

Certification scheme for industrial doors and gates as per EN 13241:2003 + A2:2016



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1 Basis

1.1 Purpose and scope

This certification scheme defines the procedures and requirements for the marking of industrial doors and gates according to EN 13241:2003 + A2:2016 with the "ift-certified" mark. Introduction and application of the specified provisions and tests ensure the sustainability of the characteristics of the industrial doors and gates demonstrated during initial type testing.

The basics are based on the requirements of the industrial door/gate installed ready for operation. A gate can optionally be equipped with transparent or non-transparent infillings, pass doors and other additional parts.

1.2 Basis of testing and certification

This certification scheme lays down the requirements for certification and surveillance of industrial doors and gates covered by EN 13241:2003 + A2:2016. For certification and surveillance of industrial doors and gates, ift-Cert must be provided with the following evidence:

Test reports according to EN 13241:2003 + A2:2016,

Product documentation for the intended purpose and/or use (e.g. variants, weights, sizes, frame material) of industrial doors and gates,

Documentation of the mandatory factory production control,

Contract with ift-Cert on certification and surveillance of production of the products governed by EN 13241:2003 + A2:2016,

Consideration of the requirements to be fulfilled by bodies certifying products, processes and services in accordance with EN ISO/IEC 17065.

1.3 Terms and definitions

1.3.1 Owner of test report

Entity which commissions a testing body with identifying or testing specific or more than one product characteristic of a product/component and receives from the testing body evidence of performance/a report of the results obtained.

1.3.2 ift-Product Passport

A summary report issued by ift Rosenheim, which determines the performance characteristics of the industrial doors and gates specified by the manufacturer and confirms them by testing, calculation or evaluation according to EN 13241:2003 + A2:2016. This can be used as a basis for the manufacturer's own type test (TT) as part of the CE marking.

1.3.3 Production site

Organisation which manufactures/further processes products/components/building materials.

1.3.4 Sales organisation

Organisation that purchases finished products and distributes them without further processing, i.e. without changing the product characteristics.

1.3.5 Certificate holder

Organisation that commissions a certification body with the certification of a product (component, service, management system).

1.3.6 Monitored site

Organisation that has to prove the factory production control and is regularly externally monitored. If the certificate holder and the monitored site are different and are legally independent organisations, this is taken into account separately in the contract.

2 Procedure and contents of certification

The general procedure and the contents of the measures required for initial certification and renewal of certification are documented by ift-Cert in the applicable "General requirements for certification, surveillance and inspection of products and services". The specifications defined in the following refer only to industrial doors and gates.

2.1 Certification procedure

- Conclusion of a certification and surveillance contract,
- Definition of the scope of product certification/certificate,
- Evaluation of test evidence/reports and product documentation,
- Initial type test/s, as necessary,
- Compilation of ift Product Passport,
- Positive initial inspection,
- Certification.

3 Initial test

3.1 Test evidence / reports

As part of the initial inspection for a product or product family, all the evidence required by EN 13241:2003 + A2:2016 shall be submitted to a notified body for industrial doors and gates.

For the evaluation of the documents, the certification body may consult further evidence from a testing body accredited according to EN ISO/IEC 17025 and recognised by ift-Cert.

The compilation of the performance characteristics to be certified takes place within the scope of the documentation review by creating an ift Product Passport, which is the basis for certification and continuous monitoring.

3.2 Minimum requirements

The following table contains the minimum requirements of performance characteristics for industrial doors and gates according to EN 13241:2003 + A2:2016, which must be verified accordingly.

Table 1 Minimum requirement

Characteristic	Class / value
Resistance to wind load	2 **)
Safe opening	passed
Operating forces	passed

**) Class 2 or class 0 according to the classification standard depending on the application and design

4 Initial audit

The objective of the initial inspection is to check the personnel and manufacturing conditions for manufacturing industrial doors and gates according to EN 13241:2003 + A2:2016 on the basis of this certification scheme. It serves in particular to determine whether the conditions are met which must be observed during the manufacture of the industrial doors and gates in order to ensure conformity with the tested type.

The initial inspection includes:

- Submission, inspection and evaluation of the required evidence for the declared performance characteristics,

- Review of the personnel and equipment requirements (designation of an independent quality inspector),

- Introduction to factory production control,

- Checking the calibration of the test facilities,

- Review the procedure for handling customer complaints,

- Review the procedure for training and qualifying staff, maintaining quality and performing audit activities.

5 Product certificate

5.1 Validity of the certificate

The product certificate is issued regularly for a period of 3 years. The product certificate may only be used as long as the validity and actuality of the basic documents or the ift product passport is ensured.

