

Intertek C&E Management System		Page 1 of 4
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS009
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: Conduit systems
Standards: IEC/EN 61386 series, EN 50086 series
Marks: S, ASTA, BAUART, TICK

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 (ten years for records of crimping tests).

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

Inspection/test	Test parameters	Sampling plan
Material tests	Bending test (clause 10.4) or impact test (clause 10.3). For non-metallic conduit the test to be performed at the minimum rated temperature	At least on each new delivery of material or at specified intervals if material is continuously delivered or mixed. Manufacturer to determine sample quantities.
	Resistance to heating (clause 12.2) or compression test (clause 10.2). For non-metallic conduit the test to be performed at the maximum rated temperature	
	Electrical properties (clauses 11.2 and 11.3) Dielectric strength test for insulated conduits Bonding tests for conductive conduits	
Marking	Visual inspection	At least first and last of each batch or shift, minimum once per day
Dimensions	Gauges or measurements Outside diameter Inside diameter Thread Wall thickness	
Cable space free from sharp edges, burrs and surface projections	Visual inspection	100%

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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.

Certification Mark	Frequency	PVT/periodic testing required
All	Annual	<p>PVT not mandatory but it is recommended to demonstrate ongoing compliance with EU Directives.</p> <p>The following PVT is recommended (clause numbers refer to IEC 61386):</p> <ul style="list-style-type: none"> 7 Marking and instructions 10.2 Compression test 10.3 Impact test at lower range temperature 10.4 Bending test 10.7 Tensile tests 11.2 Bonding test 11.3 Electrical insulating strength and resistance (non-metallic) 12.1 Flame propagation 12.2 Resistance to heat 14 External influences (if any)

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.
SEMKO, BAUART, TICK	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

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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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