

**BRL-K623**  
2019-10-01

# Evaluation Guideline

for the Kiwa product certificate for  
Plumbing fittings for capillary soldering and/or  
thread connections to copper tubes



**Trust  
Quality  
Progress**

# Preface

This evaluation guideline has been accepted by the Kiwa Board of Experts Watercycle (CWK), in which all relevant parties in the field of Plumbing fittings for capillary soldering and/or thread connections to copper tubes are represented. The Board of Experts also supervises the certification activities and where necessary requires the evaluation guideline to be revised. All references to Board of Experts in this evaluation guideline pertain to the above mentioned Board of Experts.

This evaluation guideline will be used by Kiwa in conjunction with the Kiwa Regulations for Product Certification.

The main changes compared to the previous version are the editorial modifications in the content of the BRL in relation to the quality objective of Kiwa.

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The use of this evaluation guideline by third parties, for any purpose whatsoever, is only allowed after a written agreement is made with Kiwa to this end.

## **Validation**

This evaluation guideline has been validated by Kiwa on 1 December 2018

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# 1 Introduction

## 1.1 General

This evaluation guideline includes all relevant requirements which are adhered to by Kiwa as the basis for the issue and maintenance of a certificate for products used for Plumbing fittings for capillary soldering and/or thread connections to copper tubes.

This guideline replaces the evaluation guideline BRL-K623/03, dated 01-02-2012. The quality declarations issued and based on that guideline will lose their validity at least 2 years after validation of this BRL.

For the performance of its certification work, Kiwa is bound to the requirements as included in NEN-EN-ISO/IEC 17065 "Conformity assessment - Requirements for bodies certifying products, processes and services".

## 1.2 Field of application / scope

The plumbing fittings are being used to make capillary soldering and/or thread connections, in tap water installations, household gas installations and in heating installations.

The plumbing fittings are intended for use in combination with copper pipes according to the Kiwa guideline BRL-K760.

For the application in tap-water installations a maximum working pressure of 1000 kPa and a maximum water temperature of 90°C is applicable.

## 1.3 Acceptance of test reports provided by the supplier

If the supplier provides reports from test institutions or laboratories to prove that the products meet the requirements of this evaluation guideline, the supplier shall prove that these reports have been drawn up by an institution that complies with the applicable accreditation standards, namely:

- NEN-EN-ISO/IEC 17020 for inspection bodies;
- NEN-EN-ISO/IEC 17021 for certification bodies certifying systems;
- NEN-EN-ISO/IEC 17024 for certification bodies certifying persons;
- NEN-EN-ISO/IEC 17025 for laboratories;
- NEN-EN-ISO/IEC 17065 for certification bodies certifying products.

### Remark:

This requirement is considered to be fulfilled when a certificate of accreditation can be shown, issued either by the Board of Accreditation (RvA) or by one of the institutions with which an agreement of mutual acceptance has been concluded by the RvA. The accreditation shall refer to the examinations as required in this evaluation guideline. When no certificate of accreditation can be shown, Kiwa shall verify whether the accreditation standard is fulfilled.

## 1.4 Quality declaration

The quality declaration to be issued by Kiwa is described as a Kiwa product certificate. A model of the certificate to be issued on the basis of this evaluation guideline has been included for information as Annex.

## 2 Terms and definitions

### 2.1 Definitions

In this evaluation guideline, the following terms and definitions apply:

