1996 was the one who witnessed the moment.

We undertook the challenge of taking a step forward, starting a project on the right foot: a bet on the office furniture market.

Opening the doors of GAPSA for the first time was just the beginning.
I remember the squad. An enthusiastic team made up of fourteen members, excited to see how the aspirations of differentiating GAPSA from other national manufacturers of office furniture were becoming a reality.

Our strategy?

To specialise in a single line of business: to be the most competitive manufacturer of Metal Office Furniture on the market.

The commitment, effort and sacrificial work of a committed team were key factors in our achievement: launching a quality product, seeing the birth and growth of a very significant market share and managing to position ourselves in the sector until we achieved leadership at European level, which we have maintained throughout all these years and which we continue to enjoy today.

Today Gapsa translates into experience, evolution and continuous improvement.

At our headquarters located in Castellar del Vallès (Barcelona), we have an infrastructure of 10,000 m2 imbued with the same spirit of work, improvement and improvement as fifteen years ago.
Within our facilities we carry out all the productive activity, we manufacture the Metal Furniture subjecting it to rigorous quality controls by the hand of a workforce that has been multiplying. We have managed to retain a portfolio made up of more than 3,600 active customers, who act as distributors of our product. We have opened markets in 40 countries, achieving that 85% of our sales are due to exports distributed throughout the world.

At GAPSA, we are clear that the customer comes first and exceeding their expectations is also our satisfaction.

Work philosophy

A way of doing things

IDENTITY AND REPUTATION

GAPSA, as a brand, has followed a path of consolidation that today translates into a recognition that our customers constantly transmit to us. Over time, we have built a strong identity based on quality, trust and commitment. This process of evolution has not only strengthened our presence in the market, but has also generated long-lasting relationships with our customers, who value not only our products, quality and service, but also the experience and safety we offer them.

Our identity and reputation determine a prestige that sets us apart. GAPSA is not just a name; It represents a standard of excellence that positions us as a benchmark in our sector. Every action, every interaction and every project we carry out is guided by principles of integrity, responsibility and continuous improvement. These values are what have built the reputation that distinguishes us today, and that drives us to continue growing, innovating and exceeding expectations.

CHALLENGE AND ACHIEVEMENT

Every day we face challenges with a proactive and determined attitude. We are known for anticipating problems, acting with initiative and maintaining a solution-focused mentality. We firmly believe that every obstacle is an opportunity in disguise, and that difficult situations are not barriers, but starting points to grow, innovate and overcome ourselves.

Our success is not the product of chance, but of a constant commitment to continuous improvement and learning. We transform the difficulties of the present into opportunities for the future, always maintaining a strategic vision and open to change. We take calculated risks with responsibility, we analyze the environment, we plan clearly and we adapt with agility to the scenarios that are presented to us. This approach allows us to move steadily toward our goals, even when the path becomes uncertain. More than achieving goals, we seek to constantly improve ourselves, leaving a mark with each achievement and learning from each experience. Because we know that true growth comes from action, reflection, and perseverance.

ETHICS AND PROFESSIONALISM

In our organization, ethics is not only a value, but the foundation on which we build every decision and action. We act with integrity, transparency and a deep respect for the principles that govern our profession. We are governed by standards of behavior that ensure trust, both within the team and in front of our clients and strategic allies. Our professionalism is expressed in the constant commitment to continuous improvement, the search for excellence and dedication in each task. We value fundamental qualities such as responsibility, perseverance, seriousness, vocation, discipline and dedication, which define each member of our team. Not only do we do our job well, but we do it with passion, commitment and specialization.

RESPONSIBILITY AND RESPECT

We take responsibility as a guiding principle in all our activities. We understand that every action has consequences, so we work with a clear awareness of our impact, both social and environmental. Respect is manifested in our human relationships, in the way we value our employees, customers and the natural environment. We have taken a proactive approach to sustainability. This involves optimizing resource management, implementing eco-efficient processes, and promoting practices that contribute to sustainable development. We strive to reduce our environmental footprint and make a positive impact by demonstrating consistency between what we say and what we do.

TEAM AND HUMAN TALENT

We firmly believe in the power of collaborative work. Our team is a diverse pool of talents working together towards common goals. We foster an environment in which each person can contribute their knowledge, experience and creativity, knowing that true success is built together. We leverage individual capabilities as part of a larger gear, where collaboration boosts results. The diversity of disciplines and profiles enriches us and allows us to offer comprehensive, innovative solutions adapted to current challenges.

TRANSPARENCY AND VOCATION FOR SERVICE

Transparency is one of our fundamental pillars. We act with clarity, honesty and coherence, generating relationships of trust with our customers, suppliers and collaborators. We focus on maintaining open, accessible, and effective communication channels.

