

Intertek C&E Management System		Page 1 of 4
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS043
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
Issue Date:	Revision Date: 07 Nov 2022	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: Thermal Links
Standards: EN 60691
Marks: BEAB, S

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

Intertek C&E Management System		Page 2 of 4
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS043
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
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3.2 Required inspections and tests

Inspection/test	Test parameters	Sampling plan
Insulation resistance test	The test is carried out using a test voltage equal to (2 X Rated Voltage) applied between the current path and the enclosure wrapped in metal foil. The resistance shall not be less than 2 Megohms. It is recommended that a d.c. voltage is used to eliminate possible deviations due to capacitive currents, however if an a.c voltage is used, the instrument used should measure only the in-phase component of the current flowing and no account shall be taken of the capacitive component.	100%
Dielectric strength test	This test is conducted between the current path and the enclosure wrapped in metal foil. A voltage of substantially sine wave form, having a frequency of 50/60Hz and the value equal to (2 X Rated Voltage) + 1000V is applied for 10 seconds or for 2 seconds if the test voltage is raised to 1.1 times that value. No breakdown or flashover shall occur during these tests. The current sensing device incorporated in the test circuit would normally trip at a current not exceeding 5mA.	100%

Intertek C&E Management System		Page 3 of 4
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS043
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
Issue Date:	Revision Date: 07 Nov 2022	Approved by: Anders Delsborn
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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
BEAB	Bi-Annual	<p>The manufacturer shall test three samples each, for all temperature ratings for thermal links,</p> <p>once every two years for 10.3 (Interrupting current), 11.3(Rated functioning temperature) and 11.4 (Maximum temperature limit) followed by the tests of 10.1 (Dielectric strength) and 10.2 (Insulation resistance). The pre-conditioning tests described in 9.2 (Lead secureness tests) may be omitted.</p> <p>b) Post Operation</p> <ol style="list-style-type: none"> 1. Dielectric strength test 2. Insulation resistance test. <p>The above tests may be carried out in the Manufacturer's test rooms, at a suitably equipped Test House or may be arranged through Intertek. They should be carried out to the requirements of the Safety Standard unless otherwise agreed by Intertek. If significant problems are revealed, these must be investigated and production stocks bonded until resolved with Intertek's agreement.</p> <p>All test records must be available for inspection.</p>

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

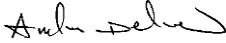
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Intertek C&E Management System		Page 4 of 4
Work Instruction (Inspection)		Document No.: WI-R-EMEA-CERT-INSP-PCS043
EMEA CERTIFICATION SCHEMES - PRODUCT CONTROL SPECIFICATIONS		
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the inspection, the 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
BEAB	Surveillance samples are selected at the request of the BEAB Surveillance Coordinator.

Document History				
Revision No.	Date	Changes	Name & Title	
			Author	Approving Official
1	11/02/2015	Original issue	Rajesh Sodha/ R W Hayward	
2	07/11/2022		G Parker	

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