- **Board of Experts:** the Board of Experts “Water Cycle” (CWK).
- **Certification mark:** a protected trademark of which the authorization of the use is granted by Kiwa, to the supplier whose products can be considered to comply on delivery with the applicable requirements and possibly with quality information on the application of the product is added by a specially designed label which is based on the result, as stated in the report issued by Kiwa on the inspection of the prototype
- **Drinking water:** water intended or partly intended for drinking, cooking or food preparation or other domestic purposes, but does not include hot water, and is made available by pipeline to consumers or other customers.
- **Drinking water installation:** an installation direct or in-direct connected to the public drinking water distribution network of a drinking water company (source Dutch drinking water act);
- **Evaluation Guideline (BRL):** the agreements made within the Board of Experts on the subject of certification.
- **Hot tap water:** water intended or partly intended for drinking, cooking or food preparation or other domestic purposes, which is heated before it is made available for those applications.
- **House hold water:** non-potable water that may only be used within premises for flushing toilets (source Dutch drinking water act);
- **Installation:** configuration consisting the pipe work, fittings and appliances;
- **Inspection tests:** tests carried out after the certificate has been granted in order to ascertain whether the certified products continue to meet the requirements recorded in the evaluation guideline.
- **IQC scheme (IQCS):** a description of the quality inspections carried out by the supplier as part of his quality system.
- **Pre-certification tests:** tests in order to ascertain that all the requirements recorded in the evaluation guideline are met.
- **Private Label Certificate:** A certificate that only pertains to products that are also included in the certificate of a supplier that has been certified by Kiwa, the only difference being that the products and product information of the private label holder bear a brand name that belongs to the private label holder.
- **Product certificate:** a document in which Kiwa declares that a product may, on delivery, be deemed to comply with the product specification recorded in the product certificate.
- **Product requirements:** requirements made specific by means of measures or figures, focussing on (identifiable) characteristics of products and containing a limiting value to be achieved, which can be calculated or measured in an unequivocal manner.

- **Supplier:** the party that is responsible for ensuring that the products meet and continue to meet the requirements on which the certification is based.

# 3 Procedure for granting a product certificate

## 3.1 Initial investigation

The initial investigation to be performed are based on the (product) requirements as contained in this evaluation guideline, including the test methods, and comprises the following:

- type testing to determine whether the products comply with the product and/or functional requirements;
- production process assessment;
- assessment of the quality system and the IQC-scheme;
- assessment on the presence and functioning of the remaining procedures.

## 3.2 Granting the product certificate

After finishing the pre-certification tests, the results are presented to the Decision maker (see 9.2) deciding on granting the certificate. This person evaluates the results and decides whether the certificate can be granted or if additional data and/or tests are necessary.

## 3.3 Investigation into the product and/or performance requirements

Kiwa will investigate the to be certified products against the certification requirements as stated in the certification requirements.

The necessary samples will be drawn by or on behalf of Kiwa.

## 3.4 Production process assessment

When assessing the production process, it is investigated whether the producer is capable of continuously producing products that meet the certification requirements.

The evaluation of the production process takes place during the ongoing work at the producer.

The assessment also includes at least:

- The quality of raw materials, half-finished products and end products;
- Internal transport and storage.

## 3.5 Contract assessment

If the supplier is not the producer of the products to be certified, Kiwa will assess the agreement between the supplier and the producer.

This written agreement, which is available for Kiwa, includes at least:

Accreditation bodies, scheme managers and Kiwa will be given the opportunity to observe the certification activities carried out by Kiwa or on behalf of Kiwa at the producer.



# 4 Requirements

## 4.1 General

This chapter contains the requirements the plumbing fittings for capillary soldering and/or thread connections to copper tubes have to fulfil.

## 4.2 Regulatory requirements

### 4.2.1 *Requirements to avoid deterioration of the quality of drinking water*

Products and materials which (may) come into contact with drinking water or warm tap water, shall not release substances in quantities which can be harmful to the health of the consumer, or negatively affect the quality of the drinking water. Therefore, the products or materials shall meet toxicological, microbiological and organoleptic requirements as laid down in the currently applicable "Ministerial Regulation materials and chemicals drinking water and warm tap water supply", (published in the Government Gazette). Consequently, the procedure for obtaining a recognised quality declaration, as specified in the currently effective Regulation, has to be concluded with positive results.

Products and materials with a quality declaration<sup>1</sup>, e.g. issued by a foreign certification institute, are allowed to be used in the Netherlands, provided that the Minister has declared this quality declaration equivalent to the quality declaration as meant in the Regulation.

#### Note

Plumbing fittings for capillary soldering and/or thread connections which are intended for use only in gas installations and/or heating installation are not entitled to be assessed upon the hygienic aspects.

## 4.3 Product requirements

### 4.3.1 *Product*

The requirements of the product are specified in standard with exception of the aspects where requirements are specified in chapter 4.3.2..