Our vocation for service drives us to actively listen, understand the needs of our customers and offer solutions that generate real value. We seek your satisfaction as a driver of improvement, which leads us to constantly review our processes, incorporate innovations and exceed expectations with personalized, close and professional attention.

INNOVATION AND DEVELOPMENT

Innovation is not an option, it is part of our DNA. We understand that innovation is anticipating changes, challenging limits and transforming ideas into concrete realities. We are characterized by our entrepreneurial attitude, by the willingness to explore new opportunities and by the ability to adapt quickly to changes in the environment. At GAPSA, we are committed to continuous learning, the strategic use of technology and the development of new products and services as paths to sustainable growth. We foster a culture of creativity, initiative and critical thinking that allows us to evolve permanently.

QUALITY

Our commitment to quality is reflected at every stage of our processes. We apply rigorous management systems certified under international standards such as UNE-EN ISO 9001, UNE-EN ISO 14001, UNE-EN ISO 14006 and UNE-EN ISO 14064.

This allows us to ensure excellence in our products and services, as well as to minimise risks and optimise resources. Quality is not an end goal, but a daily practice that involves the entire team and positively impacts our customers' experience.

EXCELLENCE

The pursuit of excellence is a constant attitude that defines the way we work and our commitment to continuous improvement. This one is not it is a specific goal, but a way of thinking and acting that is manifested in every decision, in every process and in every relationship we build.
We are guided by constructive self-criticism, understood as the ability to evaluate our performance objectively and openly, recognizing both achievements and areas of opportunity. We know that mistakes are not failures, but a valuable source of learning that allows us to grow professionally and personally. Therefore, we foster an environment where honest feedback and collaborative learning are welcomed and valued.

The deep desire to improve ourselves day by day is what drives us not to settle for what we have achieved. We firmly believe that there is always a way to do better: more efficient, more creative, more aligned with our goals and with the changing needs of the environment. This conviction translates into an organizational culture focused on continuous improvement, innovation, and optimization of our processes, services, and products.

We encourage proactivity, critical thinking and teamwork as tools to transform challenges into opportunities.

Our main objective is to constantly evolve, adapting with agility and vision to new contexts, staying at the forefront and generating a positive impact. Only in this way can we rise to the challenges we face and deliver extraordinary results that exceed the expectations of our clients, partners and collaborators.

A commitment to quality

Quality, our integral commitment

At GAPSA, we understand quality not simply as an abstract concept or a passing trend. For us, quality is a deep, transversal and sustained commitment, which defines our way of working and is present in every decision we make. It is a conviction that transcends words and translates into concrete actions, solid values and measurable results.

This commitment is manifested at all levels of our organization, from senior management to each of our employees. We foster a culture of continuous improvement, based on responsibility, innovation and constant learning. We apply rigorous control and monitoring standards to ensure that each product, service or process meets – and exceeds – our customers' expectations and industry regulations.

Quality at GAPSA is not a specific goal, but a permanent path of evolution. We strive to anticipate environmental challenges, adapt to new market demands, and respond with efficient, sustainable, and customer-centric solutions. Each project is an opportunity to reaffirm our commitment and generate lasting value.

Because at GAPSA, doing things well is not enough: we always seek to do them better.

A quality policy that guides us

In our organization, quality is not a one-off goal, but a guiding principle that permeates every action, decision, and process. We operate under a quality business policy that has been designed with clarity, coherence and a deep conviction shared by all hierarchical levels. This policy is not a static document; It is a living guide that guides our daily performance and precisely establishes the role that each area, team and individual plays in the constant search for continuous improvement.

We have adopted a comprehensive quality management system, aligned with the highest international standards, which allows us to effectively integrate all areas of the organization. This system promotes cross-cutting collaboration and the agile flow of information, ensuring that each stage of the production process actively contributes to the achievement of superior results.

Our commitment goes beyond simple regulatory compliance: we aspire to exceed established standards, anticipate market needs and offer solutions that generate real value for our customers. Customer satisfaction is our main indicator of success, and we work every day to strengthen the trust placed in us, innovate responsibly and ensure excellence in every delivery.

Quality, in short, is part of our organizational culture and represents a path of permanent evolution, driven by the active participation of our entire human team.

Self-control and team empowerment

One of the fundamental pillars of our quality management is self-control in the manufacturing process, an approach that goes beyond traditional controls to put the people directly involved in production at the center. This model involves relying on the capacity and technical criteria of our operators, who receive continuous and specialized training to acquire not only the necessary technical knowledge, but also a solid understanding of the quality standards that govern each product.

Self-monitoring not only allows for early detection of deviations, but also fosters a culture of individual responsibility and commitment. By being directly responsible for quality at their respective stages of the process, operators become active agents of continuous improvement. This level of empowerment increases motivation and strengthens team cohesion, promoting a work environment where quality is assumed as a shared task.

