



# SandMat Drop IN

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**GENERAL**

**01**

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## 1. GENERAL

The following specification is a sample guideline that can be customized by the engineer to prepare requirements for a specific site. This information is provided for reference purposes only and is not intended as warranty. Eurobent Sp. z o.o. does not assume any liability in connection with the use of this information.

This document describes the basic content of the most important documents and facts related to quality and production management in our company.

It should be noted that SandMat is one of our main products, nevertheless all principles related to quality and production apply also to other products from our range.





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# NORMATIVE REFERENCES

02

## 2. NORMATIVE REFERENCES

### 2.1 Harmonized technical specification

1. **EN 13249:2016** - Geotextiles and geotextile-related products - Characteristics required for use in the construction of roads and other trafficked surfaces (excluding railroads and asphalt pavements)
2. **EN 13250:2016** - Geotextiles and geotextile-related products - Characteristics required for use in the construction of railroads
3. **EN 13252:2016** - Geotextiles and geotextile-related products - Characteristics required for use in drainage systems
4. **EN 13253:2016** - Geotextiles and geotextile-related products - Characteristics required for use in erosion control (bank protection and shore protection)
5. **EN 13254:2016** - Geotextiles and geotextile-related products - Characteristics required for products used in the construction of reservoirs and dams
6. **EN 13255:2016** - Geotextiles and geotextile-related products - Characteristics required for use in the construction of canals
7. **EN 13265:2016** - Geotextiles and geotextile-related products - Characteristics required for use in liquid waste containment



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# DEFINITIONS

03



### 3. DEFINITIONS

- 1 **GTP** – a combined product at a producer facility of which at least one component is a geosynthetic product – Geocomposite in accordance to EN 10318 – planar, permeable, polymeric (synthetic or natural) material used in contact with soil and/or other materials in geotechnical and civil engineering applications, which does not comply with the definition of a geotextile.
- 2 **SandMat** - Geocomposite consisting of quartz sand, encapsulated between two geotextiles, held together thanks to needle-punching process.
- 3 **Geotextile** - A semi-permeable woven or nonwoven fabric used to encapsulate the quartz sand used in a GTP.
- 4 **Needle-punching** - A process whereby boards of barbed needles incorporate the staple fibers from a nonwoven geotextile, through a quartz sand, into the composite of a second geotextile layer.
- 5 **ITR** - Internal Test Report, also called MQA or Mill test etc.
- 6 **BAW** – Bundesanstalt für Wasserbau – Federal Waterways Engineering and Research Institute
- 7 **RIP-RAP** – also known as rip rap, shot rock, rock armour (in British English) or rubble, is human-placed rock or other material used to protect shoreline structures against scour and water, wave, or ice erosion.





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# QUALIFICATIONS

04



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# QUALITY MANAGEMENT

05

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## 5. QUALITY MANAGEMENT



Eurobent has an in-house laboratory where qualified staff ensures product quality from the receipt of raw materials, through the production process, to testing on finished products.



Cooperation with external certified laboratories allows continuous control of our products and their level of testing in our plant.



ISO, CE and other certificates, which we renew through periodic audits, attest to the highest level of our production and quality control.





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**ABOUT  
EUROBENT**

**06**

## 6. ABOUT EUROBENT

Eurobent Sp. z o.o. is a Polish company from Lower Silesia.

Eurobent entered the geosynthetics production market in 2008. The company is a team of young, dynamically developing people. Thanks to the high standards of its products and the professional service Eurobent has earned the trust and respect of some of the largest GTP consumers in the European market and beyond. At the same time, thanks to many years of experience in the field of geosynthetics production, the company has been able to develop invaluable knowledge in the production of GTP, which has enabled them to become an innovative and acknowledged competitor on the international market.

A company is built by talented people committed to provide the best service and products available on the international market.

Eurobent's laboratory technicians constantly undertake numerous tests on our products to ensure that their high standards are constantly maintained.

Eurobent is committed to constantly review the service we provide. The company aims to provide the highest quality product and also ensure that it would be manufactured, stored and transported in the way to minimize the negative impact on the environment. The customers can be sure that they purchase an environmentally friendly product from a company that is committed to environmental protection.