The requirements for plumbing fittings for capillary soldering and/or thread connections to copper tubes shall meet and the respective test methods have been laid down in the following standards:

EN 1254-1	Copper and copper alloys - Plumbing fittings - Part 1: Fittings with ends for capillary soldering or capillary brazing to copper tubes	February 1998
EN 1254-4	Copper and copper alloys - Plumbing fittings - Part 4: Fittings combining other end connections with capillary or compression ends	March 1998
EN 1254-4/AC	Copper and copper alloys - Plumbing fittings - Part 4: Fittings combining other end connections with capillary or compression ends	August 1999

### 4.3.2 *Additional requirements*

In view of what has been mentioned in article 4.2, the product shall also meet the following requirements.

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<sup>1</sup> A quality declaration issued by an independent certification institute in another member state of the European Community or another state party to the agreement to the European Economic Area, is equivalent to a recognized quality declaration, to the extent that, to the judgment of the Minister of the first mentioned quality declaration, is fulfilled the at least equivalent requirements as meant in the Regulation materials and chemicals drinking water- and warm tap water supply.

#### 4.3.2.1 *Hygienic treatment of products in contact with drinking water*

The supplier must have a procedure in place that protects the products in such way, that the hygiene is ensured during storage and transport.

In addition, the supplier shall inform the customer about the handling of products delivered under the certificate, which come into contact with drinking water and warm tap water, from arriving at the construction site through to the realization and commissioning. The primary reason for providing this the information is to contribute to the awareness of the importance of hygienic work as a 'prevention measure'.

#### 4.3.2.2 *Protection of products during transport and storage*

For the purpose of hygienic handling, products shall be protected against contamination. This is in regards to the surfaces of the product that come into contact with drinking water during the application.

Precautions to protect the product against contamination shall be agreed upon between the supplier and the client and shall be recorded in the quality management system of the supplier.

#### 4.3.2.3 *Other materials*

Other materials are permissible on the following conditions:

- it shall be of comparable quality<sup>1</sup>;
- it shall not generate electrochemical corrosion (contact corrosion)<sup>2</sup> ;
- resistant against water with a temperature of 90°C. The material is considered to comply to this requirements in case after the test according article **Error! Reference source not found.** no leakage occurs.
- it shall comply with the requirements laid down in article **Error! Reference source not found.**

#### 4.3.3 *Nominal diameter*

In contradistinction to EN 1254-1, table 2, this evaluation guideline is only applicable for capillary soldering fittings with the following nominal diameters:

DN 10 - DN 12 - DN 15 - DN 18 - DN 22 - DN 28 - DN 35 - DN 42 - DN 54

For plumbing fittings with threaded connecting ends and for fittings for capillary brazing, also the following nominal diameters are applicable

DN 64 – DN 76,1 – DN 88,9 – DN 108

##### **Remark**

Nominal diameters mentioned above are generally used in the Netherlands and included as such in the Kiwa evaluation guideline BRL-K760.

As specified in the VEWIN worksheets W.B. 2.2 A is soldering of pipes with a nominal diameter greater than 54 mm not permitted.

#### 4.3.4 *Internal solder end*

The entrance of the internal solder end shall be rounded with a radius of  $0.5 \pm 0.3$  mm, or bevelled over  $0.5 \pm 0.3$  mm under an angle of 45°.

<sup>1</sup> the materials are considered to comply when the functional examinations as indicated in EN 1254 part 1 and/or part 4 have been concluded with positive results.

<sup>2</sup> To be proven by the manufacturer by means of test reports.

#### 4.3.5 Width across flats

The width across flats preferably shall be according to ISO 272.

If the width across flats exceeds 46 mm, the key flats can also be octangular. The height of the key flats must be at least equal the values of Table 1.

**Table 1** - Minimum height key flat

width across flats [mm]		height of the key flat [mm]
more than	up to and including	
	22	4
22	27	5
27	32	6
32	41	7
41	50	8
50	75	9
75		10

#### 4.3.6 Reducers

For reducers the transition between the nominal diameters shall be gradually with a maximum angle of 45° between the bevel and the centre line of the fitting.

#### 4.3.7 Angles

In addition to EN 1254-1, article 4.3.5, the angle between the axis of the bore of the taper end and that of the straight ends of the T-piece, as well as with the angle between the axis of both bores of an elbow or a long radius elbow shall be 90°.