Our system is based on rigorous and dynamic performance monitoring, supported by key indicators (KPIs) that are monitored in real time. These indicators make it possible to evaluate the effectiveness of each phase of the process, from the receipt of raw materials to the delivery of the final product to the customer, ensuring traceability, compliance with technical specifications and continuous improvement.

Thanks to this comprehensive approach, we are able not only to guarantee product quality, but also to optimize times, reduce waste and consolidate an organizational culture oriented towards operational excellence.

Commitment to sustainability and the environment

Our quality policy also incorporates a strong commitment to sustainability. The lines of action are oriented towards environmental awareness, the efficient and responsible use of resources and energy, the correct management of the waste generated, and the permanent commitment to innovation. We promote sustainable development as an essential part of our work philosophy, in strict compliance with all current legal and regulatory provisions.

Active leadership and continuous improvement

In our organization, active leadership is an essential pillar for sustainable development and responsible growth. We have a fully committed Management, which not only sets the strategic vision, but leads by example at all levels of the organization. This leadership manifests itself in direct and constant participation in the planning, execution and monitoring of key initiatives, especially those related to environmental, social and operational performance.

The close involvement of our leaders allows decisions to be made with in-depth knowledge of the daily reality, thus fostering an organizational culture where responsibility and continuous improvement are part of the institutional DNA. Their active presence reinforces the importance of maintaining environmentally responsible behavior as a strategic priority, not only in speech, but in concrete actions.

Through this permanent supervision and accompaniment, we promote a mentality of constant evolution. We challenge ourselves every day to innovate, to identify opportunities for improvement, to optimize our processes and to reduce the negative impact that our operations can generate. This culture of continuous improvement not only strengthens our commitment to sustainability, but also increases the value we deliver to our customers, employees, shareholders and the community at large.

In short, active leadership combined with a permanent orientation towards continuous improvement allows us to move solidly towards a more efficient, ethical and resilient future, where operational excellence and environmental responsibility coexist as complementary and priority objectives.

Manufacturing Process

1.RECEPTION OF RAW MATERIALS

Receiving raw materials is a crucial process in any supply chain, as it ensures that the materials to be used in production meet the quality standards and requirements set by the company. This process not only includes the physical delivery of the materials, but also the verification that they meet the previous specifications and are in optimal conditions for subsequent use in production.

Verification that the purchased product meets pre-set purchase requirements

Before accepting any delivery of raw materials, a detailed inspection is necessary. This verification process can include several aspects, such as:

Visual inspection: Check that the products are in good condition, without damage, without signs of contamination or deterioration.

Verification of specifications: Compare the physical, chemical and functional characteristics of the raw material with the specifications previously agreed in the purchase contract. This may include analyzing samples or reviewing quality certificates.

Quantity and weight control: Ensure that the quantity received matches what was requested in the order and that the weight of the materials is adequate.

Documentation Review: Verify that the transport documents (such as the delivery note) match the purchase order and that all administrative requirements are in order.

La materia prima se preserva en las condiciones convenientes hasta el momento de su uso.

Once the raw material has been verified and accepted, it is essential to store it properly to prevent it from degrading or losing its properties. The preservation of the raw material must be done in optimal conditions, which may involve:

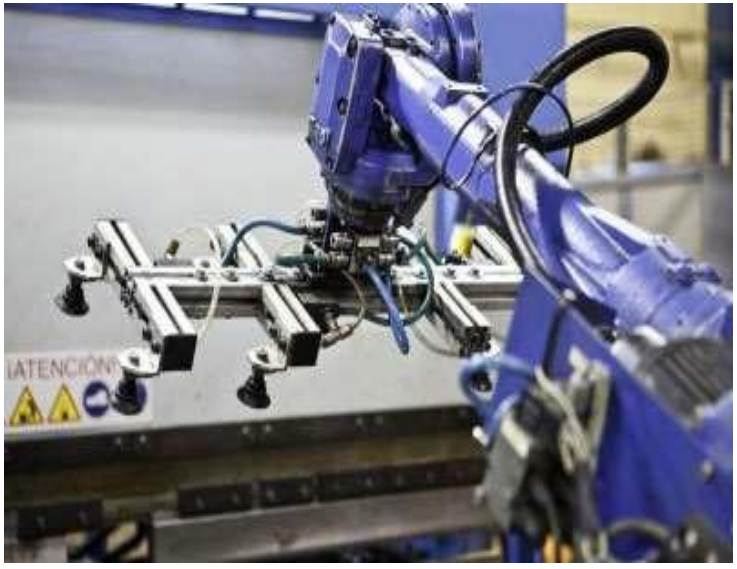
Controlled temperature and humidity conditions: Storage in spaces with regulated temperature and humidity, especially if they are sensitive to these variables, such as organic materials or chemicals.

