SLOVENSKI STANDARD
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Priključni jašek za kanalizacijo stavb - 3. del: Kontrola kakovosti

Gullies for buildings - Part 3: Quality control

Abläufe für Gebäude - Teil 3: Güteüberwachung

Avaloirs et siphons pour bâtiments - Partie 3: Maîtrise de la qualité

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91.140.80 Drenažni sistemi Drainage systems

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EUROPEAN STANDARD
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English version

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Avaloirs et siphons pour bâtiments - Partie 3: Maîtrise de la qualité

Abläufe für Gebäude - Teil 3: Güteüberwachung

This European Standard was approved by CEN on 3 September 1998.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Contents

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 165 "Waste water engineering", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 1999, and conflicting national standards shall be withdrawn at the latest by October 1999.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This standard specifies the requirements for quality control for gullies and access covers for buildings to ensure conformity of these products with EN 1253–1 : 1999 and prEN 1253–4.

2 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 1253–1 : 1999
Gullies for buildings - Part 1: Requirements

EN 1253–2 : 1998
Gullies for buildings - Part 2: Test methods

prEN 1253–4
Gullies for buildings - Part 4: Access covers

EN ISO 9001
Quality systems - Model for quality assurance in design, development, production, installation and servicing (ISO 9001 : 1994)

EN ISO 9002
Quality systems - Model for quality assurance in production, installation and servicing (ISO 9002 : 1994)

3 Definitions

For the purposes of this standard the definitions given in EN 1253–1 : 1999, EN 1253-2 : 1998 and prEN 1253–4 apply.

4 Quality control

4.1 General

Products manufactured to EN 1253–1 : 1999, EN 1253–2 : 1998 and prEN 1253–4 shall be subjected to quality control procedure as follows:

a) type testing;
b) factory production control.

The control by a third party is recommended. If third party control is carried out this should be done in accordance with annex A.

NOTE: The actual practice of third party control in the different countries may be maintained as long as the third party control in this standard retains its recommendatory character.

4.2 Type testing

Complete drawings of the products are to be available. Three production specimens shall be tested in accordance with EN 1253–2 : 1998 and prEN 1253–4 and shall comply with all the relevant requirements of EN 1253–1 : 1999 and prEN 1253-4.

This procedure shall also apply if the design is subsequently amended structurally or if the material is changed. All subsequent amendments, whether structural or not shall have the approval of the certification body, if required.

4.3 Factory production control

The purpose of the factory production control is to constantly ensure that current production of gullies and access covers is in conformity with the technical requirements of EN 1253–1 : 1999 and prEN 1253–4.

Suitable staff and independence of quality control of production are indispensable prerequisites.

The facilities necessary for factory production control include the measuring and test equipment for the tests in accordance with EN 1253–2 : 1998 and prEN 1253–4.

The factory production control shall at least cover the specific items listed in tables 1 and 2.

The documentation shall include all steps of production from the incoming raw materials to the final product leaving the factory.

The factory production control may be organized in accordance with EN ISO 9001 and EN ISO 9002.

The manufacturer shall have at his disposal:

- an organization scheme with defined responsibilities;
- skilled personnel;
- all the necessary production facilities;
- all the necessary testing facilities.

Furthermore, the manufacturer shall establish and maintain a quality plan in which process and final inspections are listed. Apart from the inspection aspect, the quality plan shall also contain the method and frequency of inspection and the documentation. Tables 1 and 2 give a model scheme of factory production control and list a minimum of specific items to be covered. Finally, the manufacturer shall establish and maintain written procedures for:

- document control;
- control of non-conforming products, their storage, handling and marking;
- dealing with complaints from customers;
- calibration and control of measuring and testing equipment.

Table 1: Factory production control for gullies

Ser. No	Items to be inspected	Requirements (see EN 1253–1 : 1999)	Test methods (see EN 1253–2 : 1998)	Frequency of control
1	Appearance	8.2	Visual inspection	Each piece
2	Dimensions	6 8.3 8.5 8.6.1	Measurement 5.1 Measurement 7.1	– At start of manufacture – Each production lot*)
3	Materials	7	Manufacturer's certification of compliance	Each consignment
4	Skirt membrane affixed to the gully	8.9.5	10.4.3	– At start of production – Each production lot*)
5	Marking	9	Visual inspection	Random sampling in series production
6	Classification by loading strength	4	4	Each production lot*)

*) The size of a production lot and the number of specimens to be taken from the lot depend on the type of products, the material and the manufacturing process.