The elbows can also be constructed in such a way that the axes of the bores are under an angle of 45° as compared to each other.

# 5 Test methods

## 5.1 General

## 5.2 Determination resistance against water with a temperature of 90°C

### 5.2.1 *Test installation.*

For determining the resistance against water with a temperature of 90 °C, a test sample, immersed in water of  $90 \pm 3$  °C, shall be installed in a test installation in which this sample can be put under a water pressure of 1600 kPa.

### 5.2.2 *Sample / Test pieces*

For this determination one sample is needed which consists of two lengths of copper pipe connected to each other with one straight fitting.  
The compression fittings shall be assembled according to the manufacturer's instructions.

### 5.2.3 *Procedure*

- a. place the test pieces in the installation and fill them with water,
- b. gradually increase the pressure to 1600 kPa and maintain this pressure,
- c. immerse the test pieces for  $168 \pm 1$  hour in water with a temperature of 90 °C,
- d. determine the water-tightness during the test sequence.

# 6 Marking

## 6.1 General

The products shall be marked with following indelible marks and indications:


- name or logo of the manufacturer;
- data or code indicating the date of production;
- type indication.

## 6.2 Certification mark

After concluding a Kiwa certification agreement, the certified products shall be indelible marked with the certification mark:

For products which come in contact with drinking water:

The Kiwa Water Mark “**KIWA** ”, or Kiwa .

For minimized marking (small sized products) the  in a rectangle is permitted.

# 7 Requirements in respect of the quality system

This chapter contains the requirements which have to be met by the supplier's quality system.

## 7.1 Manager of the quality system

Within the supplier's organizational structure, an employee who will be in charge of managing the supplier's quality system must have been appointed.

## 7.2 Internal quality control/quality plan

The supplier shall have an internal quality control scheme (IQC scheme) which is applied by him.

The following must be demonstrably recorded in this IQC scheme:

- which aspects are checked by the supplier;
- according to what methods such inspections are carried out;
- how often these inspections are carried out;
- in what way the inspection results are recorded and kept.

This IQC scheme should at least be an equivalent derivative of the model IQC scheme as shown in the Annex.

## 7.3 Control of test and measuring equipment

The supplier shall verify the availability of necessary test and measuring equipment for demonstrating product conformity with the requirements in this evaluation guideline.

When required the equipment shall be kept calibrated ( e.g. recalibration at interval).

The status of actual calibration of each equipment shall be demonstrated by traceability through an unique ID.

The supplier must keep records of the calibration results.

The supplier shall review the validity of measuring data when it is established at calibration that the equipment is not suitable anymore.

## 7.4 Procedures and working instructions

The supplier shall be able to submit the following:

- procedures for:
  - dealing with products showing deviations;
  - corrective actions to be taken if non-conformities are found;
  - dealing with complaints about products and/or services delivered;
- the working instructions and inspection forms used.

## 7.5 Other requirements

The supplier shall be able to submit the following:

- the organisation's organogram;
- qualification requirements of the personnel concerned.

## 8 Summary of tests and inspections

This chapter contains a summary of the following tests and inspections to be carried out in the event of certification:

- **initial investigation:** tests in order to ascertain that all the requirements recorded in the evaluation guideline are met;
- **inspection test:** tests carried out after the certificate has been granted in order to ascertain whether the certified products continue to meet the requirements recorded in the evaluation guideline;
- **inspection of the quality system of the supplier:** monitoring compliance of the IQC scheme and procedures.