Protection against contaminants: The raw material must be protected from external factors that can contaminate it, such as dust, light, humidity or chemical substances.

Inventory Turnover (FIFO Method): In many cases, the FIFO (First In, First Out) principle is applied, which ensures that older materials are used first, preventing products from expiring or losing their quality over time.

Safety: Protection against theft, damage, or accidents is also essential. Storage must comply with safety regulations to protect both the product and employees.

In summary, proper receipt and storage of raw materials are essential to ensure that manufactured products meet quality standards and are manufactured efficiently, without interruption due to material failures.



2. SHEET METAL MACHINING WORKSHOP

The sheet metal machining workshop is characterized by a high quality control at each stage of the production process. This ensures that the parts produced meet the technical specifications and standards required by customers or the company's internal criteria. Here

are some important aspects of the machining process and quality control involved:

1. Inspection at each machining sub-process:
During the transformation of the sheet metal into specific parts, the operators have the responsibility of thoroughly inspecting the part at each machining stage. This will verify that the dimensions, geometry and finishes are correct. Real-time monitoring allows potential errors or deviations to be detected, reducing the chance of producing faulty or out-of-tolerance parts.

2.Detailed quality control record:
To ensure traceability and process accuracy, the quality control of each part is recorded on the corresponding worksheets. These sheets not only document

The results of the inspections carried out, but also include information on the parameters used in each machining operation, the materials used and any adjustments made. This record is key to ensuring continuous feedback and allowing for internal or external audits in the future.

Sub-processes in sheet metal machining:

Sheet metal machining can involve several sub-processes, such as cutting, drilling, tapping, bending, or milling. In each of these steps, it is essential that operators perform a visual and dimensional check. Depending on the type of sub-process, measurement tools such as calipers, micrometers, or hardness meters can be used.

Impact of quality control on efficiency:
Rigorous quality control not only helps to avoid defects, but also improves the efficiency of the process. Detecting problems early in the process prevents rework and reduces waste, which has a direct impact on productivity and operating costs.

3 . Continuous improvement:
In addition to verification at each stage, quality control is also used to identify areas for improvement within the machining process. Control logs allow for periodic analysis to optimize shop practices and procedures, ensuring consistent quality is maintained and continuously improving shop performance.

This comprehensive and detailed quality control approach helps ensure that machined parts have high accuracy and that errors are minimized, thus ensuring customer satisfaction and compliance with applicable industry regulations.

3. WELDING

Spot Welding Process in the Manufacture of Metal Furniture

1. Robust and automated technology for joining metal parts

In our metal furniture manufacturing line, the joining of components is carried out by resistance welding, specifically through the spot welding technique. This process is based on the generation of heat by passing electric current through the point of contact between two sheets, followed by the application of mechanical pressure to consolidate the joint. It is a technology without the addition of material, which reduces consumption and waste. Most of the welding points are made by automated robots, which ensures:

Greater production efficiency.
High homogeneity and repeatability in the quality of the joints.
Reduction of errors and direct human intervention in risk areas.
Process automation is a key factor in the stability of the final product and in the optimization of the resources used.

2. Occupational safety and low environmental impact of the process
Spot welding is performed under highly safe conditions for personnel, as automation reduces direct exposure to heat, sparks, or fumes. In addition, this process is particularly environmentally friendly, since:
It does not require shielding gases or filler materials.
It does not generate significant emissions or polluting particles.
It does not produce hazardous waste.
Tiene un consumo energético localizado y optimizado.

It is a clean and minimally invasive technology, ideal for production environments looking to minimise their environmental footprint. Thanks to these characteristics, this process actively contributes to our commitments to environmental management systems certified under the UNE-EN ISO 14001 standard.

3. Quality control and continuous improvement

The quality of the welded joints is fundamental in our product, which is why an exhaustive control system is applied based on:
Self-monitoring of the operator, who verifies the production immediately after the process.
Systematic records of process parameters and results.
Regular data analysis to identify deviations, critical points, or areas for improvement.
These controls make it possible to guarantee the resistance of each welding point and ensure complete traceability. In turn, the records serve as a basis for fine adjustments in welding parameters and for implementing continuous improvement actions, both in equipment and procedures.

4. High mechanical strength for durable structures

Spot welding not only allows a fast and precise joining of metal sheets, but also provides excellent mechanical resistance, essential to guarantee the structural solidity of metal furniture. In particular, its application in the manufacture of cabinets and other storage elements allows:

Efficiently distribute mechanical stresses at the joining points, generating a solid and compact structural whole.
Increase the overall rigidity of the products, avoiding displacement, torsion or deformation with continued use.
Reinforce the load capacity of metal cabinets, making them suitable for supporting high weights without compromising their integrity.
Thanks to the high quality of the joints obtained with this technique, our products are characterized by their great resistance and durability, even under conditions of intensive use. This results in a long life of the furniture, reducing the need for replacements and repairs, which in turn contributes positively to the sustainability of the product life cycle.
In addition, by avoiding the use of filler materials or added elements that can degrade over time, welded joints maintain their properties stably for years, ensuring the structural reliability of metal furniture in demanding environments, such as offices, workshops or industrial facilities.

