



SLOVENSKI STANDARD
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**Pokrovi za odtoke in jaške na vozni površinih in površinih za pešce - 700. del:
Tovarniški nadzor proizvodnje, nadzor tretjih oseb in certificiranje za pokrove za
odtoke in jaške iz poliamida**

Gully tops and manhole tops for vehicular and pedestrian areas - Part 700: Factory production control, thirdparty monitoring and certification for gully tops and manhole tops made of polyamide

Aufsätze und Abdeckungen für Verkehrsflächen - Teil700: Werkseigene Produktionskontrolle, Fremdüberwachung und Zertifizierung für Gullydeckel und Schachtabdeckungen aus Polyamid

Dispositifs de couronnement et de fermeture pour les zones de circulation utilisées par les piétons et les véhicules - Partie 700: Contrôle de la production en usine, suivi et certification tierce partie pour les dispositifs de couronnement et de fermeture en polyamide

Ta slovenski standard je istoveten z: prEN 124-700

ICS:

93.080.30	Cestna oprema in pomožne naprave	Road equipment and installations
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English Version

Gully tops and manhole tops for vehicular and pedestrian areas - Part 700: Factory production control, thirdparty monitoring and certification for gully tops and manhole tops made of polyamide

Dispositifs de couronnement et de fermeture pour les zones de circulation utilisées par les piétons et les véhicules - Partie 700: Contrôle de la production en usine, suivi et certification tierce partie pour les dispositifs de couronnement et de fermeture en polyamide

Aufsätze und Abdeckungen für Verkehrsflächen - Konformitätsbewertung für Aufsätze und Abdeckungen aus Polyamid

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 165.

If this draft becomes a European Standard, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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European foreword

This document (prEN 124-700:2024) has been prepared by Technical Committee CEN/TC 165 “Waste water engineering”, the secretariat of which is held by DIN.

This document is currently submitted to the CEN Enquiry.

The standard series EN 124 “Gully tops and manhole tops for vehicular and pedestrian areas” consists of the following parts:

- Part 1: Definitions, classification, general principles of design, performance requirements and test methods
- Part 2: Gully tops and manhole tops made of cast iron
- Part 3: Gully tops and manhole tops made of steel or aluminium alloys
- Part 4: Gully tops and manhole tops made of steel reinforced concrete
- Part 5: Gully tops and manhole tops made of composite materials
- Part 6: Gully tops and manhole tops made of polypropylene (PP), polyethylene (PE) or unplasticized poly (vinyl chloride) (PVC-U)
- Part 7: Gully tops and manhole tops made of polyamide
- Part 700: Factory production control, third party monitoring and certification for gully tops and manhole tops made of polyamide

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1 Scope

This document describes procedures for factory production control, third party inspection, and certification for verifying the conformity of gully tops and manhole tops with a clear opening up to and including 1 000 mm for installation within areas subjected to pedestrian and/or vehicular traffic in accordance with prEN 124-7.

This document is only applicable in combination with prEN 124-7. The quality management system is expected to conform to or to be no less stringent than the relevant requirements of EN ISO 9001.

This document details the applicable characteristics to be assessed for type testing, batch release test, process verification test and audit test, as well as frequency and sampling for testing products according to prEN 124-7.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 124-1:2015, *Gully tops and manhole tops for vehicular and pedestrian areas — Part 1: Definitions, classification, general principles of design, performance requirements and test methods*

prEN 124-7:2024, *Gully tops and manhole tops for vehicular and pedestrian areas — Part 7: Gully tops and manhole tops made of polyamide*

EN ISO 868, *Plastics and ebonite — Determination of indentation hardness by means of a durometer (Shore hardness) (ISO 868)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 124-1, prEN 124-7 and the following apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp/>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

factory production control

FPC

continual monitoring and control of production, at each site, exercised by the manufacturer to ensure that the product complies with the requirements of technical specifications

Note 1 to entry: Requirements e.g. regarding the type, scope and frequency of factory production control measures are laid down in the technical specifications.

3.2

type testing

determining the characteristics of a product and establishing whether the requirements of the technical specification are met

3.3

third-party inspection

inspection of the factory production control and, where applicable, of the product, carried out by the inspection body

3.4

testing laboratory

institution which measures, examines, tests and calculates the characteristics of a product, or determines them in another manner

3.5

inspection body

independent third party that carries out the third party inspection

3.6

certification

confirmation by a certification body of the compliance of the product with the technical specifications, or of the suitability of the factory production control for ensuring the characteristics of the product

3.7

certification body

third-party conformity assessment body operating certification schemes

Note 1 to entry: A certification body can be non-governmental or governmental (with or without regulatory authority, for example certification body according to EN ISO/IEC 17065).

[SOURCE: EN ISO/IEC 17065:2012, 3.12]

3.8

certificate

document issued by a certification body attesting the positive result of the certification procedure

4 Elements of verification

4.1 General

Verification is based on several individual elements which are described below. Which elements come into question, and by whom they are to be carried out, depends on the verification method selected as in Clause 5.

The institutions responsible for the elements of verification shall have the necessary professional and technical competence.

4.2 Factory production control (FPC)

4.2.1 Requirements

The manufacturer shall be responsible for FPC and appoint a person responsible for each production site (works).

The manufacturer shall set up the FPC based on the requirements of EN 124-1 and prEN 124-7. He shall ensure that technical personnel and equipment which are suitable for the FPC are available. The FPC shall cover the following activities, depending on the product and manufacturing conditions:

- a) description and inspection of raw materials and products used, including the necessary verifications;
- b) tests and controls carried out during production at specified intervals;

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- c) verifications and product tests carried out on the finished product at specified intervals;
- d) ensuring and maintaining the production process (e.g. maintenance and functional controls).