### 8.1 Test matrix

Description of requirement	Article EN1254	Tests within the scope of	
		Pre-certification	Inspection by Kiwa after granting of certificate a,b )
<b>Product requirements</b>			
<i>Requirements of EN1254-1</i>			
Dimensions and tolerances	4.3	X	X
Design and manufacture	4.4	X	X
Production test requirements	4.5	X	X
Type test requirements	4.6	X	X
<i>Requirements of EN1254-4</i>			
Screwed union connections	4.2	X	X
Thread configurations	4.3	X	X
Tightening systems	4.4	X	X
Minimum wall thickness	4.5	X	X
Minimum bore for unequal-ended fittings	4.6	X	X
Minimum outside diameter of sealing face	4.7	X	X
Flange type fittings	4.8	X	X
	<b>Artikel no. BRL</b>		
Requirements to avoid deterioration of the quality of the drinking water	4.2.1	X	X
<i>Requirements of EN 1254-4 C/1</i>		X	X
<b>Additional product requirements</b>			
Toxicological requirements	4.3.2	X	X
Other materials	4.3.2.3.3	X	X
Nominal diameter	4.3.3	X	X
Execution of the internal solder end	4.3.4	X	X
Width across flats	4.3.5	X	X
Reducers	4.3.6	X	X
Angles	4.3.7	X	X
<b>Marking</b>	6	X	X

- a) In case the product or production process changes significantly, it must be determined whether the performance requirements are still met.
- b) All product characteristics that can be determined within the visiting time (maximum 1 day) are determined by the inspector or by the supplier in the presence of the inspector. In case this is not possible, an agreement will be made between the certification body and the supplier about how the inspection will take place. The frequency of inspection visits is defined in chapter 9.6 of this evaluation guideline.

## **8.2 Inspection of the quality system of the supplier**

The quality system of the supplier will be checked by Kiwa on the basis of the IQC scheme. The inspection contains at least those aspects mentioned in the Kiwa Regulations for Product Certification.



# 9 Agreements on the implementation of certification

## 9.1 General

Beside the requirements included in these evaluation guidelines, the general rules for certification as included in the Kiwa Regulations for Product Certification also apply. These rules are in particular:

- the general rules for conducting the pre-certification tests, in particular:
  - the way suppliers are to be informed about how an application is being handled;
  - how the test are conducted;
  - the decision to be taken as a result of the pre-certification tests.
- the general rules for conducting inspections and the aspects to be audited,
- the measures to be taken by Kiwa in case of Non-Conformities,
- the measures taken by Kiwa in case of improper use of Certificates, Certification Marks, Pictograms and Logos,
- terms for termination of the certificate,
- the possibility to lodge an appeal against decisions of measures taken by Kiwa.

## 9.2 Certification staff

The staff involved in the certification may be sub-divided into:

- Certification assessor (**CAS**): in charge of carrying out the pre-certification tests and assessing the inspectors' reports;
- Site assessor (**SAS**): in charge of carrying out external inspections at the supplier's works;
- Decision maker (**DM**): in charge of taking decisions in connection with the pre-certification tests carried out, continuing the certification in connection with the inspections carried out and taking decisions on the need to take corrective actions.

### 9.2.1 Qualification requirements

The qualification requirements consist of:

- qualification requirements for personnel of a certification body which satisfies the requirements EN ISO / IEC 17065, performing certification activities
  - qualification requirements for personnel of a certification body performing certification activities set by the Board of Experts for the subject matter of this evaluation guideline
- Education and experience of the concerning certification personnel shall be recorded demonstrably.

Basic requirements	Evaluation criteria
Knowledge of company processes Requirements for conducting professional audits on products, processes, services, installations, design and management systems.	<i>Relevant experience: in the field</i> <b>SAS, CAS</b> : 1 year <b>DM</b> : 5 years inclusive 1 year with respect to certification Relevant technical knowledge and experience on the level of: <b>SAS</b> : High school <b>CAS, DM</b> : Bachelor
Competence for execution of site assessments. Adequate communication skills (e.g. reports, presentation skills and interviewing technique).	<b>SAS</b> : Kiwa Audit training or similar and 4 site assessments including 1 autonomic under review.
Execution of initial examination	<b>CAS</b> : 3 initial audits under review.
Conducting review	<b>CAS</b> : conducting 3 reviews