4. PAINTING

1. Objective of anti-corrosive surface treatment

The main objective of anti-corrosion surface treatment is to prevent or delay the corrosion process in metallic materials, especially in those exposed to aggressive environments such as humidity, salinity or chemical products. These treatments seek to extend the useful life of metal parts and guarantee their functionality and resistance over time.

2. Anticorrosive Treatment by Conversion with Zirconium (Nanotechnology)

Zirconium conversion treatment is an advanced technology used to improve the corrosion resistance of metal surfaces, especially ferrous and non-ferrous metals prior to painting. It is based on the formation of a protective layer through the controlled chemical reaction between the metal surface and a bath diluted with zirconium compounds.

This process, classified within conversion treatments, does not deposit a physical layer on the metal as is the case with metal coatings, but modifies the surface of the substrate at the nanometric level, generating an extremely thin and uniform inorganic film.

Treatment features:

It is performed by immersion or spraying in a chemical bath containing zirconium in dilute solution.
It does not contain heavy metals or phosphates, making it an environmentally friendly treatment.
It improves the adhesion of the backcoat (such as powder or liquid paint) and increases the corrosion resistance of the entire system.
It is compatible with different types of metals, including steel, aluminum, and their alloys.
It requires a proper pre-cleaning process to ensure the effectiveness of the treatment.
This type of treatment, based on nanotechnology, represents an efficient and sustainable alternative to other traditional methods such as phosphating or chrome plating, especially in applications where the aim is to minimize the environmental impact without compromise the durability of the final product.

3. Automatic control and maintenance

Continuous monitoring and maintenance of degreasing and anti-corrosion treatment tanks is crucial to maintaining process quality. This includes:
Degreasing: Before applying the anti-corrosion treatment, it is necessary to clean the metal surfaces to remove dirt, oils, greases and other contaminants that may interfere with the adhesion of the coating or treatment.
Automatic maintenance: The anti-corrosion treatment tanks must be managed automatically to ensure constant and efficient operation. This involves monitoring parameters such as temperature, pH, chemical concentration, and other critical indicators to ensure the effectiveness of the treatment.

4. Analytics

Performing daily analytics is an essential part of the process. Through these tests, it is ensured that the concentration values of chemicals and the conditions of the treatment bath are within optimal ranges. This includes:
Measure the concentration of treatment products (e.g. concentrations in baths).
Check the temperature and pH of the degreasing and treatment bath.
Evaluate the effectiveness of the coating through adhesion and corrosion resistance tests.

5. Continuous process mode

Continuous treatment allows the treatment and degreasing vats to operate without interruption, ensuring that the metal parts undergo a constant treatment process. This is important to maintain high productivity and to ensure that all parts are treated evenly.

6. Importance of treatment quality

Ensuring the quality of the treatment is essential for the protection of metal parts. Defective treatment could result in premature corrosion and reduced product life. The implementation of rigorous quality control, through daily testing and continuous calibration of equipment, ensures that the efficiency of the anti-corrosion process is maintained.

7. Benefits of Anti-Corrosion Surface Treatment

Increased durability of metal parts by resisting the effects of corrosion.
Long-term cost reduction by avoiding frequent component replacement.
Mejora de la seguridad en entornos industriales al prevenir fallos estructurales debidos a la corrosión.
Cumplimiento normativo en sectores que requieren altos estándares de protección contra la corrosión (como la industria automotriz, naval o de heavy

machinery).

Conclusion

Anti-corrosion surface treatment is an essential process in the protection of metal materials, especially in environments where corrosion is a constant risk. Automatic control and daily analytics play a fundamental role in ensuring that the treatment is effective and of high quality, guaranteeing greater durability of the parts and reducing operational costs in the long term

6. Automatic Powder Coating Installation with 4.0 Technology

Technology 4.0 refers to the integration of advanced automation, the Internet of Things (IoT), artificial intelligence (AI) and data analytics into industrial processes. In this case, the powder coating facility uses these technologies to improve the efficiency, accuracy, and traceability of the painting process.

Powder coating: It is a technology that is used to apply paint efficiently and evenly. Unlike traditional liquid paint, powder coating is solvent-free, making it more environmentally friendly and less polluting. The paint is applied using an electrostatic spraying process, where charged paint particles adhere to metal surfaces. It is then cured at high temperatures to achieve a durable and resistant finish.

Automation: Automation allows the painting process to be carried out consistently, quickly and accurately, minimizing error

and optimizing production times.

