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Hydraulic road binders - Part 3: Conformity evaluation

Hydraulische Tragschichtbinder - Teil 3: Konformitätsbewertung

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Hydraulic road binders - Part 3: Conformity evaluation

Hydraulische Tragschichtbinder - Teil 3:
Konformitätsbewertung

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 51.

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Foreword

This document (prEN 13282-3:2010) has been prepared by Technical Committee CEN/TC 51 “Cement and building limes”, the secretariat of which is held by NBN.

This document is currently submitted to the CEN Enquiry.

This document will supersede ENV 13282:2000.

Annex A of this European Standard is informative.

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Scope

This European Standard specifies the scheme for the evaluation of conformity of hydraulic road binders to their corresponding product specification standards prEN 13282-1 and -2, including conformity evaluation tasks by a third party.

The standard provides technical rules for factory production control by the manufacturer, including autocontrol testing of samples and for conformity attestation by the producer. It also provides rules for actions to be followed in the event of non-conformity and, the procedure for the declaration of conformity.

1 Normative references

This European standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 13282-1	Hydraulic road binders – Part 1: Composition, specifications and conformity criteria of rapid hardening hydraulic road binders
EN 13282-2	Hydraulic road binders – Part 2: Composition, specifications and conformity criteria of normal hardening hydraulic road binders
EN 196-7	Methods of testing cement; Methods of taking and preparing samples of cement

2 Terms and definitions

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For the purpose of this European standard, the following terms and definitions apply.

2.1 Specific definitions

3.1.1

declaration of conformity

document issued by the manufacturer under the rules of this scheme for the evaluation of conformity in which he declares that the product produced by him is in conformity with the requirements of prEN 13282, Part 1 or 2

3.1.2

conformity mark

the protected marking affixed by the producer.

3.1.3

the third party

someone independent from the manufacturer or the customer and competent in conformity evaluation tasks.

3.1.4

factory production control

permanent internal control of hydraulic road binder production exercised by the manufacturer consisting of internal quality control complemented by autocontrol testing

3.1.5

factory

facility used by a manufacturer for the production of hydraulic road binder using equipment which is suitable for continuous mass production of hydraulic road binder including, in particular, equipment for adequate

grinding and homogenization and the necessary silo capacity for the storage and dispatch of each hydraulic road binder produced. This equipment and the production control applied allow the control of production with sufficient accuracy to ensure that the requirements of EN 13282 are met

3.1.6

depot

bulk hydraulic road binder handling facility (not located at the factory) used for the dispatch of hydraulic road binder (whether in bulk or bagged) after transfer or storage where the manufacturer has full responsibility for all aspects of the quality of the hydraulic road binder

3.1.7

work's quality manual

document that provides information on the factory production control which is applied by a manufacturer at a particular factory to ensure conformity of the hydraulic road binder with the requirements of the relevant product specification standard

2.2 General definitions

See annex A (informative).

3 Factory production control by the manufacturer

3.1 General requirements

3.1.1 Concept

Factory production control means the permanent internal control of hydraulic road binder production exercised by the manufacturer and consists of internal quality control (see 4.2) complemented by autocontrol testing of samples of hydraulic road binder taken at the point of release¹⁾ (see 4.3).

NOTE The requirements of this European Standard as regards factory production control take account of those clauses of EN ISO 9001 [2] which are relevant to the production, process control and testing of hydraulic road binder.

3.1.2 Work's quality manual

The manufacturer's documentation and procedures for factory production control shall be described in a Work's quality manual, which shall adequately describe, among other things:

- a) the quality aims and the organizational structure, responsibilities and powers of the management with regard to product quality and the means to monitor the achievement of the required product quality and the effective operation of the internal quality control (see 4.1.3);
- b) the manufacturing and quality control techniques, processes and systematic actions that will be used (see 4.2.1, 4.2.3 and 4.3.2);
- c) the inspections and tests that will be carried out before, during and after manufacture, and the frequency with which they will be carried out (see 4.2.2, 4.3.1 and 4.3.3).

The Work's quality manual prepared by the manufacturer for each factory shall include an adequate system of documentation (see 4.1.4 and 4.3.4).

The Work's quality manual shall address and document the procedures operated to ensure that the manufactured hydraulic road binder conforms to the technical specifications. The manual may reference associated documents which provide further details of the autocontrol testing of samples and the internal

1) This testing corresponds also to the "possibly, testing of samples taken at the factory in accordance with a prescribed test plan" mentioned in Annex III Section 2 point (ii) of the Construction Products Directive 89/106/EEC [3].

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quality control. For the purpose of this scheme, the term Work's quality manual shall be considered to include these associated documents.

NOTE In the case of an existing quality management system according to EN ISO 9001, it may be examined if the corresponding quality manual meets all the requirements of this European Standard which are relevant to the factory production control of hydraulic road binder. Provided all the requirements are included, this quality manual may also be applied for the evaluation of the conformity of the factory production control.

3.1.3 Management systems**3.1.3.1 Quality policy statement**

The Work's quality manual shall include a statement by management defining its quality policy, objectives and commitments to the attainment of product quality.

3.1.3.2 Management representative

The manufacturer shall appoint a management representative who, irrespective of other responsibilities, shall have defined authority and responsibility for ensuring that the requirements of this European Standard for the evaluation of conformity are implemented and maintained.

