

## Covenant K110051/01

Issued 2023-04-01

Replaces -

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### Circular Entrepreneurship

#### STATEMENT BY KIWA

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

### DECEUNINCK N.V.

namely,

- Recovery of rest pieces resulting from the manufacture of plastic window frames;
- Recovery of plastic window frames from renovation projects;
- Recycling of the recovered material and reusing it in similar products;
- Supplying products that have a functional lifespan of 50 years or more.

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 Covenant manual K15013.

Ron Scheepers  
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.*

COVENANT

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## **Preface**

This Kiwa Covenant has been prepared by the Technical Committee for recycled plastic window profiles of Kiwa Nederland B.V. and accepted by the Kiwa Committee of Covenant (KCC). The KCC also supervises the certification activities and where necessary requires the Kiwa Covenant to be revised.

This Kiwa Covenant will be used by Kiwa in conjunction with the Kiwa-Regulations for Certification. This regulation details the method employed by Kiwa for conducting the necessary investigations prior to issuing the product certificate and the method of external control. The inspection frequency is determined by the above mentioned Technical Committee and Kiwa Committee of Covenant.

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## 1 Scope of the Covenant

### 1.1 Definition of the product

This Covenant concerns the circular entrepreneurship for the sustainable production of window frame profiles made from PVC. The products are specified in 3.1.

The products are intended to be used as window frames in buildings. After the end of life or as waste from assemblers the products are recoverable through plastic recycling facilities.

### 1.2 Objective and declaration

This covenant covers the evaluation and surveillance of an approved fabrication process producing window profiles that are partly made of recycled material. Products and materials are utilized in accordance with Circular Entrepreneurship concept explained in Chapter 2 and requirements stated in Chapter 3.

Deceuninck has developed a Concept Circular Entrepreneurship with the aim to achieve a high degree of sustainable production by continuous improvement. An important part of the concept is the recovery of rest waste material from the assembling of the profiles and from renovation projects and the reprocessing of the waste material into the Deceuninck's own recycling plant resulting in a circular product, leading in general to:

- Recycling of the material and reuse in equal products that is recovered within the Concept Circular Entrepreneurship as mentioned above;
- Minimize the waste stream in the production chain of window frames by recovery of rest material (offcuts and sawdust) during assembling of the profiles ;
- Delivery of a product that fulfils the requirements of BRL 0702;
- Applying controlled and sustainable business operations;
- Purchasing plastic window profiles (partly or completely) made from recycled plastic via Deceuninck.

### 1.3 Assumed working life of the product

The window frames made from the profiles have a functional lifespan of minimum 50 years.

### 1.4 Common terms relating to the product

The definitions below are in accordance with NEN-EN-ISO14021 and Directive 2008/98/EC:

Master batch: Polyvinylchloride(PVC-U):	Additives including colours to enhance the properties of plastics. A rigid type of PVC where no plasticizers are used in the production.
Waste:	Waste means any substance or object which the holder discards or intends or is required to discard.
Recycling:	Any recovery operation by which waste materials are reprocessed into products, materials or substances whether for the original or other purposes. It includes the reprocessing of organic material but does not include energy recovery and the reprocessing into materials that are to be used as fuels or for backfilling operations.
Recycled material:	Material that has been reprocessed from recovered (reclaimed) material by means of a manufacturing process and made into a final product or into a component for incorporation into a product.
Pre-consumer:	Material diverted from the waste stream during a manufacturing process. Excluded is reutilization of materials such as rework, regrind or scrap generated in a process and capable of being reclaimed within the same process that generated it.
Recyclate:	This is a raw material that is sent to, and processed in a waste recycling plant or materials recovery facility which will be used to form new products.
Recovered (re- claimed) material:	Material that would have otherwise been disposed of as waste or used for energy recovery, but has instead been collected and recovered (reclaimed) as a material input, in lieu of new primary material, for a recycling or a manufacturing process.
Regrind:	Shredded and cleaned material recovered from a waste stream as pre and post-consumer material.

## 2 Circular Entrepreneurship Concept

### 2.1 Flowchart

The Concept Circular Entrepreneurship is reflected in the procedures and processes drawn up as a result:

- With customers of Deceuninck;
- With recyclers of collected (PVC) materials;
- With the aim to reuse (recycled) materials.