3D Painting System

The 3D painting system involves the use of machine vision technology and robotic systems to apply paint to surfaces more effectively and in detail. Through this technology, the system can adapt to complex shapes and geometries found in products, which is particularly useful in the manufacture of cabinets or parts with intricate structures.

Advantages of 3D painting:

Improves precision in paint application.
It allows for the application of thinner and more uniform layers.
Increases flexibility, as paint can be applied on uneven or complexly shaped surfaces.
Optimización del uso de materiales, reduciendo el desperdicio de pintura.

Epoxy paint

Epoxy paint is a highly durable and resistant type of coating, especially suitable for industrial applications. This paint has excellent adhesion properties and resistance to chemicals, abrasion, humidity and extreme temperatures, making it an ideal choice for environments that require strong protection against wear factors.

Key features:

High corrosion resistance, which prolongs the service life of painted parts.
Ideal for applications in industrial environments, such as metal cabinets, machinery, metal structures, and more.
Stability in high humidity conditions or corrosive environments.

Periodic control of the micronage of all parts of the cabinet

Micron control refers to the constant monitoring of the thickness of the layers of paint applied to each part of the cabinet or component. This control is essential to ensure a consistent, high-quality application, which not only improves the appearance of the product, but also ensures that corrosion and wear protection is adequate.

Importance of micron control:
It ensures that each part of the cabinet receives the right amount of paint.
It prevents paint overload, which can result in an unsightly finish or unnecessary material consumption.
It reduces variability in finishes, ensuring uniformity across all products.

Control of paint consumption to reduce environmental impact

Controlling paint consumption is a key practice to improve the sustainability of manufacturing processes. By applying just the right amount of paint needed, not only is material waste reduced, but the environmental impact of the process is also minimized. This control can be implemented through automated measurement and monitoring technologies, which adjust the paint supply in real-time according to the specific needs of each part.

Environmental benefits:

Decreased carbon footprint by reducing the use of chemicals and solvents.
Less generation of paint residues, which if not controlled correctly, can be harmful to the environment.

Savings in natural resources, since the use of paint is optimized, reducing the amount that is discarded.

In summary, the use of technology 4.0 in the powder coating installation, together with the 3D painting system and advanced controls of micronage and paint consumption, contributes not only to the improvement of the quality of the final product (in this case, the cabinets) but also to greater efficiency in the use of materials and a reduction in environmental impact. which is key in modern industry.

4.ASSEMBLY LINE

Complete unitary functional verification of the manufactured cabinets.

The assembly line is a crucial part in the production of any type of equipment, including cabinets. In the case of cabinet manufacturing, once the parts have been assembled, a complete unitary functional check is carried out to ensure that each cabinet meets quality standards and functions correctly.

1. Assembly Process:

The assembly process involves aligning and joining cabinet components (such as doors, shelves, hinges, opening systems, etc.). This is done systematically on an assembly line, where each worker or workstation performs specific tasks. Once the cabinet is fully assembled, it moves on to the next phase: functional verification.

2. Unitary functional verification:

Objective: The functional verification aims to ensure that the cabinet functions correctly as a whole, that all components are installed correctly and comply with the technical specifications.
Common tests in verification:
Inspection of the physical structure: The solidity of the cabinet structure is checked, verifying that there are no defects or loose parts.
Pruebas de puertas y cierres: Se comprueba que las puertas abran y cierren correctamente y que las bisagras estén firmemente instaladas.

Evaluation of opening mechanisms: In the case of cabinets with special opening systems, such as those with automatic opening or electronic mechanisms, the correct operation of these systems is checked.
Electrical tests (if applicable): If the cabinet includes electrical components (such as lighting or cooling systems), it is verified that the electrical circuits are working correctly without risk of short circuits or failures.
Aesthetic review: In addition to functional tests, the finish of the cabinet is checked to ensure that it is aesthetically correct, without scratches, stains or imperfections.

3. Tools and technology in verification:

Depending on the complexity of the cabinets, manual tools or automated technologies (such as sensors, high-resolution cameras, or software testing) can be used to verify the quality of each unit.
In some cases, verification is done by an automated quality control system that evaluates the functionality of each unit without direct human intervention.

4. Recording of results:
All verification test results are carefully recorded to ensure that each cabinet has passed the assessment. If faults are detected, the cabinet is sent to a repair station or discarded.
These records are also useful for traceability in case of any problems with the products after distribution.

5. Closing the assembly process:
Once a cabinet passes all unit functional verification tests, it is labeled as approved and prepared for packaging and distribution.
If any problems are found during verification, the defective products are returned for repair or adjustment, and the process is repeated until quality is assured.

6. Importance of verification:
Ensures that the final product meets customer expectations and quality standards.
It helps reduce costs in the long run by detecting problems early in the production chain.
It improves customer satisfaction, as the delivered products are of high quality and without functional defects.
In summary, full unit functional verification is a fundamental process within the assembly line to ensure that each manufactured cabinet is fully operational, without malfunctions, and meets quality standards before reaching the end consumer.

