

Intertek C&E Management System		Page 1 of 3
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS003
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
Issue Date:	Revision Date: 11 th Feb 2015	Approved by: Anders Delsborn
	Effective Date: 19 th Feb 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: General purpose fuse-links
Standards: BS 1362
Marks: ASTA

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.

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

Note: these are “safety critical” items. Documentation including bills of material and quality plans must be available for review by Intertek during inspection.

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3.2 Required inspections and tests

Inspection/test	Test parameters	Sampling plan
Process control checks (Samples shall be taken from each machine/production line and subjected to the mentioned tests)	See items 1 to 7 below	Ref: BS 6001 Part 1: 1972 Inspection Level 2, AQL 0.4% (see below for example)
	1) external dimensions	All samples
	2) Tightness of end-caps (by hand)	All samples
	3) Content, clarity and colour of marking	All samples
	4) Test fuse operation at 1.9In (as BS 1362 clause 8.3.4)	10 samples
	5) Repeat test at 1.9In if one failure during test 4) above. No further failures allowed.	10 samples
	6) Test fue operation at 1.6In (as BS 1362 clause 8.3.3). No failures allowed	10 samples
	7) quantity of filler and correctness of assembly	50% of samples
Mechanical test	Tumbling barrel test as in BS 1362 clause 8.5	3 from each shift and machine/line
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
Voltage drop/resistance	According to pre-determined values which can be demonstrated to discriminate between satisfactory and non-satisfactory products. Note: different ratings of fuse must have different acceptance values.	100%

Example of applicable sampling plans:

Batch quantity	Sample	Accepted	Rejected
1,201 – 3,200	125	1	2
3,201 – 10,000	200	2	3

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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.

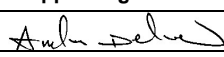
Inspection/test	Test parameters	Sampling plan
Power loss and overload	BS 1362 clause 8.2 and 8.3.5	6 samples per month

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.

Certification Mark	Surveillance testing requirements
ASTA	Samples to be selected each year as detailed on the sample selection record (form AFT-17) provided to the inspector before each visit.

Document History				
Revision No.	Date	Changes	Name & Title	
			Author	Approving Official
1	11/02/2015	Original issue	R W Hayward	

End of Document

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