Technical competences	Evaluation Criteria
Education	<b>General:</b> Education in one of the following technical areas: <ul style="list-style-type: none"> <li>• Civil Engineering;</li> <li>• Engineering.</li> </ul>
Testing skills	<b>General:</b> <ul style="list-style-type: none"> <li>• 1 week laboratory training (general and scheme specific) including measuring techniques and performing tests under supervision ;</li> <li>• Conducting tests (per scheme).</li> </ul>
Experience - specific	<b>CAS</b> <ul style="list-style-type: none"> <li>• 3 complete applications (excluding the initial assessment of the production site) under the direction of the <b>PM</b></li> <li>• 1 complete application self-reliant (to be evaluated by <b>PM</b>)</li> <li>• 3 initial assessments of the production site under the direction of the <b>PM</b></li> <li>• 1 initial assessment of the production site self-reliant (witnessed by <b>PM</b>)</li> </ul> <b>SAS</b> <ul style="list-style-type: none"> <li>• 5 inspection visits together with a qualified <b>SAS</b></li> <li>• 3 inspection visits conducted self-reliant (witnessed by <b>PM</b>)</li> </ul>
Skills in performing witnessing	<b>PM</b> Internal training witness testing

Legenda:

- Certification assessor (**CAS**)
- Decision maker (**DM**)
- Product manager (**PM**)
- Site assessor (**SAS**)

### 9.2.2 Qualification

The qualification of the Certification staff shall be demonstrated by means of assessing the education and experience to the above mentioned requirements. In case staff is to be qualified on the basis of deflecting criteria, written records shall be kept.

The authority to qualify staff rests with the:

- **PM**: qualification of **CAS** and **SAS**;
- management of the certification body: qualification of **DM**.

### 9.3 Report initial investigation

The certification body records the results of the pre-certification tests in a report.

This report shall comply with the following requirements:

- completeness: the report provides a verdict about all requirements included in the evaluation guideline;
- traceability: the findings on which the verdicts have been based shall be recorded and traceable;
- basis for decision: the **DM** shall be able to base his decision on the findings included in the report.

#### **9.4 Decision for granting the certificate**

The decision for granting the certificate shall be made by a qualified Decision maker which has not been involved in the pre-certification tests. The decision shall be recorded in a traceable manner.

#### **9.5 Layout of quality declaration**

The product certificate shall be in accordance with the model included in the Annex.

#### **9.6 Nature and frequency of third party audits**

The certification body shall carry out surveillance audits on site at the supplier at regular intervals to check whether the supplier complies with his obligations. The Board of Experts decides on the frequency of audits.

At the time this BRL entered into force, the frequency of audits amounts 2 audit(s) on site per year for suppliers with a quality management system in accordance with ISO 9001 for their production, which has been certified by an acknowledged body (in accordance with ISO/IEC 17021) and where the IQC scheme forms an integral part of the quality management system. In case the supplier is not in possession of any product certificate (issued by Kiwa or any other accredited certification body), the frequency is increased to 3 visits for the duration of one year.

The audit program on site shall cover at least:

- the product requirements;
- the production process;
- the suppliers IQC scheme and the results obtained from inspections carried out by the supplier;
- the correct way of marking certified products;
- compliance with required procedures;
- handling complaints about products delivered.

For suppliers with a private label certificate the frequency of audits amounts to one audit per two years. These audits are conducted at the site of the private label certificate holder. The audits are conducted at the site of private label holder and focussed on the aspects inserted in the IQC scheme and the results of the control performed by the private label holder. The IQC scheme of the private label holder shall refer to at least:

- the correct way of marking certified products;
- compliance with required procedures for receiving and final inspection;
- the storage of products and goods;
- handling complaints.

The results of each audit shall be recorded by Kiwa in a traceable manner in a report.

#### **9.7 Non conformities**

When the certification requirements are not met, measures are taken by Kiwa in accordance with the sanctions policy as written in the Kiwa Regulation for Certification. The Sanctions Policy is available through the "News and Publications" page on the Kiwa website "[Kiwa Regulation for Certification](#)".

#### **9.8 Report to the Board of Experts**

De certification body shall report annually about the performed certification activities. In this report the following aspects are included:

- mutations in number of issued certificates (granted/withdrawn);
- number of executed audits in relation to the required minimum;
- results of the inspections;
- required measures for established Non-Conformities;
- received complaints about certified products.

### **9.9 Interpretation of requirements**

The Board of Experts may record the interpretation of requirements of this evaluation guideline in one separate interpretation document.

### **9.10 Specific rules set by the Board of Experts**

By the Board of Experts the following specific rules have been defined. These rules shall be followed by the certification body.