5. PACKING

Metal Furniture Packaging Process

The packaging of metal furniture is carried out with the aim of guaranteeing its protection during transport and storage, minimising the risk of damage due to handling or environmental conditions. The process includes different protection measures depending on the type of product and its destination, with or without the use of pallets.

1. Product Preparation

The metal furniture elements (cabinets, tables, shelves, etc.) are grouped and ordered according to criteria of stability, volume and purpose.

The use of pallets It is limited to specific situations where the customer requires it or when transport logistics require it. In all other cases, the products are placed directly on reusable support bases or in a self-supporting arrangement.

2. Corner and Surface Protection

Rigid protective corners are placed in all corners of the furniture or assembly to protect it from bumps, crushing or scratching.

Specific protective boards are applied to the top and bottom of the assembly:

The underboard acts as a base for protection against contact with rough or wet surfaces.

The top carton protects the top of the product from impact during transport or accidental stacking.

3. Stretch wrapping

By means of an automatic or semi-automatic stretch wrapper, the product is wrapped with stretch plastic film, guaranteeing a firm and compact hold of the whole.

The wrapping covers from the base to the top, adjusting the tension of the film so as not to damage the product, but ensuring its stability.

The stretch film provides protection against dust, moisture and accidental displacement.

4. Bucks-Specific Packaging

The *bucks* (drawers or auxiliary modules) are individually packed.

Each *buck* is placed in a sturdy cardboard box, designed to fit its dimensions.
Inside, foam protections are placed on the inside faces to absorb impacts and prevent movement during transport.
Boxes are securely closed and labeled correctly.

5. Identification and Quality Control
Once the packaging is complete, each unit is labeled with the corresponding information: model, reference, destination, handling symbols, etc.
A final inspection is carried out to verify that the packaging is correct and meets the quality and protection standards set by the company.
deliver it to you in that format as well.

6. STORAGE

1. Importance of Careful Handling

Careful handling is essential to prevent damage to cabinets and other stored products. These pieces of furniture are often fragile, especially if they are made of materials such as wood, glass, or delicate metal components. Shocks, drops, or improper pressures during the process can cause visible or structural damage.

2. Use of Protective Material

To ensure the safety of cabinets and other objects in the warehouse or on the truck, it is essential to use protective materials such as:

Bubble wrap: Protects surfaces from scratches or dents.
Corrugated cardboard: Offers additional protection to edges and corners.
Fabric or plastic covers: They cover cabinets effectively to prevent dirt or friction damage.

3. Staff Training

The personnel in charge of storage and loading must be trained to make proper movements. This includes learning how to:

Levantar correctamente: Usar técnicas de levantamiento que eviten daños al producto y a la salud del trabajador.
Distribute the weight: In the case of trucks, make sure that the weight is well distributed to prevent the fall or displacement of the cabinets during transport.
Avoid unnecessary bumps: Make sure that the furniture does not hit other surfaces or products during the process.

4. Organization and Adequate Space

During storage it is important to organize the space efficiently, ensuring that the cabinets are stacked securely. This involves:
Use of shelves: For smaller or lighter cabinets, use suitable shelves for storage.
Wide spaces for the largest: For large or heavy cabinets, large spaces should be left where there is no risk of falling or damage.
Stacking safety: If cabinets must be stacked, it is important to ensure that there is no risk of them falling, using restraint systems or anchors if necessary.

5. Truck Loading

In the process of loading trucks, the order and arrangement of products are key to protecting cabinets and other furniture. Some recommended practices are:Load in a balanced way: Position the cabinets so that their weight is evenly distributed in the truck, preventing them from sliding or falling during transport. Securing products: Use tapes or straps to ensure cabinets don't slip. Foam blocks or cushions can also be used to cushion any impact.

Use of ramps and suitable tools: In case the cabinets are heavy or bulky, ramps, wheelbarrows or pallet trucks should be used to move them more easily and safely.

6. Quality Control and Safety

Performing a quality check before loading the cabinets can be helpful in identifying any defects or damage prior to the transport process. In addition, it is important to comply with occupational safety regulations to ensure the integrity of both products and workers.

7. Storage Conditions

Warehouse conditions should also be appropriate for the safe storage of cabinets:Controlled temperature and humidity: Some materials, such as wood, can be affected by changes in humidity, which can alter the quality of products. Dust- and dirt-free environments: Keeping the warehouse clean helps prevent dust build-up that could affect furniture.

Conclusion

El almacenaje y la manipulación cuidadosa son procesos fundamentales para garantizar que los armarios y muebles lleguen a su destino sin daños. Esto requiere

de técnicas adecuadas de manipulación, el uso de materiales de protección, una carga bien organizada y un entorno de trabajo seguro tanto para los productos como para los trabajadores.