The Concept Circular Entrepreneurship is assessed on the basis of documented processes and the flow chart seen in Figure 1 that waste materials are recycled and applied as described in this Covenant. The plants indicated with a blue block in the flow chart are part of this Covenant. The green striped steps (window frame assemblers) are bound by a contract to Deceuninck to ensure the closure of the chain.

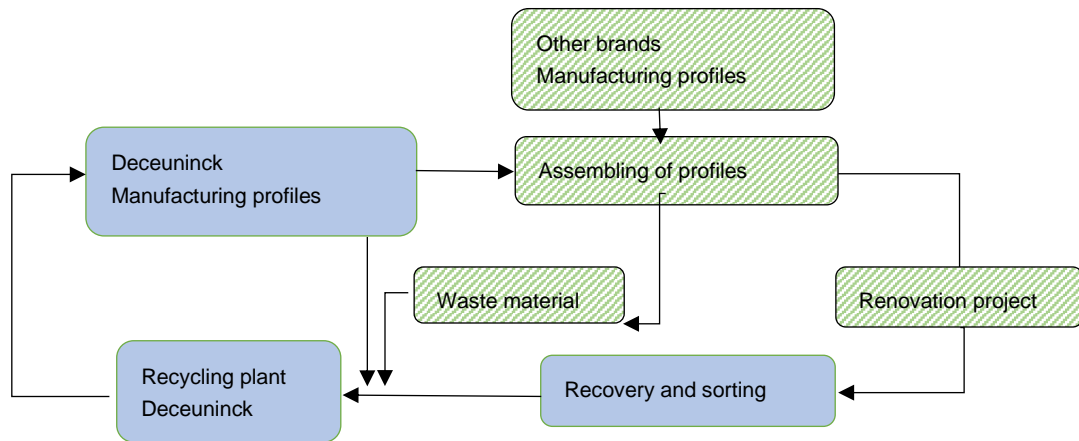


Figure 1 Flowchart Concept Circular Entrepreneurship

### 2.2 Circularity aspect

When assemblers supply window frames to renovation projects, they must ensure that old plastic window frames from all types of brands released during demolition are collected and returned to Deceuninck. This also applies to off cuts and other waste to be returned from the assembly step in the window manufacturers. See Figure 2 for illustration of Deceuninck Circular.

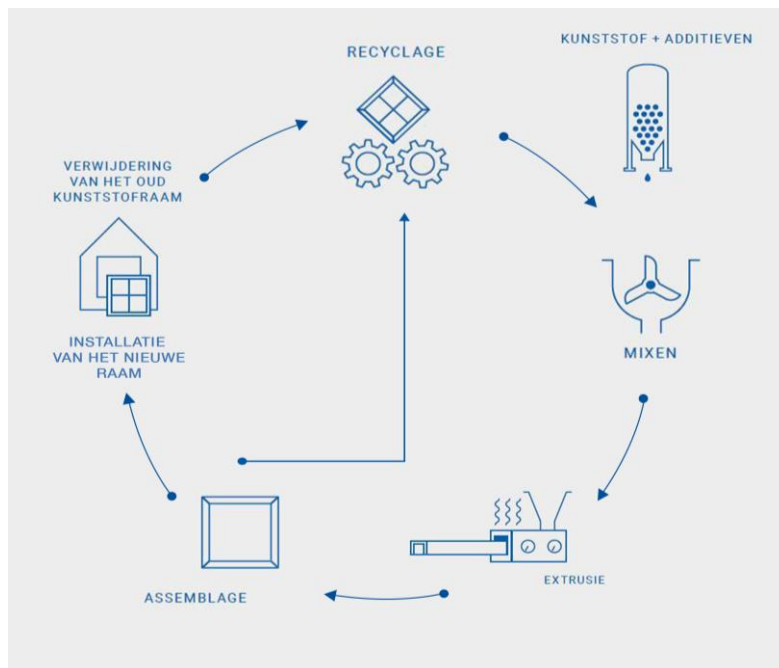


Figure 2 Deceuninck Circular

### 3 Relevant characteristics of the product, the required verification and the assessments of fitness for use

#### 3.1 Used materials

The window profiles are made of the following materials summarized in Table 1. The used PVC and additives shall be purchased on the basis of a specification; the types and quantities shall be checked on arrival.