# 10 Titles of standards

## 10.1 Public law rules

BJZ2011048144  
29 June 2011

Regeling van de Staatssecretaris van Infrastructuur en Milieu<sup>1</sup>

## 10.2 Standards / normative documents

Number	Title	Version*
NEN-EN ISO/IEC 17020	Conformity assessment - General criteria for the operation of various types of bodies performing inspection	
NEN-EN ISO/IEC 17021	Conformity assessment - Requirements for bodies providing audit and certification of management systems	
NEN-EN ISO/IEC 17024	Conformity assessment - General requirements for bodies operating certification of persons	
NEN-EN ISO/IEC 17025	General requirements for the competence of testing and calibration laboratories	
NEN-EN ISO/IEC 17065	Conformity assessment - Requirements for bodies certifying products, processes and services	
EN 1254-1	Copper and copper alloys- Plumbing fittings – Part1: Fittings with ends for capillary soldering or capillary brazing to copper tubes.	February 1998
EN 1254-4	Copper and copper alloys- Plumbing fittings – Part1: Fittings with ends for capillary soldering or capillary brazing to copper tubes.	August 1991
EN 1254-4 +C1	Copper and copper alloys – Plumbing fittings – Part 4: Fittings combining other end connections with capillary or compression ends.	March 1998
EN 248	General specification for electrodeposited	
EN 228	Pipe threads where pressure-tight joints are not made on the threads	
ISO 272	Fasteners; Hexagon products, widths across flats, second edition.	
NEN 1006	General requirements for water supply installations	
NEN 1006/A1	General requirements for water supply installations	
NEN 1006/A3	General requirements for water supply installations	
BRL- K760	Copper pipes.	

\*) When no date of issue has been indicated, the latest version of the document is applicable.

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<sup>1</sup> Valid from 1 July 2017

# I Model certificate (example)



CERTIFICATE

## Product certificate Kxxxxx/xx

Issued            *Date*  
Replaces        *Kxxxxx/xx*  
Page              *1 of 2*

### Plumbing fittings for capillary soldering and/or thread connections to copper tubes

#### STATEMENT BY KIWA

With this product certificate, issued in accordance with the Kiwa Regulations for Certification, Kiwa declares that legitimate confidence exists that the products supplied by

#### Name supplier

as specified in this product certificate and marked with the Kiwa®-mark in the manner as indicated in this product certificate may, on delivery, be relied upon to comply with Kiwa evaluation guideline

BRL-K623 "WC-pans" dated 15.09.2024

which covers the requirements of

EN 1254-1: 1998 "Copper and copper alloys- Plumbing fittings – Part1: Fittings with ends for capillary soldering or capillary brazing to copper tubes."

EN 1254-4: 1998 "Copper and copper alloys- Plumbing fittings – Part1: Fittings with ends for capillary soldering or capillary brazing to copper tubes."

Ronald Karel  
Kiwa

*Publication of this certificate is allowed.*

*Advice: consult [www.kiwa.nl](http://www.kiwa.nl) in order to ensure that this certificate is still valid.*

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Company  
Name supplier  
Address  
Zip code City  
Country  
Telephone number  
email  
internet site

Certification process consists of initial and regular assessment of:

- quality system
- product

## II Model IQC-scheme (example)

Inspection subjects	Inspection aspects	Inspection method	Inspection frequency	Inspection registration
Raw materials or materials supplied: - recipe sheets - incoming goods inspection raw materials	<ul style="list-style-type: none"> <li>•material</li> <li>•dimensions</li> <li>•supplier</li> </ul>			
Production process, production equipment, plant: - procedures - working instructions - equipment - release of product	<ul style="list-style-type: none"> <li>•temperature</li> <li>• material composition</li> <li>•appearance</li> <li>•non filled parts</li> <li>•weld lines</li> <li>•dimensions</li> <li>temperature</li> </ul>			
Finished-products	finishing correctness carbon			
Measuring and testing equipment - measuring equipment - calibration	Certificates Issue Control and registrations			
Logistics - internal transport - storage - preservation - packaging - identification or marking of semifinished and finished products	Damage package Height of storage traceability			