4.2.2 Measures to be taken in the event of non-compliance with requirements

Where it has been established that the requirements on the product or on the FPC have not been complied with, the manufacturer shall immediately specify corrective actions to be taken and check the effectiveness of such action.

Products that do not meet the requirements of prEN 124-7 shall be immediately marked and/or removed by the manufacturer.

4.2.3 Records and documentation

The results of the FPC shall be recorded and evaluated. The documentation shall include at least the following:

- a) description of the test object;
- b) type of tests;
- c) date of manufacture (where appropriate and technically possible);
- d) date and results of tests and comparison of results with requirements;
- e) any corrective actions carried out;
- f) place and date;
- g) name, function and signature of person responsible.

In addition, the manufacturer shall document the entire control procedure, as well as the duties and responsibilities within the FPC, and keep this documentation up-to-date.

The documentation shall be kept for at least five years and submitted on demand to the inspection body and certification body.

4.3 Test methods

4.3.1 Sampling

Sampling shall be carried out either by the manufacturer or an independent third party. Representative samples shall be taken at the works from the products intended for delivery. For the number of samples for the respective tests see Table 2.

Any products declared by the manufacturer as being faulty or to be excluded for other reasons shall only be excluded from the sampling if they are set aside and marked accordingly.

Samples shall be clearly and permanently marked. The person taking the sample shall prepare and sign a sampling report. If the samples are taken by an independent third party, this report shall be confirmed by the manufacturer or their representative, who shall receive a copy of the report.

The sample report shall include at least the following:

- a) reference to prEN 124-7:2024
- b) manufacturer and works;

- c) name of person taking the sample;
- d) sampling site;
- e) the size of the stock (from which the samples were taken), where necessary;
- f) the number or quantity of samples;
- g) designation of the product in accordance with prEN 124-7;
- h) marking of the product by the manufacturer
- i) marking of the product by the sampler;
- j) if necessary, the characteristics to be tested and the test location;
- k) place and date;
- l) name, function and signature of person responsible.

4.3.2 Type testing

The type test serves to determine the characteristics of a product and establish whether the requirements of prEN 124-7 are met.

Type testing shall be performed as described in Table 1 and Table 2 whenever there is:

- a) a change in design (D);
- b) a change in material (M);
- c) a change in production processing method (P), other than routine in-process adjustments;
- d) and an extension of the product range (E).

NOTE 1 Type testing might need to be revalidated as a result of deviation of process verification test.

- An example of a change in design (D) would be understood as changes that only have an influence on performance characteristics of the product.
- An example of a change in production processing method (P) would be understood as a change in production method from e.g. injection moulding to polymerization, or in injection moulding a different gating system for injecting the melt into the tool.
- An example of an extension of the product range (E) would be understood as an extension with a new size group.

The type test shall be repeated for the appropriate characteristic(s), whenever a change occurs in the gully top or manhole top design, in the raw material or in the supplier of the components, or in the method of production (subject to the definition of a family), which would affect significantly one or more of the characteristics.

Unless any of the conditions a) to e) above occurs, the type test results remain valid.

A type test may be performed by the manufacturer under control of the inspection body or outsourced to an independent testing laboratory.

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Type tests shall demonstrate that the products conform to all requirements for the characteristics given in Table 1 and Table 2, as applicable.

4.3.3 Random sampling test

A random sampling test is to be carried out minimum once a year by the inspection body. It serves to control the specified product characteristics and to confirm that the requirements of EN 124-1 and prEN 124-7 are met.

5 Verification of conformity**5.1 General**

Verification of conformity with the relevant technical specifications shall be based on the elements described in Clause 5.

Table 1 — Responsibility for elements of verifying conformity

Element	Verification method
	System
Factory production control	M
Sampling	I or M
Initial type testing	I or T
Random sampling test	I
Test report	I
Third-party inspection	I
Inspection report	I
Certification	C
Key M Manufacturer T Testing laboratory (independent third body) I Inspection body C Certification body (for the product certificate) NOTE: In some cases, "Certification Body" and "Inspection Body" are the same organization	

Materials, products and fitness for purpose shall conform to the requirements given in prEN 124-7.

Materials and products shall be produced by the manufacturer under a quality management system which includes a quality plan.

The compliance of gully tops and manhole tops with the requirements of this document and with the performances declared by the manufacturer in the DoC shall be demonstrated by:

- determination of the product type;
- factory production control by the manufacturer, including product assessment.

The manufacturer shall always retain the overall control and shall have the necessary means to take responsibility for the conformity of the product with this document.

All performances related to characteristics included in this document shall be determined when the manufacturer intends to declare the respective performances unless prEN 124-7 gives provisions for declaring them without performing tests.

Assessment previously performed in accordance with the provisions of this document, may be taken into account provided that they were made to the same or a more rigorous test method, under the same system on the same product or products of similar design, construction and functionality, such that the results are applicable to the product in question.

For the purposes of verification, the manufacturer's products may be grouped into families, where it is considered that the results for one or more characteristics from any one product within the family are representative for that same characteristics for all products within that same family.

NOTE Products can be grouped in different families for different characteristics.

Where components are used whose characteristics have already been determined, by the component manufacturer, on the basis of assessment methods of other product European standards, these characteristics need not be re-assessed. The specifications of these components shall be documented.

5.2 Test samples, testing and compliance criteria

5.2.1 General

The number of samples of gully tops and manhole tops to be tested/assessed shall be in accordance with Table 2. Characteristics for which the performance is to be declared are written in **bold** letters.

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