Within the recertification, the certificate is extended accordingly if the evaluation of the certification requirements is positive.

The procedure for modifying or extending the certified scope as well as the suspension and revocation of certification is specified by ift Rosenheim in the applicable "General requirements for certification, surveillance and inspection of products and services".

The certificate remains valid only as long as the provisions and requirements of this certification scheme as well as the product as such remain unchanged. Any changes to the product that have an effect on the characteristics verified by the type test, shall be communicated to the certification body without being asked.

In case of failure to comply with the provisions and measures specified by this certification scheme, the certificate as well as the right of affixing the mark to the respective products, will be withdrawn.

5.2 Marking

The products can be marked by affixing the "ift-certified" mark. The applicable documents listed in Section 2 - procedure and contents of certification - shall be observed. In addition to applying the mark on shipping documents, catalogues, technical documentation, advertising documents or packaging, marking may also be in a digital format.

The right of affixing the quality mark expires automatically by terminating the certification and surveillance contract, or in the event of non-compliance with the criteria laid down by this certification scheme.

6 Factory production control

The manufacturer of industrial doors and gates undertakes to establish a system of factory production control to assure consistent characteristics of industrial doors and gates. The manufacturer shall name an employee responsible for certification who has the authority, knowledge and experience in the production process of industrial doors and gates. This employee is responsible for due implementation of factory production control. If unallowed non-conformities are detected during factory production control, the person responsible for factory production control shall immediately initiate measures to eliminate such non-conformities or defects. Factory production control includes the following mandatory inspections/tests:

- Material control/control of incoming goods

- Production control

- Inspection of marking

Suitable equipment and devices shall be provided for performing factory production control.

6.1 Material control/control of incoming goods

The following shall be observed for material control/control of incoming goods:

Material - control of incoming goods

Receiving inspection of drive units and controls,

Manufacturer's certificate of conformity as per EN 10204:2005, at least as per Clause 2.1 or acceptance certificates as per EN 10204:2005, Clause 3.1 are permitted.

6.2 Production control

Production control to assure consistent characteristics of industrial doors and gates shall be carried out and documented adequately, at least in accordance with ISO 2859-1:1999 + Cor. 1:2001 + Amd. 1:2011, S2, AQL 1.5.

7 Third party control

7.1 General

Contents, rights and duties are described by ift-Cert in the applicable relevant documents "General requirements for certification, surveillance and inspection of products and services".

7.2 Regular inspection/audit of monitored site

7.2.1 Intervals and contents

The third-party audit is performed twice a year in the form of a regular site inspection at the monitored location (production site or sales organisation) If manufacturers operate a certified QM-system as per standard series EN ISO 9001, the regular audit/inspection may be performed only once a year and comprises the following:

Inspection and evaluation of the required evidence / ift Product Passports,

Management of factory production control and evaluation of its results,

Processing accuracy (e.g. attachment of hardware, construction design, etc.),

Proof of calibration of measuring tools and test facilities,

Calibration of the test apparatus and, if necessary, testing of a ready-for-use gate taken at random from production, storage or dispatch,

Proof of handling customer complaints and employee trainings,

Product marking and conformity assessment.

If no ready-to-use products are found for inspection during a regular inspection, at least the following checks shall be carried out:

- Submission, inspection and evaluation of the required evidence,
- Management of factory production control and evaluation of its results,
- if necessary, random checks of products and vendor parts in stock,
- Validity of the test reports/test certificates, expert statements.

If no certified systems in ready-to-operate condition or complete components for the assembly of a industrial door/gate in production or dispatch are found in 2 consecutive regular inspections, an object-related third party control or a special audit can be agreed upon at the time of completion of the industrial door/gate. This is evaluated as a regular inspection.

7.2.2 Surveillance report

An audit report is prepared on the findings of the regular audit/inspection. If one or more measured values are beyond the specified limit values, the cause of the non-conformity must be identified and eliminated at short term. After elimination of defects, the certification body decides whether additional quality assurance measures are required (e.g. a special audit/inspection).

7.2.3 Remedy of deviations - Special audit

Special audits may become necessary as a consequence of:

- negative evaluation of surveillance or
- complaints received from the market concerning the certified construction product.

7.2.4 Deadlines to remedy deviations

Deviations from essential characteristics of a construction product according to Article 4 of the Construction Products Regulation shall be eliminated immediately. In justified cases, ift-Cert reserves the right to inform the responsible market surveillance. As a rule, the deadline provided for discharge of other deviations detected during the surveillance should not exceed three month. As a rule, the deadline provided for discharge of deviations detected during the special audit is set at a maximum of one month.