Table 1 List of used materials in the product

Material	origin
Polyvinylchloride (PVC-U)	Granulate (of recycled material)
	Virgin material
color additive product / label	Master batch

#### 3.2 Characteristics of the Product – fitness for use

The products belonging to this covenant meet the following requirements summarized in Table 1.

Table 2 Product requirements - fitness for use

Product	Certificate	Guideline
Deceuninck iCOR Elegant profiles of PVC-U colored in mass	K104170	BRL 0702
Deceuninck iCOR Elegant profiles of PVC-U provided with a coating	K104171	BRL 0702
Deceuninck iCOR Elegant profiles of PVC-U provided with a foil	K104172	BRL 0702

The verification shall be done by the presence of a relevant certificate on the certifier's website confirming that the product meets the applicable requirements as described in the mentioned Guideline.

#### 3.3 Application of the Circular Entrepreneurship Concept

From each of the parties as described in chapter 2, below shall be realized:

- Availability of documents showing transport of recyclate between the parties:
  - production failure and waste of operations is returned by customers of Deceuninck and window manufacturers using other brands;
  - reclaimed materials are recycled into granules suitable for reapplying by Deceuninck.
  - materials from renovation projects are returned by customers of Deceuninck and others;
  - material recovery and processing is such that no material is lost except for normal production losses that are not recoverable.

The verification shall be done by the control of material flow and the source during the surveillance audits.

#### 3.4 Post Consumer Material and related legislation

When Post Consumer material (of end of life products) is reprocessed with the aim to be used as recycle material in products the valid guidelines, regulations and or legislation about the possible hazardous additives shall be followed, such as Reach or EU rules. For example the existence of lead and cadmium in used end of life PVC products.

#### 3.5 Marking

After concluding a Kiwa certification agreement, the certified product, material or process can be indelible presented with the Kiwa Covenant logo as shown below Figure 3. The product shall be provided with the following marks:

- Logo picture Kiwa Covenant;
- Manufacture's name, trade name;
- Material identification;
- Production code.



Figure 3 Kiwa covenant logo (left in in NL and right in EN)

## **4 Quality system requirements**

### **4.1 General**

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

### **4.2 Manager of the quality system**

Within the organizational structure an employee must be appointed to be responsible of managing the quality system.

### **4.3 Internal quality control/quality plan**

The supplier must have an implemented and operational internal quality control scheme in place (IQC-scheme).

In this IQC-scheme the following must be demonstrably recorded:

- materials used in the product;
- which aspects are checked by the manufacturer;
- according to which methods these inspections are carried out;
- how often these inspections are carried out;
- how the inspection results are registered and stored.

This IQC-scheme shall be derived from the example format as shown in the annex. The scheme must be detailed in such a way that it provides Kiwa sufficient confidence that the requirements of this Covenant are continuously fulfilled.

### **4.4 Management of laboratory- and measure apparatus**

The supplier must determine which laboratory- and measure apparatus are needed based on this Covenant in order to demonstrate that the product fulfils the requirements.

When applicable laboratory- and measure apparatus need to be calibrated at specified intervals.

The supplier needs to validate and register the previous measure results, when at the time of calibration is determined that the laboratory and measure devices are not operating correctly.

The apparatus in question need to be marked in such a way that can be determined what the calibration status is.

The supplier is required to register the calibration results.

### **4.5 Procedures and work instructions**

The supplier must be able to submit procedures for:

- storage of used materials and readied product;
- the handling of non-conforming products;
- corrective actions in case non-conformities are found;
- the handling of complaints regarding the products and/or services supplied;
- managing work instructions and inspection sheets in use.

### **4.6 Other quality system requirements**

The supplier must be able to submit:

- an organization chart;
- qualification requirements of the involved staff.

## 5 Initial inspection and continuous surveillance by Kiwa

### 5.1 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 type tests;
- Inspections;
- Control of the supplier's the quality system.