One of Eurobent's main products is SandMat which consists of a non-woven geotextile or PP composite layers and a quartz sand embedded inside. It can be used successfully in scour protection, filtration and drainage.



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# LABELING, DELIVERY & STORAGE, HANDLING

07

## 7. LABELING, DELIVERY & STORAGE, HANDLING

### 7.1. Labeling

SandMat is labeled according to EN ISO 10320 for easy identification after unloading and during installation. Each roll shall be marked with the following information:



Manufacturer's name



Product identification



Roll number

### 7.2. Delivery and storage

SandMat is usually provided in rolls with a width of 5,0 m and a length of 35 m. Rolls can be also offered in other dimensions, depending on customer needs. Average roll diameter is approximately 60-70 cm, and the weight is approximately 1000 kg. SandMat rolls are wound on plastic tubes with an inner diameter of 10 cm. Every roll is packed in a plastic, UV resistant sleeve. All rolls are marked with a label containing the information about dimensions, lot and a unique, traceable roll number.

Each roll is equipped with a set of two lifting straps. It is recommended to put a steel core inside the roll while unloading material from the truck to prevent bending of the roll.

While storing SandMat rolls do not place them directly on the ground but on pallets or similar constructions underneath. Rolls should not be stacked in more than 4 rolls high.

SandMat rolls should not be directly exposed to the bad weather conditions during the storage. All rolls shall be covered with a plastic sheet or a tarpaulin. Do not remove the plastic sleeves prior to installation.

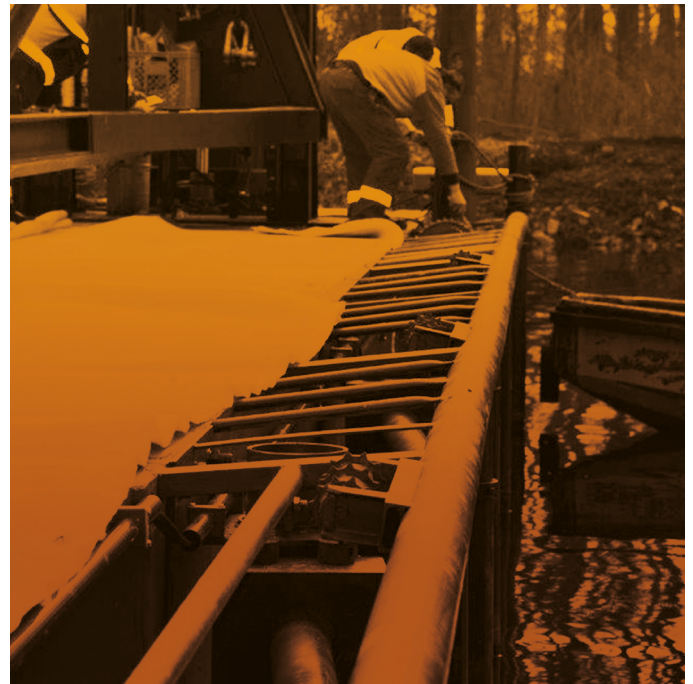
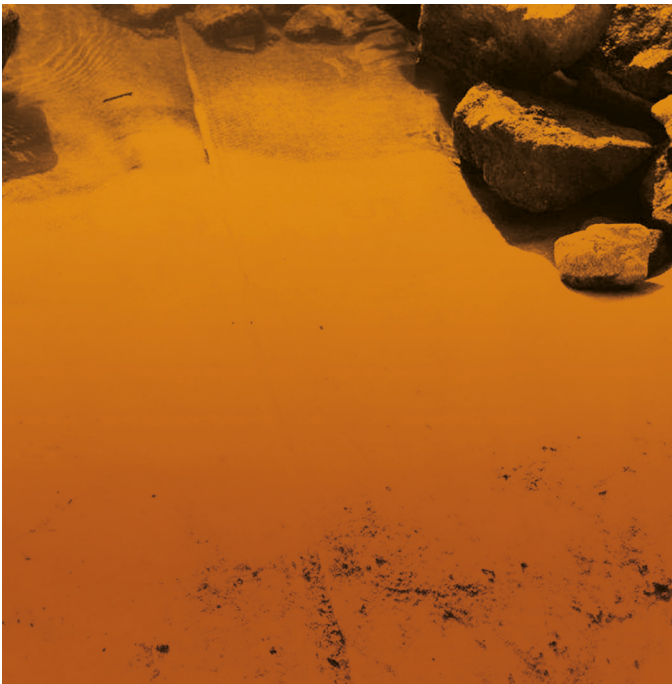




