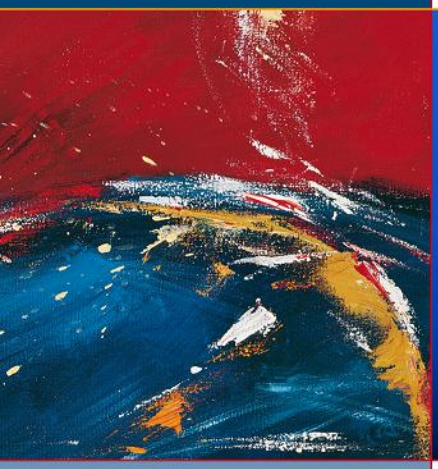
BRL-K640/04
01-02-2012

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



Preface

This evaluation guideline has been accepted by the board of experts CWK of Kiwa, in which the parties concerned in the sector Drinkingwater appliances are being represented. This 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. 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.

This evaluation guideline is to be assessed by the Board of Experts at least every 5 years, but at the latests before 1st of February 2017.

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Validation
This evaluation guideline has been validated by Kiwa on 1st of February 2012.

Contents

Contents

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 fittings with compression ends for use with copper tubes.

This evaluation guideline replaces BRL –K640/04 dated 15th of August 2003.

For the performance of its certification work, Kiwa is bound to the requirements as included in the clause 4.6 “conditions and procedures for granting, maintaining, extending, suspending and withdrawing certification” of EN45011.

1.2 Field of application / scope

Fittings to be tightened with matching compression tool, compression- and push fit fittngs 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

When by the manufacturer reports from test Institutions or laboratories are produced in order to demonstrate that the product meets the requirements of this evaluation guideline, the institute or laboratory shall meet one of the applicable accreditation norms, being;

- NEN-EN-ISO/IEC 17025 for laboratories;
- NEN-EN–ISO/IEC 17020 for inspection bodies;
- NEN-EN 45011 for certification bodies certifying products;

This requirement is being considered to be fulfilled when a certificate of accreditation can be shown, either issued by the Board of Accreditation (RvA) or one of the institutions with which the RvA an agreement of mutual acceptance has been concluded.
The accreditation shall refer to the examination as required in this BRL. When no certificate of accreditation can be shown, Kiwa will verify whether the accreditation norm is fulfilled or conduct the determined examination once more themselves or subcontract it to a third party.

1.4 Quality declaration

The quality declarations to be issued based on this Kiwa guideline are described as Kiwa product certificates.
A model of this quality declaration has been included as an Annex in this BRL.

2 Terms and definitions

In this evaluation guideline the following terms and definitions are applicable:

Evaluation Guideline: the agreements made within the Board of Experts on the subject of certification.

Board of Experts: The Board of Experts ”CWK”.

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

IQC scheme: a description of the quality inspections carried out by the supplier as part of his quality system.

Product requirements: requirements made specific by means of measures or figures, focusing on (identifiable) characteristics of products and containing a limiting value to be achieved, which limiting value can be calculated or measured in an unequivocal manner.

Pre-certification tests: tests in order to ascertain that all the requirements recorded in the Evaluation Guideline are met.

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.

> **Remark(s)**
> The test matrix contains a summary showing what tests Kiwa will carry out in the pre-certification stage and in the event of inspections as well as showing the frequency with which the inspection tests will be carried out.

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.

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 occuring 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 obtaining the quality declaration

3.1 Pre certification tests

The pre certification-tests to be performed are based on the (product) requirements as included in this evaluation guideline including the test methods and depending on the nature of the product to be certified, contain the following:

- Type testing to determine whether the products comply with the product- and/or functional requirements;
- Assessment of the Production Process;
- Assessment of the quality system and the IQC-scheme,
- Examination on the availability and functioning of the remaining procedures.

3.2 Granting the quality declaration

After finishing the pre-certification tests the results are presented to the person deciding on granting of certificate. This person evaluates the results and decides whether the certificate can be granted or additional data and/or tests are necessary.

4 Requirements and test methods

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. These requirements are part of the technical specification of the products, as stated in the certificate.

4.2 Materials

4.2.1 Requirements to avoid deterioration of the quality of the 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 the toxicological, microbiological and organoleptic requirements as laid down in the valid "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 valid Regulation, has to be concluded with positive results.

Products and materials with a quality declaration∗, 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 Plastic fittings

4.3.1 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.

4.3.2 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.

4.4 Metal fittings

4.4.1 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.

4.4.2 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.

4.4.3 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.

∗ A quality declaration issued by an independent certification institute in another member state of the European Community than the Netherlands 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.

4.4.4 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[1] according to the suppliers specifications shall be examined according durability requirements. This will be tested according to 6.2. After the durability examination the fittings shall meet the requirements concerning tightness of the connection.

[1] 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 Marking

5.1 General

The following markings shall be indelibly and permanently on the products:

- Manufacturer's name and/or logo/trading name;
- Production date or code;
- Type.

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

5.2 Certification mark

After concluding a Kiwa certification agreement the products shall be marked, in addition to the marking requirements mentioned in EN 1254-2, article 7, shall be indelibly marked with the certification mark **KIWA** .