### 5.2 Test matrix (circular entrepreneurship)

Table 3 Test matrix, showing initial investigation and surveillance inspections

Description of requirements	Clause BRL	Tests within the scope of:	
		Initial investigation	Inspections <sup>1) + 2)</sup>
<b>General</b>			
Maintenance of equivalent application	1.2	X	X
Use of materials	3.1	X	X
Meet to BRL 0702	3.2	X	X
Verification of documents and contracts that guarantee the Concept of Circular Entrepreneurship	3.3	X	X
Legislation	3.4	X	X
Marking	3.5	X	X
IQC schedule	4.3	X	X

- 1) In case the product or production process changes significantly, the performance requirements shall be determined again.
- 2) During the inspection visit, the inspector shall check the product on the basis of a selection of the above listed requirements. The frequency of the inspection visits is recorded in clause 6.3 'Nature and frequency of external inspections'.

### 5.3 Inspection of the quality system

The quality system 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 Certification.

## **6 Agreement on the implementation of certification**

### **6.1 General**

Beside the requirements included in this Covenants, also the general rules for certification as included in the Kiwa Regulations for Certification apply.

In particular, these are:

- The general rules for conducting the initial type tests, to be distinguished in:
  - the way suppliers are to be informed about 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 directions for conducting inspections and the aspects to be audited;
- The measurements to be taken by Kiwa in case of Non Conformities;
- Measurements 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 measurements taken by Kiwa.

### **6.2 Report initial investigation**

Kiwa records the results of the initial investigation in a report. This report shall comply with the following requirements:

- completeness: the reports verdicts about all requirements included in the Covenant;
- traceability: the findings on which the verdicts have been based shall be recorded traceable;
- basis for decision: the decision maker shall be able to base his decision on the findings included in the report.

### **6.3 Nature and frequency of external inspections**

Kiwa shall enforce inspections at the supplier's site to investigate whether the obligations are met. At the time of validation of this Covenant this frequency has been fixed at 1 inspection visits per year for the manufacturer of the window profiles and 1 for the recyclers processing the material. In some cases a desk audit is possible to be decided by Kiwa.

Inspections shall invariably include:

- The IQC-scheme of the supplier and the results of tests carried out by the supplier;
- The correct marking of the certified products;
- The compliance with the required procedures.

The findings of the inspection visits performed shall be traceably recorded, by the certification body, in a report.

### **6.4 Sanction policy**

The sanction policy and the weighing of the non-conformities is available through the service page on the website of Kiwa.

## 7 Recommendations for customers

Check at the time of delivery whether:

- the supplier has delivered in accordance with the agreement;
- the mark and the marking method are correct;
- the products show no visible defects as a result of transport etc.

If you should reject a product on the basis of the above, please contact:

Deceuninck N.V.,  
and, if necessary,  
Kiwa Nederland B.V.

Consult the suppliers processing guidelines for the proper storage and transport methods.

## 8 Standards normative documents

<b>Standard <sup>1)</sup></b>	<b>Title</b>	<b>Year</b>
EN-ISO 9001	Quality management systems - Requirements	2015
NEN-EN ISO/IEC 17020	Conformity assessment - General criteria for the operation of various types of bodies performing inspection	2012
NEN-EN ISO/IEC 17065	Conformity assessment - Requirements for bodies certifying products, processes and services	2012
NEN-EN-ISO14021	Environmental labels and declarations — Self-declared environmental claims (Type II environmental labelling)	2016
Kiwa K15013	Kiwa Covenant for products and processes	2018
Directive 2008/98/EC	Waste Framework Directive	2008
BRL 0702	Unplasticized PVC profiles for façade elements, window frames, windows and doors	2007

- 1) The documents, in whole or in part, are normatively referenced in this document. For dated references, only the edition cited applies. For undated references, the latest edition of the reference document (including any amendments) applies.

## Annex Model IQC Scheme

Inspection subjects	Inspection aspects	Inspection method	Inspection frequency	Inspection registration
Raw materials or materials supplied: - recipe sheets  - incoming goods inspection raw materials				
Production process, production equipment, plant: - procedures - working instructions - equipment - release of product				
Finished-products				
Measuring and testing equipment - measuring equipment  - calibration				
Logistics - internal transport - storage - Preservation  - packaging - identification				