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Hydraulic road binders - Part 3: Conformity evaluation

Hydraulische Tragschichtbinder - Teil 3: Konformitätsbewertung

Liants hydrauliques routiers - Partie 3: Évaluation de la conformité

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Hydraulic road binders - Part 3: Conformity evaluation

Liants hydrauliques routiers - Partie 3: Évaluation de la conformité

Hydraulische Tragschichtbinder - Teil 3: Konformitätsbewertung

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COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (FprEN 13282-3:2014) 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 Unique Acceptance Procedure.

This document will supersede EN 13282-3:2013.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

This European Standard, EN 13282, *Hydraulic road binders* consists of the following parts:

- *Part 1: Rapid hardening hydraulic road binders — Composition, specifications and conformity criteria*
- *Part 2: Normal hardening hydraulic road binders — Composition, specifications and conformity criteria*
- *Part 3: Conformity evaluation*

Compared to the version EN 13282-3:2013 the following major changes have been included in this document:

- Use of the terminology given by the Construction Products Regulation (Regulation (EU) No 305/2011).
- Link between this European Standard and Annexes ZA of European Standards covering cements.

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FprEN 13282-3:2014 (E)

1 Scope

This European Standard specifies the scheme for the evaluation of conformity of hydraulic road binders to their corresponding product specification standards EN 13282-1 and FprEN 13282-2.

This European Standard provides technical rules for factory production control by the manufacturer, including autocontrol testing of samples. It also provides rules for actions to be followed in the event of non-conformity.

This European Standard should be linked with Annexes ZA of European Standards covering hydraulic road binders, i.e. EN 13282-1 and FprEN 13282-2, in particular for the assignments of tasks to the manufacturer and to the certification body.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 196-1, *Methods of testing cement - Part 1: Determination of strength*

EN 196-2, *Methods of testing cement - Part 2: Chemical analysis of cement*

EN 196-3, *Methods of testing cement — Part 3: Determination of setting times and soundness*

EN 196-7, *Methods of testing cement - Part 7: Methods of taking and preparing samples of cement*

EN 13282-1, *Hydraulic road binders - Part 1: Rapid hardening hydraulic road binders - Composition, specifications and conformity criteria*

FprEN 13282-2, *Hydraulic road binders — Part 2: Normal hardening hydraulic road binders — Composition, specifications and conformity criteria*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1 Specific definitions

3.1.1

AVCP

abbreviation for assessment and verification of constancy of performance

3.1.2

certificate of conformity of factory production control

document issued under the rules of this scheme for the AVCP indicating that adequate confidence is provided that factory production control is in conformity with the relevant product specification standard

3.1.3

conformity mark

protected mark applied on the basis of the certificate of conformity of the factory production control

3.1.4

initial period

immediate period starting after the first issuing of the certificate of conformity of factory production control for a hydraulic road binder and at the latest from the first dispatching of hydraulic road binder

3.1.5**production control certification body**

impartial body, governmental or non-governmental, possessing the necessary competence and responsibility to carry out AVCP according to given rules of procedure and management

3.1.6**factory production control**

documented, permanent and internal control of production in a factory, in accordance with the relevant harmonised technical specifications

3.1.7**factory**

facility used by a manufacturer for the production of hydraulic road binders, using equipment which is suitable for continuous mass production of hydraulic road binder including, in particular, equipment for adequate grinding and homogenisation and the necessary silo capacity for the storage and dispatch of each hydraulic road binder produced

Note 1 to entry: This equipment and the production control applied allow the control of production with sufficient accuracy to ensure that the requirements of the relevant product specification standard are met.

3.1.8**new factory**

factory which is not already producing hydraulic road binder(s) certified using this European Standard

3.1.9**existing factory**

factory which is already producing hydraulic road binder(s) certified using this European Standard

3.1.10**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

3.1.11**dispatching centre**

facility (not located at the factory) for handling and dispatching of hydraulic road binder (received in bulk or in any other condition) by activities that shall not modify the characteristics or the integrity of the product received from the manufacturer, where an intermediary has full responsibility for all aspects of the quality of the hydraulic road binder

3.1.12**intermediary**

natural or legal person who takes from the manufacturer or the importer hydraulic road binder certified using this European Standard and bearing the conformity mark, taking full responsibility for maintaining in a hydraulic road binder handling facility all aspects of the quality of the hydraulic road binder and who supplies the hydraulic road binder onwards to a further person

3.1.13**determination of the product-type**

determination of the set of representative performance levels or classes of a construction product, in relation to its essential characteristics, on the basis of type testing (including sampling), type calculation, tabulated values or descriptive documentation of the product

3.1.14**confirmation autocontrol testing**

continual testing carried out by an intermediary which consists of testing of samples taken by the intermediary at the point(s) of release from the dispatching centre

FprEN 13282-3:2014 (E)**3.1.15****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 this European Standard and the relevant product specification standard

4 Factory production control by the manufacturer**4.1 General requirements****4.1.1 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 [3] which are relevant to the production, process control and testing of hydraulic road binder.

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

In the case of an existing quality management system according to EN ISO 9001 [3], 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 certification of conformity of the factory production control.

¹⁾ This testing corresponds also to the "further testing of samples" mentioned in Annex V Section 1.1 point (a) (ii) of the Construction Products Regulation (Regulation (EU) No 305/2011).

4.1.3 Management systems

4.1.3.1 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.

4.1.3.2 Management representative

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

4.1.3.3 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 functioning and the results of the factory production control, taking into account records of the internal audits.

4.1.3.4 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 or training. Appropriate records shall be retained.

4.1.4 System of documentation

4.1.4.1 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 AVCP.

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.

The manufacturer shall have a system to identify the current versions of documents in order to prevent the use of non-applicable documents.

4.1.4.2 Quality records

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

4.2 Internal quality control

4.2.1 Process control

4.2.1.1 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.

FprEN 13282-3:2014 (E)**4.2.1.2 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.

4.2.1.3 Control of off-specification production

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

4.2.2 Measuring and testing**4.2.2.1 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.

4.2.2.2 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.

4.2.3 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.

4.3 Autocontrol testing of samples**4.3.1 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 the relevant product specification standard. 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 requirements given in the clause entitled "Conformity criteria" in the relevant product specification standard. 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.

4.3.2 Evaluation of results of autocontrol testing of samples**4.3.2.1 General**

As a rule, the manufacturer shall carry out a statistical evaluation as specified in 4.3.2.3. However, when the frequency of testing applied by the manufacturer is such that less than 20 autocontrol test results are obtained within a control period, the manufacturer shall carry out a non-statistical evaluation, as specified in 4.3.2.2.