

Intertek C&E Management System		Page 1 of 5
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS013
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
Issue Date: : 11 th Feb 2015	Revision Date: 04 th September 2017	Approved by: Fredrik Wennersten
	Effective Date: 04 th October 2017	

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, BAUART and TICK MARK). They are for use by manufacturers and by factory inspectors.

2.0 Scope

Products: Electrical motor-operated hand-held-tools, transportable tools and lawn and garden machinery

Standards: EN 60745-1 Annex N, EN 62841-1 Annex F

Marks: GS, S, BAUART, TICK and 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)

Inspection/test	Test parameters	Sampling plan
Earthing continuity for class I appliances by an ac source with a no load voltage not exceeding 12V.	10A between earthing terminal or contact of a plug and each of the accessible metal parts which have to be earthed for safety reasons. - < 0.3 Ω for appliances having a supply cord not exceeding 5m. 0.12 Ω may be added for each additional 5m of supply cord	100%
Dielectric strength, basic insulation class III appliances	400 Vac , 3 second No flash-over or breakdown Leakage current not to exceed 5 mA. (If the tool incorporates dc components, then test with dc may be necessary.)	100%
Dielectric strength, basic insulation class I appliances	1000 Vac , 3 second No flash-over or breakdown Leakage current not to exceed 5 mA. (If the tool incorporates dc components, then test with dc may be necessary.)	100%
Dielectric strength, double or reinforced insulation	2500 Vac, 3 second No flash-over or breakdown Leakage current not to exceed 5 mA. (If the tool incorporates dc components, then test with dc may be necessary.)	100%
Functional test	If incorrect operation might result in a hazard, the correct operation is checked for example by electric measurement, by verifying the functional device, such as switches and manually-operated controls, guards, and by verifying the direction of rotation of motors.	100%
Integral plugs	- Fixing of pins, pull-test with 40N - rear edges of metal-pins well rounded	At the beginning of a batch, at appropriate steps and at the end of a batch

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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 AF shall be fulfilled.

4.0 Product Verification Tests/Periodic testing (refer to CIG 021 clause 5.8)

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
S	(Annual)	PVT is not mandatory but it is recommended to demonstrate ongoing compliance with EU Directives. The following PVT is recommended: - PVT according to document ENEC 303 Annex AF.
GS, , BAUART and TICK Mark	Annual	For each basic type certified, the following tests according to the product standard or as specified: <ul style="list-style-type: none"> • Marking (Clause 8) • Protection against electric shock (Cl. 9) • Abnormal operation (To check operation of protective devices, if any).(Cl. 18) • Mechanical Hazards (Cl. 19) • Creepage distances, clearances and distance through insulation. (Cl. 28) • Comparison of used components with the approved version. (See list of critical components in test report / CDF) • Appliances with integral plug: <ul style="list-style-type: none"> ○ Dimensions including front and rear edges of metal pins ○ Rotation test on pins with 0.4 Nm for one minute ○ Pull test on pins at temperature of 70°C, 40 N for plugs rated 2.5 A. 50 N for plugs rated > 2.5 A
ENEC	Each production	PVT according to document ENEC 303 Annex AF shall be fulfilled

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	lot and Every two years	

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.

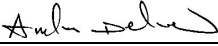
The certification body will arrange for the required testing to be completed. This will be charged to the manufacturer or Licence holder. A report of the testing will be provided.

Certification Mark	Surveillance testing requirements
GS, S, BAUART and TICK Mark	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
ENEC	Product surveillance according to document ENEC 324. Samples for product surveillance are selected by the inspector at the time of factory inspection, to be sent to Intertek Semko AB

Document History

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Revision No.	Date	Changes	Name & Title	
			Author	Approving Official
1	11/02/2015	Original issue	Bernhard Miedtank/ R W Hayward	
2	04/09/2017	Added the standard EN 62841, corrections in 4.0 PVT tests and in 5.0 ENEC Product surveillance	Christoffer Johansson/ Paul Klemets	Fredrik Wennersten

End of Document

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