### 7.3. Handling

The QCA inspector shall verify whether handling equipment does not pose any danger to installation personnel or risk of damage/deformation to the liner material itself. Suitable handling equipment is described below:

1. **Spreader Bar Assembly** - A spreader bar assembly shall include both a core pipe or bar and a spreader bar beam. The core pipe shall be used to uniformly support the roll when inserted through SandMat core while the spreader bar beam will prevent chains or straps from chafing the roll edges.
2. **Stinger** - A stinger is a rigid pipe or rod with one end directly connected to a forklift or other handling equipment. If a stinger is used, it should be fully inserted into the roll to prevent excessive bending of the roll when lifted.
3. **Straps** - A properly structured and supported pole or “carpet puller” can be used to unload SandMat rolls on site. As an alternative, straps that are appropriately rated and located across the roll can be used as approved lifting method to unload SandMat rolls.



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# AFTER DELIVERY INSPECTION

08



## 8. AFTER DELIVERY INSPECTION



1. Each roll shall be visually inspected when unloaded to determine if any packaging or material has been damaged during transit.
2. Repairs to damaged SandMat shall be performed in accordance with installation manual:
  - a. Rolls with visible damage shall be marked and set aside for closer examination during deployment.
  - b. Minor rips or tears in the plastic packaging shall be repaired with moisture resistant gluing tape prior to being placed in storage to prevent moisture damage.
  - c. SandMat rolls delivered to the project site shall be only those indicated on internal test reports (ITR).
3. Preserve integrity and readability of roll labels.



AFTER DELIVERY INSPECTION

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# WARRANTY

09



## 9. WARRANTY



1

Material shall be warranted against Manufacturer's defects for a period of 50 years from the date of purchase.

2

Installation shall be warranted against defects in workmanship for a period of 1 year from the date of project completion.

WARRANTY

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# PRODUCT & QUALITY

10

## 10. PRODUCT & QUALITY

### 10.1. What is SandMat and where can you use it?

SandMat was designed especially for filtration in flood embankments, on slopes and waterway bottoms for stabilisation, as well as in similar applications such as dams, side ditches etc. Due to its flexibility, strength and robustness SandMat has proved to be extremely durable in the protection of coastal structures. Thanks to the sand balast, SandMat can also be used in underwater installations.

It is perfect for use in all coastal locations such as seawalls, breakers, groynes, dykes and embankments.

SandMat can be used for the protection of waterways and marine environments. SandMat is an excellent alternative to classic materials such as gravel. In the case of water pressure differentials (e.g. groundwater diversion) or turbulent stresses (e.g. wave impact), geotextiles can prevent soil movement downslope in the boundary layer.

SandMat can be used to prevent the erosion and displacement of subsoils in coastal projects and other sensitive environments.

Top soil, concrete blocks, riprap as well as armourstones can be placed directly onto a SandMat surface due to its proven strength and flexibility.

The following puncture resistance classes have been tested in Federal Institute of Engineering and Waterways Research (BAW), for the individual SandMat types:

- 1800 Nm drop energy complies with armourstone grading LMB10/60 under the terms of DIN EN 13383-1
- 1200 Nm drop energy complies with armourstone grading LMB5/40 under the terms of DIN EN 13383-1
- 600 Nm drop energy complies with armourstone grading CP90/250 under the terms of DIN EN 13383-1



The restrictive testing at BAW also determined the soil type in which the SandMat can work - soil type BT C. At the same time the following confirmation of durability for 50 years in soils with  $4 < \text{pH} < 9$  and soil temperatures  $< 25^{\circ}\text{C}$  have been obtained.

SandMat can be installed quickly and accurately both, in dry conditions and underwater, also from marine vessels, due to its sand balast.