Quality Certificates

OFFICE EXCELLENCE

Voluntary mark of certification granted by AFNOR (Association Française de Normalisation). The FBCA Institute of Technology, an accredited certification organization, is commissioned by AFNOR to manage the applications of this brand in the field of furniture
office. It is a product certification promoted by public authorities to facilitate trade
by introducing an additional element of trust.
The Office Excellence brand is synonymous with quality assurance, and is a reflection of GAPSA's continuous effort for improvement.

MARCA CE

By means of the CE Marking, the manufacturer of a piece of equipment certifies that it complies with the basic requirements set by the implementing Community Directives present in the EEC.

As it is mandatory, products to which safety directives apply should not be placed on the market without the corresponding CE Marking has been carried out and all that this entails.

MARCA SGS

SGS is one of the world's leading internationally recognized and accredited certification bodies. The SGS Product Security brand recognises product compliance with international security standards and Quality as well as endorses the continuous monitoring of the quality of the production of the marked product during the entire manufacturing process.

AIDIMA

An international technological centre, made up of companies from the furniture, wood, packaging and related industries. AIDIMA has the support of IVACE (Valencian Institute of Business Competitiveness) and is recognized by the Ministry of Science and Innovation as an Innovation and Technology Center, and integrated into the Network of Technological Institutes REDIT.

Its main objectives are to contribute to the increase of competitiveness of the Spanish furniture, wood, packaging and related industries, in all aspects related to innovation, R+D, quality, training, information, safety and in general, the improvement of management, especially in the areas of design, production and marketing. and the strengthening of exports.

pCon

In the realm of space planning and product configuration, "pCon" stands for "Product Configuration" and refers to a software system that enables 3D visualization, graphical configuration of products, and the creation of visual materials for decoration

GAPSA provides pCon to its customers.

Environmental Certificates

NF ENVIRONMENT

Voluntary mark of certification granted by AFNOR (Association Française de Normalisation). NF certifies that an industrial or consumer product meets the quality characteristics defined by French, European and international standards. The brand is evaluated with a life cycle analysis of the cabinet, its concession is materialized with the label that certifies the environmental quality of the product, and which is periodically controlled.

The brand, NF Environnement, is synonymous with commitment, and is a reflection of GAPSA's commitment to the environment.

ISO 9001 – ISO 14001

International standard that contains the central elements for the development, implementation and maintenance of an effective Environmental Management System. The certification based on it is based on continuous improvement and involves a line of work that goes beyond mere legal compliance.

ISO 14006

ISO 14006:2020 is an international standard that provides guidelines for integrating eco-design into organizations' environmental management systems. Its main objective is to reduce the environmental impacts of products throughout their entire life cycle, from the extraction of raw materials to final disposal.

Corporate Social Responsibility

GAPSA collaborates with Médecins Sans Frontières (MSF)

Solidarity is the main support that some organizations have in the fight against the oblivion of the most disadvantaged. GAPSA's will translates into delivering humanitarian and health aid to populations in emergency situations due to natural and human causes, armed conflicts, marginalized populations, etc. through Médecins Sans Frontières. With this collaboration, GAPSA aims to do its bit in an attempt to preserve life and alleviate suffering by helping to finance the humanitarian projects of Médecins Sans Frontières.

GAPSA collaborates with the Josep Carreras Foundation against leukaemia

For more than 35 years, the Josep Carreras Foundation has been working with determination to ensure that leukaemia is, one day, a 100% curable disease. GAPSA joins this cause, supporting the projects that the Foundation promotes for the benefit of patients with leukaemia, lymphoma, multiple myeloma and other types of blood cancer, as well as in favour of scientific progress.

A sense of responsibility

Did you know that…

industries around the world release 24 billion tons of CO_2 into the atmosphere annually, half of which is absorbed by flora and the sea?

60% of the world's wealth is in forests?

A dripping tap for a whole day translates into a loss of 30 liters of water?

For every ton of paper we recycle, we avoid cutting down 7 trees that exceed 15 meters in height?

We are at a time when we have, in front of us, the extraordinary opportunity to change course and do things differently.

Do things right. We act, and you?

At GAPSA we try to minimise the impact of our activity by avoiding environmental degradation, based on compliance with a Corporate Quality and Environmental Responsibility policy that involves all members of the organisation, making them participants in actions that add life in favour of our planet.

The lines of action of the policy guide us towards awareness, responsible consumption of resources and energy, correct waste management, innovation, sustainable development and compliance with all current legal and regulatory provisions.

In addition, we have the support of an involved Management, which leads and supervises the evolution of a committed behavior at an environmental level that seeks to minimize the impact of our activity and promote continuous improvement.

GAPSA PRODUCTS

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