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Navodilo za kontrolo proizvodnje za CE-oznaļevanje (potrjevanje skladnosti 2+) zidarske malte

Guidance on Factory Production Control for the CE Marking (Attestation of Conformity 2+) of designed masonry mortars

Anleitung zur werkseigenen Produktionskontrolle für die CE-Kennzeichnung (Konformitätsnachweisverfahren 2+) von Mauermörteln nach Eignungsprüfung

Guide de contrôle de la production en usine pour le marquage CE (attestation de conformité 2+) des mortiers de maçonnerie performanciels (formulés)

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This Technical Report was approved by CEN on 12 August 2005. It has been drawn up by the Technical Committee CEN/TC 125.

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Foreword

This Technical Report (CEN/TR 15225:2005) has been prepared by Technical Committee CEN/TC 125 "Masonry", the secretariat of which is held by BSI.

1 Introduction

This CEN Technical Report has been developed by CEN TC 125 and is aimed at providing guidance regarding factory production control (FPC) for designed masonry mortars (conformity system 2+).

For prescribed masonry mortar, plaster and rendering mortar (conformity system 4) there is no requirement for involvement by Notified Bodies (NBs). Manufacturers of prescribed masonry mortars can use the guidance given in this document as a basis for establishing suitable factory production control procedures to enable demonstration of conformity with the standard and the declared values.

The aim of this Guidance is to assist manufacturers in their work leading to CE marking of designed mortars.

The guidance consists of

— A general elaboration of Clause 8.3, factory production control, which is common to all the FPC references for the work of Notified Bodies and manufacturers to be found in Annex ZA, and

— An inspection scheme containing specific checklists for designed masonry mortar, which is to be considered informative.

NOTE This guidance document can be used for the evaluation of factory production control of other types of mortar that are produced in the same factory.

2 Specifications

2.1 General

These specifications are for the elaboration of FPC according to the instructions in Table ZA.3 in EN 998-2/ Annex ZA, which refer to Clause 8.3 - Factory Production Control.

Manufacturers having a factory production control system which complies with EN ISO 9001:2000 and which addresses the requirements of the harmonised standard EN 998-2, are recognised as satisfying the FPC requirements of the Directive.

The manufacturer shall establish, document and maintain a factory production control system to enable continuing conformity with the standard and the declared values of the products placed on the market.

The responsibility, authority and interrelation of all personnel who manage, perform and verify work affecting the quality of designed masonry mortar products shall be defined in the documentation of the factory production control system and keep effective.

The factory production control system shall describe the procedure of production, the regular inspections by the manufacturer and the testing. Controls and tests should address the characteristics of raw materials and finished products, as well as the production procedures, the production equipment or machines, the test equipment and the marking of the product.

All the test results shall be recorded.

Actions to be taken when the control test values or criteria do not meet those specified shall be documented by the manufacturer.

The conformity of the product shall be determined by testing according to the requirements of the harmonized standard EN 998-2 and correlated to the values and parameters stated in the factory production control manual.

2.2 Process control

2.2.1 Incoming raw materials

As appropriate, the manufacturer shall define the acceptance criteria of raw materials, and the procedures operated to ensure that these are met.

Manufacturer's inspection scheme for raw materials is given in Table 1.

2.2.2 Production process

The relevant features of the production processes shall be defined giving the frequency of the manufacturer's inspection checks, together with the required criteria and the required in-progress product characteristics. Actions to be taken when the criteria or the product characteristics are not achieved shall be specified by the manufacturer within the FPC documentation.

All production equipment that has an influence on the declared values shall be controlled and regularly inspected according to the documented procedures, frequencies and criteria.

Manufacturer's inspection schemes for production equipment are given in Table 2.

2.3 Finished product conformity

2.3.1 Tests on the finished product

The factory production control system shall incorporate a sampling plan and which shall respect the required frequency of testing of the finished product. The results of testing shall be recorded.

The sample shall be representative of the production.

The tests shall be carried out in accordance with the methods described in the EN 998-2, if given, and with the agreed FPC documentation.

Alternative methods of test to the reference methods specified in the standard may be adopted, except for initial type testing and in case of dispute, provided that these alternative methods satisfy the following:

a) A relationship can be shown to exist between the results from the reference test and those from the alternative test, and

b) The information on which the relationship is based is available.

The results of testing shall meet the specified compliance criteria and shall be recorded.

For production evaluation the manufacturer could define the conformity criteria in the FPC documentation. The conformity of the production may be evaluated in a number of ways including acceptance by variables, assessment by attributes or assessment based on individual results. One method of satisfying this for production processes is to use the approach given in ISO 12491.

Manufacturer's inspection scheme for finished product testing is given in Table 3.

The frequency of testing given in the inspection scheme may be reduced where it may be shown that the required compliance values are consistently achieved. Thus where a higher level of consistency is achieved, a lower level of testing may be adopted.

2.3.2 Test equipment

All weighing, measuring and testing equipment that has an influence on the declared values shall be calibrated and regularly inspected according to the documented procedures and frequencies, as stated in the factory production control manual.

Manufacturer's inspection schemes and the calibration criteria for equipment are given in Table 4.

2.4 Statistical techniques

Where and when possible and applicable, the results of inspections and testing shall be interpreted by means of statistical techniques, by attributes or by variables, to verify the product characteristics and to determine if the production conforms with the compliance criteria and the product conforms with the declared values.

2.5 Traceability – marking and stock control of products

The marking and stock control shall be documented. Products should be identifiable and traceable with regard to their production origin. Only conforming products shall be CE marked.

Manufacturer's inspection scheme for the manufacturer for marking and stock control is given in Table 5.

2.6 Non-conforming products

The procedure for dealing with non-conforming products shall be documented. Products that do not conform to the requirements shall be segregated and marked accordingly. However, these may be reclassified by the manufacturer and given different declared values. The manufacturer shall take action to avoid a recurrence of the non-conformity.

3 Inspection schemes

The checklists in these tables are to be used as guidance to Notified Bodies and manufacturers. The frequencies given in these tables represent the initial position and they may be reduced on the basis of satisfactory long-term product test performance. The inspections may be made directly by the manufacturer or under the responsibility of the manufacturer.

The announced surveillance inspections by the Notified certification Body shall be carried out at least once per year.