SandMat with its unique structure is used when there is a lack of filtration stability between two soil layers or when hydrodynamic stresses can cause particle displacement. This situation usually occurs in the case of stabilisation of slopes and bottoms of waterways, as well as dams, dikes.

SandMat is highly effective in erosion control at higher current velocities and strong water movements. This is due to its calculated elongation capacity, providing long-term protection and stability for the fortifications.

SandMat is an environmentally friendly product and a perfect solution for waterways where high filtration efficiency, revetment's stability and abrasion resistance due to wave action is required.

## 10.2. How do we ensure the highest quality?

Eurobent only works with the best and proven raw material suppliers. Contractors are certified and are leading manufacturers in their industry. The delivery control system in accordance with the Internal Quality Control Plan and ISO requirements ensures that our products are manufactured from the best components available on the market.

All products manufactured by Eurobent guarantee the highest quality and specification compliance through the manufacturing process and selection of the highest quality components.

Depending on project requirements and specifications, Eurobent use various combinations of geotextiles in production. SandMat products are developed according to customer requirements and design specifications, while complying with EN 13249:2016, EN 13250:2016, EN 13253:2016, EN 13254:2016, EN 13255:2016, EN 13265:2016.

SandMat is tested according to the most stringent requirements, as it has been approved by passing tests at the Federal Institute of Engineering and Waterways Research (**BAW**), which has developed a soil test procedure for assessing the suitability of a geotextile as a filter in shipping channels.

External dynamic and hydraulic filter stresses in waterways channels are simulated by:

- the flow test procedure (rapid sinking and rising of the water level) and
- turbulence test methods (turbulent wave motion, propeller flow, backwash flow).

SandMat product range offers numerous needle-punch geocomposites that meet these essential requirements.

## 10.3. Materials

1. Acceptable Products:
  - a. SandMat
  - b. Engineer approved alternative
2. Alternative Materials:
  - a. Prior to considering an alternative material, the Contractor shall submit certified test results and statements of quality from the proposed GTP supplier to the engineer, indicating without exception that the proposed GTP meets the requirements of this specification. Submittals shall be delivered to the engineer in a minimum of five business days in advance of the bid.

## 10.4. SandMat Properties

SandMat shall be in accordance with the test methods, test frequencies and material physical properties as listed in the following data sheets. Control Plan and ISO requirements ensures that our products are manufactured from the best components available on the market.





## TECHNICAL DATA SHEET

### EUROBENT SANDMAT 600/200

Needle punched composite, consisting of quartz sand, embedded and fixed between two layers of geotextile.

Properties of geotextile	Test Method	Frequency	Value
Carrier Layer - PP Nonwoven	EN ISO 9864	20,000 m <sup>2</sup>	600 g/m <sup>2</sup>
Cover Layer - PP Nonwoven	EN ISO 9864	20,000 m <sup>2</sup>	200 g/m <sup>2</sup>

GTP Properties	Test Method	Frequency	Value
Mass per unit area of Quartz Sand	EN 14196	4,000 m <sup>2</sup>	4700 g/m <sup>2</sup>
Mass per unit area of GTP	EN 14196	4,000 m <sup>2</sup>	5500 g/m <sup>2</sup> (±10%)
Thickness	EN ISO 9863-1/-2	4,000 m <sup>2</sup>	9,5 mm (±1mm)
Tensile strength MD	EN ISO 10319	4,000 m <sup>2</sup>	40 kN/m (-4kN/m)
Tensile strength CMD	EN ISO 10319	4,000 m <sup>2</sup>	60 kN/m (-6kN/m)
Elongation at break MD	EN ISO 10319	4,000 m <sup>2</sup>	70% (±30%)
Elongation at break CMD	EN ISO 10319	4,000 m <sup>2</sup>	70% (±30%)
CBR	EN ISO 12236	4,000 m <sup>2</sup>	7,0 kN (-0,7kN)
Opening Size	EN ISO 12956	25,000 m <sup>2</sup>	73,9 µm (±20 µm)
Water permeability	EN ISO 11058	25,000 m <sup>2</sup>	17,65 mm/s (-0,41mm/s)
Resistance to abrasion loads	RPG of BAW	1/Year	YES
Resistance to dynamic perforation load	RPG of BAW	1/Year	1800 Nm
Hydraulic filtration efficiency against soil type	RPG of BAW	1/Year	BTC

