

**BRL-K640**  
2019-10-02

# Evaluation Guideline

for the Kiwa product certificate for  
Fittings to be tightened with matching  
compression tool, compression- and push fit  
fittings as part of appliances and installations



**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 Fittings to be tightened with matching compression tool, compression-and push fit fittings as part of appliances and installations 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

# Contents

<b>1</b>	<b>Introduction</b>	<b>4</b>
1.1	General	4
1.2	Field of application / scope	4
1.3	Acceptance of test reports provided by the supplier	4
1.4	Quality declaration	4
<b>2</b>	<b>Terms and definitions</b>	<b>5</b>
2.1	Definitions	5
<b>3</b>	<b>Procedure for granting a product certificate</b>	<b>7</b>
3.1	Initial investigation	7
3.2	Granting the product certificate	7
3.3	Investigation into the product and/or performance requirements	7
3.4	Production process assessment	7
3.5	Contract assessment	7
<b>4</b>	<b>Requirements</b>	<b>8</b>
4.1	General	8
4.2	Regulatory requirements	8
4.3	Product requirements	8
4.4	Plastic fittings	8
4.5	Metal fittings	8
<b>5</b>	<b>Test methods</b>	<b>10</b>
5.1	Determination of durability	10
<b>6</b>	<b>Marking</b>	<b>11</b>
6.1	General	11
6.2	Certification mark	11
<b>7</b>	<b>Requirements in respect of the quality system</b>	<b>12</b>
7.1	Manager of the quality system	12
7.2	Internal quality control/quality plan	12
7.3	Control of test and measuring equipment	12
7.4	Procedures and working instructions	12
7.5	Other requirements	12
<b>8</b>	<b>Summary of tests and inspections</b>	<b>13</b>
8.1	Test matrix	13
8.2	Inspection of the quality system of the supplier	13

<b>9</b>	<b>Agreements on the implementation of certification</b>	<b>14</b>
9.1	General	14
9.2	Certification staff	14
9.3	Report initial investigation	15
9.4	Decision for granting the certificate	16
9.5	Layout of quality declaration	16
9.6	Nature and frequency of third party audits	16
9.7	Non conformities	16
9.8	Report to the Board of Experts	16
9.9	Interpretation of requirements	17
9.10	Specific rules set by the Board of Experts	17
<b>10</b>	<b>Titles of standards</b>	<b>18</b>
10.1	Public law rules	18
10.2	Standards / normative documents	18
10.3	Bibliography	<b>Fout! Bladwijzer niet gedefinieerd.</b>
<b>I</b>	<b>Model certificate (informative)</b>	<b>19</b>
<b>II</b>	<b>Model IQC-scheme (informative)</b>	<b>20</b>

# 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 Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of appliances and installations.

This guideline replaces the evaluation guideline BRL-K640/04, dated 01-02-2012.  
The quality declarations issued and based on that guideline will not lose their validity.

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

Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of an appliance or installation are to be applied in tap water installations with a maximum working pressure of 1000 kPa and a maximum water temperature of 90°C. These installations are either plastic or metallic

## 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.
- **Tap water (origin Drinking water directive NEN 1006):** water intended for drinking, cooking, food preparation or other domestic purposes.

Remark(s)

- Tap-water can be drinking water, hot tap-water or domestic water
- The definition of tap-water differs from the definition mentioned in the Dutch water installation law (= Waterleidingwet). Because besides making tap-water available and offering to third parties either by a drinking water producer or through a collective water supply system, also water in individual domestic water installations is defined as tap-water in EN 1006.
- **Working pressure ( $p_w$ ):** highest occurring effective pressure under normal circumstances within the tap-water installation as a whole or in specific parts.
- **Effective pressure ( $p_e$ ):** The difference between the nominal pressure ( $p$ ) and the ambient pressure ( $p_{amb}$ ). As formula:  $p_e = p - p_{amb}$ .

## 3 Procedure for granting a product certificate

### 3.1 Initial investigation

The pre-certification tests 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 fittings to be tightened with matching compression tool, compression- and push fit fittings as part of a appliance or installation 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.

## 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 4.4 and 4.5.

## 4.4 Plastic fittings

### 4.4.1 *Fittings to be used to connect plastic pipes*

The functional requirements and examination procedures for plastic fittings to be used in plastic piping systems is laid down in Kiwa guidelines BRL-K 534 and BRL-K536.