3.1.3.3 Internal audits and management review

In order to ensure the continuing suitability and effectiveness of the Work's quality manual to meet the requirements of this European Standard, the manufacturer shall perform at least once per year:

- a) internal audits covering the scope of this clause 4 and 6.1;
- b) a management review of the factory production control, taking into account records of the internal audits.

3.1.3.4 Training

The Work's quality manual shall describe the measures taken to ensure that all the personnel involved in operations that can affect internal quality control and product quality have appropriate experience, training and ongoing competence. Appropriate records shall be retained.

3.1.4 System of documentation**3.1.4.1 Document control**

The management representative shall be responsible for the control of all documents and data related to factory production control and to this scheme for the evaluation of conformity.

This control shall ensure that the appropriate issues of all documents are available at essential locations, that obsolete documents are withdrawn and that changes or modifications to any document are effectively introduced.

A master list shall be established to identify the current version of documents in order to prevent the use of non-applicable documents.

3.1.4.2 Quality records

The manufacturer shall retain records of factory production control for at least the period required to comply with relevant legislation.

3.2 Internal quality control

3.2.1 Process control

3.2.1.1 General

The Work's quality manual shall describe the parameters for process planning, process control and testing, inspection, corrective action, verification, dispatch and the associated records.

3.2.1.2 Constituents and composition of hydraulic road binder

The manufacturer shall establish documented procedures and appropriate test methods to ensure that the constituents meet the requirements of the relevant product specification standard and are suitable to enable hydraulic road binder to be produced meeting the technical specification.

The Work's quality manual shall describe the methods used by the manufacturer to ensure that the composition of the hydraulic road binder produced conforms to the relevant product specification standard including appropriate test methods.

3.2.1.3 Control of off-specification production

The Work's quality manual shall contain procedures to ensure that off-specification production is adequately managed.

3.2.2 Measuring and testing

3.2.2.1 Inspection, measuring and test equipment

The equipment for in-process inspection and testing shall be regularly checked and calibrated in accordance with the procedures and frequencies laid down in the Work's quality manual.

3.2.2.2 Inspection and test status

Procedures for the inspection and test status through the stages of manufacture shall be detailed in the Work's quality manual. These shall include procedures for the control of off-specification intermediate materials.

3.2.3 Handling, storage, packaging and delivery

The Work's quality manual shall describe the precautions taken for the protection of the quality of the hydraulic road binder while under the responsibility of the manufacturer. It shall include a description of the procedures used at depots. Delivery documentation shall allow traceability to the producing works.

3.3 Autocontrol testing of samples

3.3.1 Sampling and testing

The manufacturer shall operate a system of autocontrol testing for each declared hydraulic road binder. This system shall be used to demonstrate conformity to the requirements in the clause entitled "Conformity criteria" in EN 13282-1 or -2. The properties to be tested, the testing methods, the minimum frequency of autocontrol testing during routine testing and initial period testing and the conformity criteria shall be in accordance with the basic requirements given in the clause entitled "Conformity criteria" in EN 13282-1 or -2. For hydraulic road binders not being dispatched continuously, the frequency of testing and the point of sampling shall be as specified in the Work's quality manual.

All test data shall be documented.

prEN 13282-3:2010 (E)**3.3.2 Corrective action**

The Work's quality manual shall document procedures for the review and adjustment of the factory production control in case of non-conformity (see 6.1).

The actions taken in the event of non-conformity shall be recorded in a report subject to inspection during the management review.

In the event of hydraulic road binder yielding a test result not conforming to the single result limit value conformity criteria specified in the relevant product specification standard, the manufacturer shall immediately determine the affected quantity, take appropriate action to prevent the dispatch of this quantity and inform the affected customer if such hydraulic road binder has been released. In addition, the manufacturer shall immediately determine the causes of such non-conformity, take corrective actions and undertake a review of all relevant factory production control procedures. All such actions and findings shall be appropriately recorded in a report subject to inspection during the management review.

NOTE: The third party may require to be kept informed of these actions and findings.

3.3.3 Measuring and test equipment for autocontrol testing

The equipment used for autocontrol testing shall be regularly checked and calibrated in accordance with procedures and frequencies laid down in the Work's quality manual. These procedures may include comparison of compressive strength test results by proficiency testing with another laboratory designated in the Work's quality manual.

The Work's quality manual shall document procedures to ensure that all personnel involved in autocontrol testing have appropriate experience, training and ongoing competence. Appropriate records shall be retained.

3.3.4 Quality records

The manufacturer shall retain records of the autocontrol test results and appropriate records on test equipment for at least the period required to comply with relevant legislation.

4 Conformity evaluation by the third party

NOTE: The third party has responsibility for three separate functions – certification, inspection and testing. These three functions may be performed by one body or by more than one body.

5.1 Surveillance, assessment and acceptance of the factory production control**4.1.1 Inspection tasks**

The inspection tasks include surveillance, assessment and acceptance of the factory production control operated by the manufacturer. Inspection shall verify that the factory production control complies with the requirements of clause 4 and has been carried out according to the Work's quality manual.

4.1.2 Frequency of inspections

Announced inspections shall normally be carried out once per year.

4.1.3 Reports

Following each inspection, a confidential report shall be prepared and sent to the manufacturer.

The manufacturer shall, if appropriate, inform the third party of any corrective actions taken or planned to be taken following receipt of the report.

The third party shall then make a decision on its final assessment.