Standard Roll Dimensions	Test Method	Frequency	Value
Width x Length	Typical	Every roll	5,0 m X 35 m (±1%)
Quantity	Typical	Every roll	175 m <sup>2</sup>



## SandMat 4700/300 Compo

# TECHNICAL DATA SHEET

## EUROBENT SANDMAT 4700/300 Compo

Needle punched composite, consisting of quartz sand, embedded and fixed between two layers of geotextile.

Properties of geotextile	Test Method	Frequency	Value
Carrier Layer - PP Woven&Non-woven Composite	EN ISO 9864	20,000 m <sup>2</sup>	260 g/m <sup>2</sup>
Cover Layer - PP Nonwoven	EN ISO 9864	20,000 m <sup>2</sup>	300 g/m <sup>2</sup>
Resistance to weathering Cover Layer	EN 12224	-	14 days

GTP Properties	Test Method	Frequency	Value
Mass per unit area of Quartz Sand	EN 14196	4,000 m <sup>2</sup>	4700 g/m <sup>2</sup>
Mass per unit area of GTP	EN 14196	4,000 m <sup>2</sup>	5260 g/m <sup>2</sup> (±10%)
Thickness	EN ISO 9863-1/-2	4,000 m <sup>2</sup>	8,5 mm (±1mm)
Tensile strength MD	EN ISO 10319	4,000 m <sup>2</sup>	≥ 12,5 kN/m
Tensile strength CMD	EN ISO 10319	4,000 m <sup>2</sup>	≥ 12,5 kN/m
Elongation at break MD/CMD	EN ISO 10319	4,000 m <sup>2</sup>	> 20%(1)
CBR	EN ISO 12236	4,000 m <sup>2</sup>	3,5 kN (-10%)
Opening Size	EN ISO 12956	25,000 m <sup>2</sup>	100 µm (±10%)
Water permeability	EN ISO 11058	25,000 m <sup>2</sup>	11,6 mm/s (±0,5mm/s)
Resistance to abrasion loads	RPG of BAW	1/Year	Yes
Resistance to dynamic perforation load	RPG of BAW	1/Year	600 Nm
Hydraulic filtration efficiency against soil type	RPG of BAW	1/Year	1/2/3/4

Standard Roll Dimensions	Test Method	Frequency	Value
Width x Length	Typical	Every roll	5,1 m X 40 m (±1%)
Quantity	Typical	Every roll	204 m <sup>2</sup>

1. Measured at first peak

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# MINIMUM FREQUENCY OF CONTROLS AND TESTS OF SANDMAT

11

## 11. MINIMUM FREQUENCY OF CONTROLS AND TESTS OF SANDMAT

Control/test	Task	Frequency	Standard
Compliance with the order from client	Inspection of the finished product for compliance with the order	Every roll	-
Marking	Checking transparency and indelibility of symbol EUROBENT® - SandMat in accordance to PN EN ISO 10320	Every roll	-
Visual inspection	Packaging integrity, physical appearance, cleanness	Every roll	
Unit superficial mass	Meeting technical specification	1x20.000m <sup>2</sup>	PN EN ISO 14196
Thickness	Assesment of conformity to technical specifications	1x20.000m <sup>2</sup>	EN 14196
Tensile strength	Assesment of conformity to technical specifications	1x20.000m <sup>2</sup>	EN ISO 10319
Elongation at break	Assesment of conformity to technical specifications	1x20.000m <sup>2</sup>	EN ISO 10319
CBR Static Puncture Resistnce	Assesment of conformity to technical specifications	1x20.000m <sup>2</sup>	EN ISO 12236
Cone Drop test	Assesment of conformity to technical specifications	1 x 50 000 m <sup>2</sup>	PN EN ISO 13433
Pore size	Assesment of conformity to technical specifications	1 x 50 000 m <sup>2</sup>	PN EN ISO 12956
Water permeability	Assesment of conformity to technical specifications	1 x 50 000 m <sup>2</sup>	PN EN ISO 11058



