tick if witness evidence is visually recorded ☐ (*supply witness details on rear*)

This statement relates to my time working on production lines working for Manse Masterdor and subsequently Masterdor under the ownership of Synseal.

I joined Manse Masterdor in March 2004. At this time we only produced wooden doors and I worked as a general operative putting hardware onto the doors. In 2006 or 2007 the company started producing 'GRP' doors and I was given more of a key role. A few months later the company started to produce 'GRP' fire doors. These initially arrive in various sizes we call 'blades'. A normal 'GRP' door blade is easily distinguished from a 'GRP' fire door blade. This is because the structure is made from a hard foam, visible from the top, bottom and sides. The 'GRP' fire door blade has a hard wood surround frame which is visible. At this time the doors were being produced in Ambergate. When we received each blade it would have a sticker/identification label added to the base by the dispatch pickers. This reference would then be added to the machinery known as the CNC, which I think stands for 'computer numerical control'. This generates a spec sheet that tells you exactly the door which is to be made. The size is pre-determined and the beam saw cuts this. The CNC then automatically drills all necessary holes for the appropriate hardware requested on the spec sheet. The hardware is then manually added to the doors by operators. This includes letter boxes, hinges, door knockers, spy holes, 'U' rails, locks and any glazing. The door reference is written in marker on the base of every door after it has been CNC'd. There are two production lines depending on what is required to be produced. Both production lines are able to produce standard 'GRP' doors and 'GRP' fire doors. If it is a fire door then at this point intumescent strips and

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pads are added. All staff know that a standard door and fire door are very different. It is obvious from the spec sheet and the visual appearance of the blade. Staff understand the significance of the fire protection components being very important. It is really stressed strongly while training new starters.

From the start of fire door production back in 2006/2007 this involved placing two intumescent pads at the each of the three locking mechanisms. There was also a 10 mm intumescent strip placed down the locking side of the door that also entered the locking mechanism voids. There was also an intumescent strip placed around the void for the letterbox. There were also intumescent pads placed next to the three sets of hinges (one per hinge). On the glazed glass void no intumescent was applied. The cassette containing the glazing was supported by eight to ten metal brackets (depending on the shape and size of the glazing) to ensure the integrity of the glazed panel. The cassette was finally sealed in a fireproof 'Thixotropic sealant' around the aperture. This was quite thin, like whipped cream and would seep out so you knew it was fully sealed. Excess was then removed. The cassette of the glazing was then clicked together with male/female connectors that clicked into place. The glazed cassette was a snug fit due to the accuracy of the CNC in cutting the void.

At some point the production process changed. I really cannot recall when this was but if I had to guess I would say 2009 or 2010. My supervisor, Peter WITTON and manager Gary FOX had meetings with a fire assessor or someone to do with fire safety every few months at the time. I'm not sure but think he may have been called Danny. I recall Peter referring to him as 'Dan the fireman'. From what I was lead to believe he had advised that there was no need for the intumescent pads by the locking mechanisms with the exception of the internal pad by the central lock where the key hole and handle were. He also omitted the 10mm intumescent strip from the locking side of the door. He also advised the letter box intumescent strip was not necessary as there was one already on the letterbox itself. Also, the number of metal brackets was reduced to between two and four per glazed pane as being sufficient. Finally, he advised the 'Thixotropic sealant' used as a mastic around the cassette containing the glazed panels could be omitted and replaced by normal sealant used on standard GRP doors. However the entire aperture was to now be fitted with a 30 mm intumescent strip. Because of these recommendations from then on, we constructed the doors as he had advised. I imagine there were savings on materials. I have drawn a diagram of the early doors and the fireproofing applied and the subsequent doors produced after these recommendations. I exhibit this as CKA/01. Quite a lot of us thought they are cutting back on the materials but thought as

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we had been advised from an expert that it was alright. The frames to the best of my knowledge have never been changed.

About three or four weeks ago, late February 2018, we were instructed to use different metal clips to support the fire proof glazing cassette to the doors. I have drawn a clip we were using between 2006 until three or four weeks ago and the new 2-part clip and exhibit this as CKA/03. The new clip will hold the glass in a lot better. We were instructed to use more of them and produce the doors as we did prior to the changes. This I believe is a precaution following the recent issue of a door reportedly failing a test. However we continue to use the same mastic around the cassette as is used in the non-fire doors rather than the 'Thixotropic sealant' used originally.

Once off the production line each door was stood up on a vertical rack and then matched with an appropriate frame. The frame production is carried out under the supervision of Troy SUTCLIFF. Each frame is specific for each blade so the door reference numbers are matched up. The frame and blade are then attached to create the finished door set. A label is attached to every door at the factory containing a unique identification number. I have added my comments to a picture of a label which I exhibit as CKA/02. Finally the door set is 'cleaned and packed'. This is a simple wipe down of dust, a check for scuffs or scratches and if it ok, packed ready to be delivered. No doors are kept in stock, they are all built to order for specific addresses.

There have always been busier and slower times on the production lines over the years. However there has never been a time when the demand has been too much for us to cope with. No matter how busy we were, a fire door would always have been manufactured as a fire door. There were no cutting corners or anything like that. Care was always taken and a no door, fire or otherwise was ever rushed. We glazed all of our standard and fire doors. We never bought stock with glazing already fitted to them. The glazing was originally bought in and put together onsite at Dewent. In November 2014 'Synseal' bought the company Manse Masterdor. They already owned 'Global Glass'. From here on the glass was supplied by them. The glass itself has always been 'kite marked' and it was always paze in a bottom corner. The blades and cassettes have always been supplied by 'Distinction' who I think get them from Taiwan. Sometimes the blades are delivered with damage or warping. These are always rejected and returned. The 60 minute fire doors never have glazing and have always had all the intumescent strips and pads

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positioned as the original 30 minute fire doors. In addition they have two intumescent strips on the top of the door. The vast majority of doors are sold as door sets with hardware fitted. Occasionally doors are produced without a frame. Normally it is just a few at a time. I presume to replace damaged doors that were previously bought from us where the customer already has a frame or conversely just a frame. Very few, just half a dozen a week out of several hundred. Occasionally a door will be produced with no hardware fitted but holes drilled.

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