## 4.5 Metal fittings

### 4.5.1 *Fittings to be used to connect copper pipes*

The functional requirements and examination procedures for fittings to be used to connect copper pipes are laid down in Kiwa guideline BRL-K639.

### 4.5.2 *Fittings to be used to connect plastic pipes*

The functional requirements and examination procedures for plastic fittings to be used in plastic piping systems is laid down in Kiwa guidelines BRL-K 534 and BRL-K536.

### 4.5.3 *Fittings to be tightened with matching compression tool*

The functional requirements and examination procedures for plastic fittings to be used in plastic piping systems is laid down in Kiwa guidelines BRL-K 774.

<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.

#### **4.5.4 Other fittings to be used to connect copper pipes**

Any other type of fitting different from the types mentioned above shall meet the material- and functional requirements as mentioned in Kiwa guideline BRL-K639, with exception of the following requirements:

- Air tightness,
- Resistance against torsion,
- Strength,
- Durability.

Fittings which are re-mountable<sup>1</sup> according to the suppliers specifications shall be examined according durability requirements. This will be tested according to 5.1. After the durability examination the fittings shall meet the requirements concerning tightness of the connection.

#### **4.5.5 Additional requirements**

##### **4.5.5.1 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'

##### **4.5.5.2 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.

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<sup>1</sup> In the instruction manual of the supplier the obligatory use of new parts and/or pipes in case of remounting is allowed. This kind of fittings is also categorized as re-mountable.

# 5 Test methods

## 5.1 Determination of durability

### 5.1.1 *Test installation*

For the determination of the durability, the test pieces shall be installed in a test installation, in which the torque needed to fasten the nuts can be measured and in which the tightness at ambient temperature can be measured.

### 5.1.2 *Test samples*

For the test three samples are needed which were already tested on tightness.

### 5.1.3 *Procedure*

- a. mount the fittings according the instructions of the manufacturer/supplier.
- b. dismount the connection, according the instructions of the manufacturer/supplier.
- c. mount the fitting once again with if applicable new parts and/or pipe according the instructions of the manufacturer/supplier.
- d. repeat point b. and c. 25 times.
- e. determine the water tightness.

## 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.

It is recommended to mark the product with the connecting size(s) of the connecting end(s).

•


or:

For indications and markings see product standard <.....>

### 6.2 Certification mark

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

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

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

The mentioned marking requirements are not applicable for fittings which are integrated in devices.

# 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 no. of BRL	Tests within the scope of:	
		Pre-certification	Inspection by Kiwa after granting of certificate a,b)
<b>Product requirements</b>			
Requirements to avoid deterioration of the quality of the drinking water	4.2.1	X	X
<b>Functional requirements</b>			
Plastic fittings	4.4	X	X
Metal fittings	4.5	X	X
<b>Certification mark</b>			
General	6.1	X	X
Certification mark	6.2	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 2 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

The 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
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
NEN-EN 45011	General requirements for the competence of testing and calibration laboratories
BRL- K534	Fittings for polyethylene pipes to transport drinking water
BRL- K536	Fittings for polyethylene pipes to transport drinking water Plastic piping systems for drinking water
BRL- K639	Compression fittings for use with copper pipes
BRL- K774	Compression fittings for use with copper pipes Fittings to be tightened with matching compression tool

### Note

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 (informative)



## Product certificate Kxxxxx/xx

Issued                      Date  
Replaces                  Kxxxxx/xx  
Page                        1 of 2

CERTIFICATE

### Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of appliances and installations

#### 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-K640 "Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of appliances and installations " dated 15.09.2024

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 (informative)

Inspection subjects	Inspection aspects	Inspection method	Inspection frequency	Inspection registration
Raw materials or materials supplied: - incoming goods inspection raw materials - Semi finished parts	material dimensions  material dimensions appearance supplier			
Production process, production equipment, plant: - procedures - working instructions - equipment - release of product - Machining - assembly	material composition temperature appearance holes and cavities in cast  capillary hole shape screw thread correct parts and lubricated correctly			
Finished-products  - Marking	finish (smooth) correctness (version and place) Koolstof			
Measuring and testing equipment - measuring equipment - calibration	certificates (internal/external) validity inspection registration			
Logistics	damages packaging stack height traceability			

