

Intertek C&E Management System		Page 1 of 5
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS042
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, BAUART and TICK MARK). They are for use by manufacturers and by factory inspectors.

2.0 Scope

Products: Gasoline powered machines

Standards: Intertek-Prüfprogramm P12-0004, EN ISO 10517, EN ISO 11680-1, EN ISO 11681-1, EN ISO 11681-2, EN ISO 11806-1, EN ISO 11806-2, ISO/DIS 8437, ISO 11789, EN 709, EN 809, EN 836, EN 12733, EN 13683, EN 13684, EN 15503

Marks: GS, BEAB, BAUART and TICK Mark

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

Inspection/test	Test parameters	Sampling plan
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
Correct tightening torque for all screws	Visual, check to work instructions	Each shift
Dimensions accuracy of critical mechanical parts	Visual or by gauges, check to work instructions. Test may be done at appropriate steps in production or at incoming goods.	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. Check of: <ul style="list-style-type: none"> - Switches and controls; - Normal function check (such as brake function, self-propelled, etc.) - Guards and interlocks ; - Speed measurement for machines with exposed cutting means (idle / clutch engagement if applicable / max. engine speed) (e.g. chain saw, brush cutter, grass trimmer, earth auger, pole mounted pruner and similar machines) 	100%
Satisfactory appearance, markings, warnings and any user instructions correct and clear	Visual inspection	100%
Earth continuity and dielectric strength test as following for machines having electrical connections e.g. electric starting devices on machines:		
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.	100%

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	- < 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	
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	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 machine incorporates dc components, then test with dc may be necessary.)	100%

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
GS, BEAB, 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 • Speed measurements, such as idle speed, clutch engagement speed, max. engine speed • Stopping time test, if required by the standard the product is certified to • Brake time test, if required by the standard the product is certified to

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		<ul style="list-style-type: none"> Mechanical strength test, if required by the standard the product is certified to Comparison of used components with the approved version, for example Motor, carburetor, spark plug and switches Protection against electric shock for appliances with electrical components Creepage distances, clearances and distance through insulation for appliances with electrical components
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5.0 Surveillance testing by the Certification Body

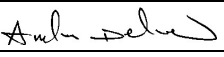
If required, samples are selected during the factory inspection and the manufacturer should send these to the address provided. If samples are required but not available at the time of the inspection, the manufacturer should send these as soon as they become available. If there is no stock or production,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

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

End of Document

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