MINIMUM FREQUENCY OF CONTROLS AND TESTS OF SANDMAT

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**DOCUMENTS AND  
OTHER AIDS  
AVAILABLE AT  
DIFFERENT STAGES OF  
THE COOPERATION**

**12**



## 12. DOCUMENTS AND OTHER AIDS AVAILABLE AT DIFFERENT STAGES OF THE COOPERATION

**BEFORE**

**AFTER**

### 12.1. Before sale

1. Technical data sheet of the selected product
2. Quality control plan
3. SandMat sample for presentation and testing in an external laboratory
4. List of completed projects, presenting the company's impressive history
5. Internal and external lab test reports for products manufactured in the past
6. Quality documents - certificates, DoP, etc.

### 12.2. After sale

1. Internal test reports according to frequency for produced and loaded rolls
2. SandMat installation and handling instructions
3. Warranty



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# INSTALLATION

13

## 13. INSTALLATION

### 13.1. Subgrade Preparation

Surface, on which you plan to install the SandMat must be free of sharp rocks, organic matter and other objects larger than 50 mm. The subgrade should be compacted at least 90% of its proctor density. While compacting with a smooth-wheeled or rubber-tired roller, try to keep the surface free of water. SandMat may be installed on a frozen subgrade, however only if the subgrade soil in the unfrozen state meets the requirements listed above.

### 13.2. Installation

SandMat should be placed on the prepared subgrade without wrinkles or folds. Place the SandMat on the ground at the installation site. Unroll the SandMat roll like a carpet.

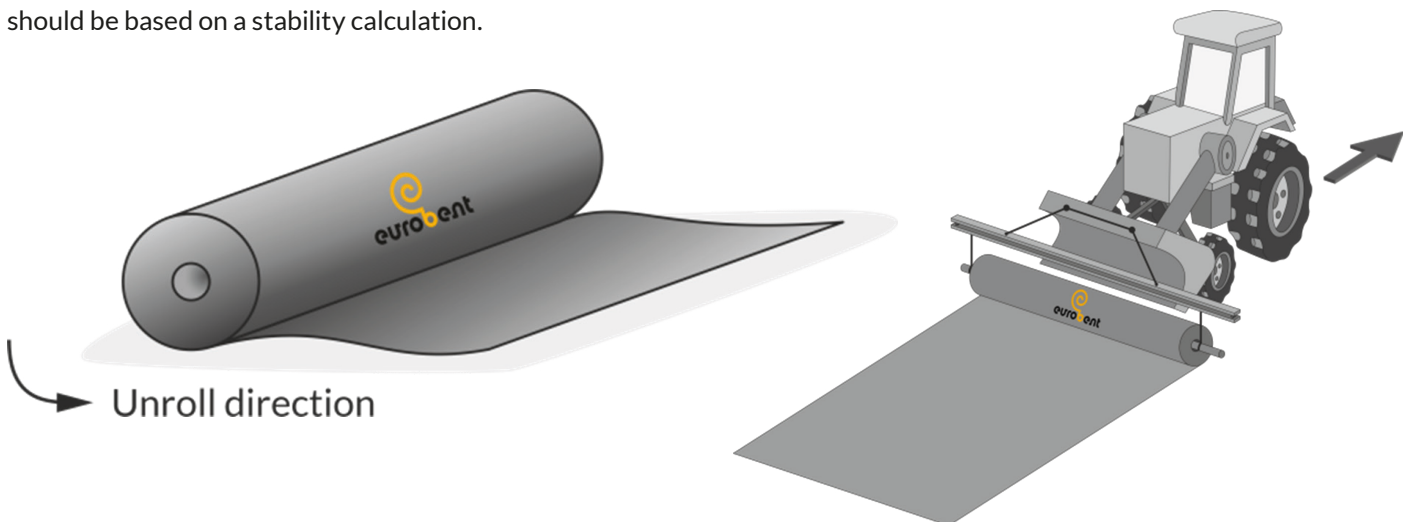
For easier handling and positioning of SandMat it is recommended to provide a lifting device which allows to lift the rolls with a bulldozer or front end loader. The iron pipe may serve as a device for unloading as well as for installation of the liner.