Table 2: Factory production control for access covers

Ser. No	Items to be inspected	Requirements (see prEN 1253–4)	Test methods (see EN 1253–2 : 1998)	Frequency of control
1	Appearance	6.2	Visual inspection	Each piece
2	Dimensions	6.3	Measurement	– At start of manufacture – Each production lot*)
3	Materials	5	Manufacturer's certificate of compliance	Each consignment
4	Marking	8	Visual inspection	Random sampling in series production
5	Classification by loading strength	4	4	Each production lot*)

*) The size of a production lot and the number of specimens to be taken from the lot depend on the type of the products, the material and the manufacturing process.

Annex A (informative)

Control by third party (third party control)

A.1 General

The purpose of the third party control is to demonstrate the ability of the manufacturer to manufacture products which continuously meet the requirements of EN 1253–1 : 1999 and prEN 1253–4 and to give independent certification to these products.

A.2 Procedure of the third party control

Third party control consists of:

– approval of type testing;

– general evaluation of the production and testing facilities as well as suitability of staff for continuous and orderly manufacture;

– controlling and approval of the system and of the results of the factory production control;

– independent testing of finished products, covering at least the aspects listed in tables A.1 and A.2.

Table A.1: Third party control on gullies

Ser. No	Items to be inspected	Requirements (EN 1253–1 : 1999)	Test methods (see EN 1253–2 : 1998)	Samples to be examined at each visit of inspector
1	Appearance	8.2	Visual inspection	At least two specimens with different nominal sizes (DN) of three different types*) of gullies
2	Dimensions	6	Measurement	
		8.3	5.1	
		8.5	Measurement	
		8.6.1	7.1	
3	Materials	7	Control of manufacturer's certificate of compliance	
4	Skirt membrane affixed to the gully	8.9.5	10.4.3	
5	Marking	9	Visual inspection	
6	Classification by loading strength	4	4	

*) Gullies are of the same type, when they have the same design and construction characteristics and when they are of the same material, however they may have different features.

Table A.2: Third party control on access covers

Ser. No	Items to be inspected	Requirements (see prEN 1253–4)	Test methods (see EN 1253–2 : 1998)	Samples to be examined at each visit of inspector
1	Appearance	6.2	Visual inspection	At least two specimens with different clear openings of three different types*) of access covers, if available
2	Dimensions	6.3	Measurement	
3	Materials	5	Control of manufacturer's certificates of compliance	
4	Marking	8	Visual inspection	
5	Classification by loading strength	4	4	
*) Access covers are of the same type, when they have the same design and construction characteristics and when they are of the same material, however they may have different features.				

The inspection visits of the third party are carried out without previous announcement at regular intervals two times a year.

The inspection can be reduced after two years without failures to once a year, provided that the independent certification body has made sure that the manufacturer's quality control system is adequate, that the controls have been continuously carried out in a proper and effective way and that its results are in compliance with the requirements of EN 1253–1 : 1999 and prEN 1253–4. This reduced inspection frequency is valid as long as no non-conforming products are detected.

A.3 Report by the third party

The results of the inspection visits are given in a written report. The manufacturer signs this report. If no agreement can be reached between the inspector and the manufacturer on the content of the report, the manufacturer will sign the report and state his reservations thereon.

The report contains at least the following items:

- name and/or mark of the manufacturer;
- name and location of the production plant;
- title and number of this standard;
- description and manufacturer's reference numbers of products tested;
- results of the inspection in terms of:
  - staff,
  - production and testing facilities,
  - conformity of the products,
  - factory production control,
  - document control,
  - control, handling and disposal of non-conforming products,
  - calibration and control of measuring equipment,
  - handling complaints concerning non-conformity of products;
- signature of the manufacturer's representative, place and date;
- the inspector's signature.

Within four weeks after the inspection, an official report will be sent to the manufacturer by the third party.