

<b>Intertek C&amp;E Management System</b>		Page 1 of 4
<b>Work Instruction (Inspection)</b>		<b>Document No.:</b> <b>WI-R-EMEA-CERT-INSP-PCS001</b>
<b>EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS</b>		
Issue Date: 11 <sup>th</sup> Feb 2015	Revision Date: 10 <sup>th</sup> Sept. 2015	Approved by: Anders Delsborn
	Effective Date: 24 <sup>th</sup> Sept. 2015	

### 1.0 Purpose

Product Control Specifications (PCS) specify the requirements for routine inspections, tests, Product Verification Tests and sample selection for products certified under an Intertek EU Type 5 certification scheme (including GS, S, BEAB, ASTA, ENEC, BAUART and TICK MARK). They are for use by manufacturers and by factory inspectors.

### 2.0 Scope

Products: Rewirable products (including: plugs, connectors, portable socket-outlets), with or without a cable connected.

Standards: SS 428 08 67 (S), BS 1363 (ASTA), IEC 60320, IEC 60309, IEC 60884 + others

Marks: S, ASTA, ENEC

### 3.0 Routine inspections and tests

#### 3.1 General

The following requirements apply to most products.

Variations may be permitted by prior, written agreement from the certification body.

The factory should have a quality plan defining all inspections and tests on materials, components and completed products as appropriate.

Completed products shall be marked to confirm satisfactory completion of all required testing.

Any products which fail inspection or testing shall be segregated and not allowed to continue through the process until rectified and re-inspected or retested.

Products shall not be released until the testing equipment has been checked again following a production batch.

Records of inspections and test should be maintained and held for at least two years.

Records shall include:

- Type of product
- Date of test
- Place of manufacture
- Quantity tested
- Number of failures and actions taken

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### 3.2 Required inspections and tests (for Intertek Certification Marks)

<b>Inspection/test</b>	<b>Test parameters</b>	<b>Sampling plan</b>
All mouldings and parts correct, correctly formed and free from defects	Visual, check to work instructions	10 per day or shift
All internal connections (e.g. riveted or welded) correct	Visual, check to work instructions	10 per day or shift
<sup>A)</sup> Preparation of conductors (e.g. removal of sheaths, prepared conductor length,	Visual, check to work instructions	10 per day or shift
Correct tightening torque for all screws	Visual, check to work instructions	Each shift
Confirm correct fuse is fitted (if appropriate)	Visual, check to work instruction for configuration under manufacture	10 per day or shift
Satisfactory appearance, markings and any user instructions correct and clear	Visual inspection	100%
Dimensions	Visual, check to work instructions.  For BS 1363 plugs: use of BS1363 Figure 5 gauge is required unless otherwise agreed by Intertek.	3 samples at beginning of a batch and 3 samples at end of batch or after 8 hours, if sooner
Cover fixing screws	Tighten (to the torque required by the product standard) and loosen ten times. Screw and threaded hole must be suitable for continued service	10 per day or shift
Check functioning of electrical test equipment	To suit, e.g. dummy samples to confirm detection of each fault condition	Start and end of each shift
<sup>A)</sup> Correct polarity connection and continuity	SELV, 2 seconds (manual) SELV, 1 second (if automatic timing)	100%

<sup>A)</sup> Applicable to rewirable products fitted with a cable.

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### 3.3 Required inspections and tests (for ENEC Marked products)

In addition to the inspections and tests detailed in section 3.2, the requirements of document ENEC 303 Annex Y shall be fulfilled for IEC 60309 products.

### 4.0 Product Verification Tests/Periodic testing (refer to CIG 021 clause 4.8)

Product verification tests are in addition to the production line inspection and routine tests and are performed on samples taken randomly from the production line.

The manufacturer is responsible for conducting or arranging for the following periodic testing to be completed. Records shall be available for review during factory inspection visits.

<b>Certification Mark</b>	<b>Frequency</b>	<b>PVT/periodic testing required</b>
SEMKO ASTA	Annual	PVT is not mandatory but it is recommended to demonstrate ongoing compliance with EU Directives. The following PVT is recommended <ul style="list-style-type: none"> <li>• Marking</li> <li>• Construction</li> <li>• Protection against moisture</li> <li>• Insulation resistance and electric strength</li> <li>• Terminals and cord anchorage</li> </ul>
ENEC		PVT according to document ENEC 303 Annex Y shall be fulfilled for IEC 60309 products.

Intertek certification offices can advise on any aspect of PVT and can provide the testing service if required.

### 5.0 Surveillance testing by the Certification Body

If required, samples are selected during the factory inspection and the manufacturer should send these to the address provided. If samples are required but not available at the time of the inspection, the manufacturer should send these as soon as they become available. If there is no stock or production, the manufacturer should advise the certification body that samples will not be provided due to no production.

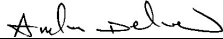
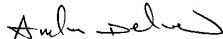
The certification body will arrange for the required testing to be completed. This will be charged to the manufacturer or Licence holder. A report of the testing will be provided.

<b>Certification Mark</b>	<b>Surveillance testing requirements</b>
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ASTA	Samples to be selected each year as detailed on the sample selection record (form AFT-17) provided to the inspector before each visit.
SEMKO	Regular selection of samples is not required. Samples may be required if any deviations to the type tested or non-compliance with the product standard are suspected

Document History				
Revision No.	Date	Changes	Name & Title	
			Author	Approving Official
1	11/02/2015	Original issue	R W Hayward	
2	10/09/2015	Update of required test for products covered by IEC 60320, IEC 60309, IEC 60884 and SS 428 08 67 Update to include products with and without connected cables	R W Hayward Thomas Jonasson	

End of Document

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