On slopes the orientation of panels shall be parallel to the slope. The panels should be secured in an anchor trench at the top of the slope. The requirement as well as dimensioning should be based on a stability calculation.

When installing SandMat over a soil subgrade, the finished surface should be smooth without any abrupt elevation changes, voids, cracks or ice. In addition it should be firm and unyielding, and compacted to a sufficient degree so that deployment or other construction equipment does not leave tracks or ruts greater than 25 mm in depth.

Notwithstanding the above requirements, the subgrade surface must also be prepared in strict accordance with the project drawings and specifications, and the engineer's approval of the subgrade must be obtained prior to material deployment.

SandMat is often used as part of a scour protection along river embankments and riverbeds and at the bottom of canals that are previously filled with water. Underwater installation requires a bigger overlapping section up to 1,0 m. Orientation of underwater overlapping has to take the streaming direction into consideration. Installation starts always downstream. The following rolls are installed in upstream direction to avoid streaming caused lifting forces underneath the overlapping area and to create an overlapping structure comparable to roof tiles. The unrolling process is performed by using a steel beam pushed through the core of the roll connected by chains to a suitable lifting machine. To ensure a proper overlapping underwater it is recommended to assist and control the unrolling process by divers.



An effective measurement to reduce overlapping is to connect neighbored roll edges by seams. The sewing process can not be performed under water. Consequently the product has to be layed out on a barge, or other vessel with a large enough deck. The SandMat can already be overlapped on the deck of the barge using seams, which will be described in the next subsection of the document.

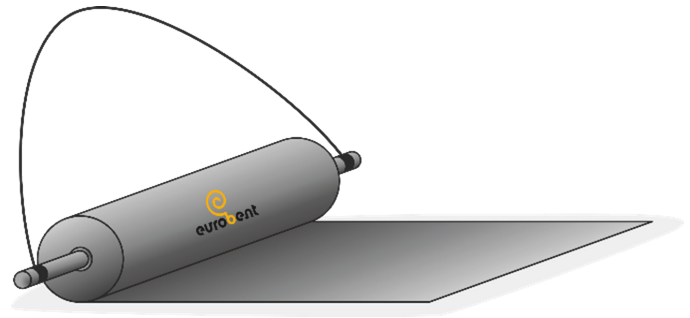
To ensure proper functioning of the SandMat at the bottom of the channel, it must be protected from disorderly washout by water movement. The easiest way is to cover it with stones, which is possible due to the high puncture resistance of the liner.

If installing SandMat not underwater, it must be covered with a layer of soil within up to 14 days of installation to maintain the 50-year product warranty.

### 13.3. SandMat placement

SandMat shall be placed in a way that longitudinal joints are parallel to the slope direction. Transversal joints should also be located a minimum of 1 m from the toe and crest of any slopes steeper than 4H:1V. End seams on slopes should be used only if the liner is not expected to be in tension and interface friction testing confirms this.

SandMat surface should be smooth, without any folds, especially at the exposed edges.