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

6 Test methods

6.1 General

6.2 Determination of durability

6.2.1 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.

6.2.2 Test samples

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

6.2.3 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.

7 Quality system requirements

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 must have been appointed who is in charge of managing the supplier's quality system.

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 have been demonstrably recorded in this IQC scheme:

- what aspects are checked by the producer;
- 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 included in the addendum.

7.3 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.

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:

- Pre-certification tests;
- Inspection test as to toxicological requirements and product requirements;
- Inspection of the quality system.

The frequency with which Kiwa will carry out inspection tests is also stated in the summary.

8.1 Test matrix

Description of requirement	Article BRL	Tests within the scope of		
		Pre-certification	Supervision by Kiwa after granting of certificate[1)]	
			inspection[2)]	frequency (no./year)
Product requirements				
Toxicological requirements	4.2	X	X	2
Functional requirements				
Plastic fittings	4.3	X	X	1
Metal fittings	4.4	X	X	1
Certification mark				
General	5.1	X	X	2
Certification mark	5.2	X	X	2

[1)] In case of significant changes of the product or production process, compliance of the product to the performance requirements shall be determined

[2)] Inspections as indicated are to be conducted by the inspector or by the manufacturer, whether or not in presence of the inspector.

8.2 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 Product certification.

9 Agreements on the implementation of certification

9.1 General

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

These rules are in particular

- The general rules for conducting the pre-certification 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.

9.2 Certification staff

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

- certification experts: they are in charge of carrying out the pre-certification tests and assessing the inspectors' reports;
- inspectors: they are in charge of carrying out external inspections at the supplier's works;
- decision-makers: they are 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 following qualification requirements have been set by the Board of Experts for the subject matter of this Evaluation Guideline:

EN45011	Certification Expert	Inspector	Decision maker
Education - general	• Technical higher-level professional education • Internal training certification and Kiwa policy • Training auditing	• Intermediate-level professional education • Internal training certification and Kiwa policy • Training auditing	• Higher level professional education • Internal training certification and Kiwa policy • Training auditing
Education - specific	• for BRL relevant technical education • specific studies and training (know-how and skills)	• for BRL relevant technical education • specific studies and training (know-how and skills)	• not applicable unless specific requirements have been specified by the BoE
Experience - general	• 1 year of relevant work experience with at least 4 pre certification tests of which one carried out independent under supervision.	• 1 year of relevant work experience with at least 4 inspections of which one carried out independent under supervision	• 4 year of relevant work experience with at least 1 year in certification

EN45011	Certification Expert	Inspector	Decision maker
Experience - specific	• Detailed knowledge of the BRL and 4 certification tests carried out on the basis of the BRL or one related.	• Detailed knowledge of the BRL and 4 inspections carried out on the basis of the BRL or one related.	• general knowledge of the BRL

The level of education and the experience of the certification staff involved should be demonstrably recorded.

9.2.2 Qualification

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

The authority to qualify staff is dedicated to:

- decision makers: qualification of certification experts and inspectors,
- Management of Kiwa: qualification of decision makers.

9.3 Report Pre certification tests

Kiwa records the results of the pre certification tests in a report. This report shall comply with the following requirements:

- completeness: the reports verdicts about all requirements included in the evaluation guideline,
- 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.

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 traceable.

9.5 Lay out of quality declaration

The product certificate shall be conform the model included as an annex

9.6 Nature and frequency of external inspections

The certification body shall carry out Audits at the supplier at regular intervals to check whether the supplier complies with his obligations. About the frequency of inspections the Board of Experts decides. At the time this Evaluation Guideline took effect, the frequency was set at number of 2 inspection visits per year.

Inspections shall at least refer to:

- The suppliers IQC-scheme and the results obtained from inspections carried out by the supplier,
- The correct way of marking of certified products
- Complying with required procedures.

The results of each inspection shall be traceable recorded in a report.

9.7 Interpretation of requirements

The Board of Experts may record the interpretation of requirements of these evaluation guidelines in one separate interpretation document.

10 Bibliography

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

I Model certificate

Certificate

Product certificate
KXXXXXX/0X

kiwa
Partner for progress

Issued

Replaces

Page 1 of 2

Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of appliance and/or installation

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

Name supplier

complying with the technical specifications as laid down in this product certificate and marked with the Kiwa®-mark in the manner as indicated in this product certificate, on delivery, may be relied upon to comply with Kiwa evaluation guideline BRL-K640/04 "Fittings to be tightened with matching compression tool, compression- and push fit fittings as part of appliance and/or installation", dated 20xx-xx-xx.

Bouke Meekma
Kiwa

Publication of the certificate is allowed.
Advice: consult www.kiwa.nl in order to ensure that this certificate is still valid.

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Certification process consists of initial and regular inspection of:
- **quality system**
- **product**

II Model IQC-scheme

Subjects	Aspects	Method	Frequency	Registration
Raw materials or materials supplied: • Incoming inspection raw materials • Semi finished parts	material dimensions material dimensions appearance supplier			
Production process, production equipment, material: • procedures • work 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)			
Measuring and testing equipment • measuring equipment • calibration	certificates (internal/external) validity inspection registration			
Logistics	damages packaging stack height traceability			