### 13.4. Joining panels

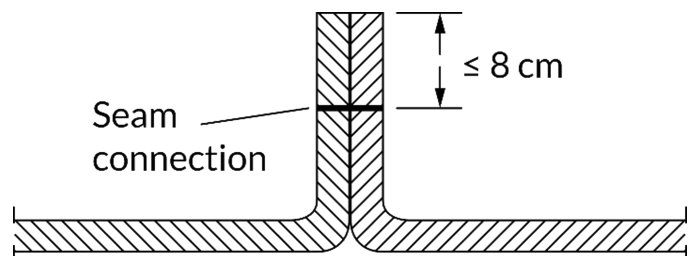
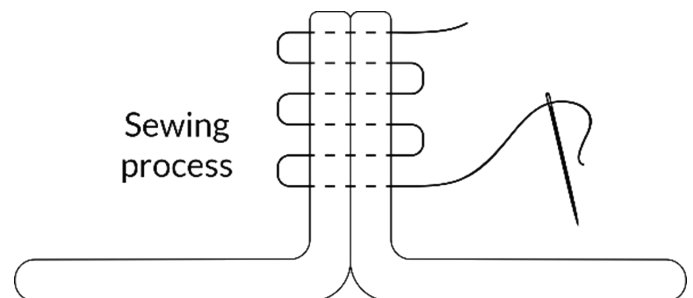
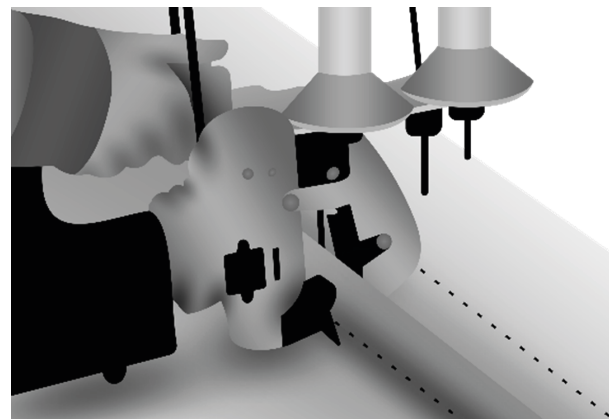
Each panel is marked with two lines, the first located 15 cm from the edge, and the second one is 7 cm farther. This helps in the parallel arrangement of the panels in relation to each other.

The size of the overlap depends on the shape of the underground and design requirements.

The longitudinal edges of SandMat are free of sand, which ensure proper sewing of panells. In order to properly connect the two SandMat panels, they should be placed in such a way that they overlap along the sides. SandMat edges should then be folded up one to the other so that the overlapping section form a single upstanding line. The sewing process will connect the edges of two rolls along the folded overlapping section that is free of sand filling material to protect the sewing needle from damages. It is recommended to use suitable sack sewing machines as sewing device, e.g. Union Special Type 2200 GA or comparable and proper yarn with high tesile strength that provide - once transformed into a seam - stronger resistance than the sandmat during a pull apart test.

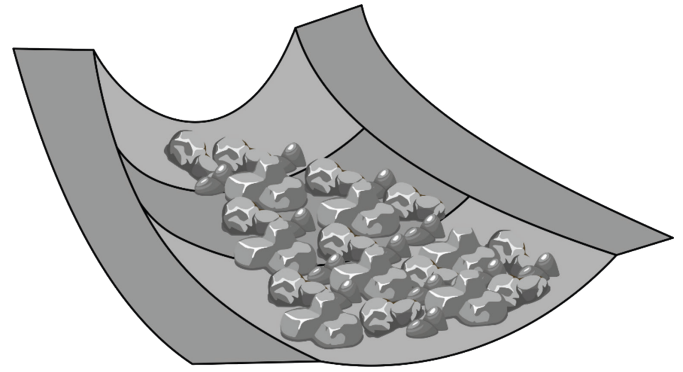
**Sewing minimizes overlaps, saving a large part of the material.**

The minimum distance between the edge of the product and the seam shall not be less than 8-10 cm. The given variation is due to the hand sewing process that - in opposite to industrial sewing - does not allow precise straight sewing lines. This requirement leads to a total loss by overlapping between two neighbored rolls of 16-20 cm. Compared to standard overlapping underwater of up to 1,0 m. the sewing process provide a saving of 80% overlapping losses.





The above described sewing process provide a safe and approved connection between the rolls achieving the same tensile properties as the product itself. As temporary connection between two rolls at dry installation conditions without further movement of the product, the geotextile surface inside the overlapping area can melted by using a hot air gun such as e.g. Leister Triac or comparable and pressed together. This hot air connection is comparably weak.



Moreover, thanks to high puncture resistance, SandMat shall be covered with Riprap, which fixes the mat to the subsoil and prevents the panels from moving relative to each other.

### 13.5. Damage repair

If there is a tear in the mat, remove the sand from the edges and sew the mats together as described in Joining Panels.

In case of a tear in the form of a hole in the SandMat, which cannot simply be sewn up, a patch should be cut from another SandMat panel and placed in the defect area. The fixing of the patch should be done in the manner of overlapping joints.



INSTALLATION





**eurobent**  
KEEP ROLLING



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