



ZI – 18

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Information on the certification body OFI CERT

Bonding of railway vehicles and vehicle parts according to DIN 6701-2

General information on the conformity assessment and certification process
according to the appropriate product certification systems.



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This basis for the certificate is continuously adapted to the quality standard.
We are pleased to accept written suggestions.

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1 Scope and general information

This information by the certification body of OFI CERT applies to user companies which perform bonding work on railway vehicles and vehicle part.

This certificate includes general information on the conformity assessment and certification process and thereby the process and the assessment fundamentals which are required for the assessment of certificates of conformity according to DIN 6701.

Since 01.01.2010, all user companies must have proven their aptitude to bond railway vehicles and vehicle parts through certification in accordance with DIN 6701-2. The DIN 6701 series presents the recognised stand of the art for the bonding of railway vehicles and vehicle parts.

2 Definitions

2.1 Abbreviations

| | |
|------------|---|
| ZI | Information of OFI CERT |
| OFI CERT | Certification body of OFI |
| FPC | Factory-side production control and process check |
| AK Bonding | Bonding work group for DIN 6701 |

2.2 Basic documents

For all bodings of railway vehicles addressed in this certificate and vehicle parts, the following standards and fundamental documents were elaborated:

- DIN 6701-1:2004 (Draft) "Adhesion of railway vehicles and vehicle parts - Part 1: Basic terms, Basic rules" (Note: Was withdrawn 2016)
- DIN 6701-2:2015 "Bonding of railway vehicles and vehicle parts - Part 2: Qualification of the user companies"
- DIN 6701-3:2015 "Bonding of railway vehicles and vehicle parts - Part 3: Guide on the construction and provision of proof of adhesive bonds in railway vehicle construction"
- DIN 6701-4:2015 "Bonding of railway vehicles and vehicle parts - Part 4: Rules of execution and quality assurance"
- DVS 3310:2012 "Quality requirements in bonding technology"
- A-Z collection of the "Bonding Work Group DIN 6701"

3 Conformity assessment process as part of initial certification

The system to evaluate and review the constancy of performance is established for the initial issue of the certificate of conformity and the on-going certification activity according to DIN 6701-2.

3.1 Application and required documents

The applicant must submit the following documents to OFI CERT for certification:

- Filled-out form signed by the company "Request for certification according to DIN 6701" of OFI-CERT;
- General operational description of the user operation;

- List of bonding work (cf. section 3.2)
- org chart from which the position of the bonding supervisor is derived;
- List of the bonding supervisor entities with a distribution of tasks and responsibilities;

3.2 Determination of the performance characteristics or bonding work

A component of the application is a list of the bonding work:

- Indication of the assemblies with a reference to the classes
- Name of materials / surfaces
- Filled-out code table (analogous to DIN 6701-2:2015-12, Table A.1);

3.3 Determination of the partners involved in the conformity assessment procedure

In coordination with the applicant, the auditor of the conformity assessment authority is selected who is to perform the initial verification of the plant and the FPC. The auditor was provided all of the documents required in section 3.1 by OFI CERT.

3.4 Assessment fundamentals

The basis for the evaluation of the certification is compliance with the requirements according to DIN 6701-2. The bases for assessment are always to be subdivided into two groups:

- Requirements for FPC and the quality manual
- Tests and reports (in-house factory production check, initial verification);

3.4.1 Requirements for WPK and the quality manual

Through the initial inspection by the auditor of OFI CERT, it should be noted whether the personal and technical prerequisites apply for the proper establishment and implementation of the FPC.

3.4.1.1 Manufacturers with a certified quality management system

If certification was submitted for a valid, certified manufacturer quality management system in accordance with EN ISO 9001, the general requirements for organisation and the quality manual have been met.

3.4.1.2 Manufacturers without a certified quality management system

Manufacturers without a quality management system will receive no conformity certification according to DIN 6701, according to DVS 3310:2012, item 1 "Introduction".

COMMENT:

In DVS 3310:2012, item 1 it is explained "In order to achieve a seamless adhesion process and to recognise sources of possible difficulties, the business which wishes to apply this guideline (DVS 3310) must have an appropriate quality assurance system."

3.4.2 Tests and reports

The results of the initial verification are summarised by the auditor of OFI CERT in an inspection report. The inspection report is the basis for the certification. At best, improvement measurements have been stated.

3.5 Certification

Certification (issue of conformity certification) is on the basis of documents in section 3.4 and upon conclusion of the agreement (section 3.6.1).

Measurements for improvement which are issued as part of the inspection by WPK by the auditor of OFI CERT are to be implemented by the issue of the conformity certification. OFI CERT assesses these in terms of implementation.

3.5.1 Certification contract

A contract is to be concluded between OFI CERT and the user company to perform the inspection of the WPK. This body of agreements defines the rights and obligations of the contractual partners and defines all products or processes subject to the WPK.

3.5.2 Management of improvement measures

After conclusion of the initial inspection of the plant and the WPK the auditor of the certification authority OFI CERT must specify the observations in writing during the audit in an inspection report and will perform an overall assessment which also includes measures for improvement.

Improvement actions are weighted in terms of the degree of influence on product quality or the stability of the production process by the auditor or the certification authority OFI CERT and are given deadlines for their implementation.

The implementation check is by OFI CERT. In the event that a deadline is to be exceeded imminently, the certification authority OFI CERT is to be informed verifiably and immediately. The certification authority OFI CERT decides about the further process.

In the event of an initial inspection - the goal is to obtain future certification - a deadline can be exceeded or delayed implementation of the improvement measures can result in the certificate of conformity not being issued.

3.5.3 Issue of the conformity certification according to DIN 6701-2

The issue of the conformity certification occurs after an initial inspection of the plant and WPK. This is associated with the location of the user business and its bonding supervising persons.

The recognition of certificates of conformity, their implementation or revocation are published on the website of OFI CERT (<http://www.oficert.at>) and in the "Online registry DIN 6701" (<http://www.din6701.de>).

3.5.4 Validity period of the conformity certification

According to the "A-Z collection", the validity of the certificate of conformity is limited to at most 3 years. The fee for the entire validity period is billed upon the issue of the conformity certification.

During the conformity certification validity period, an inspection takes place (section 4). The conformity certification is reissued upon expiry of the validity of the conformity certification after meeting the regulations in section 5.

4 Conformity assessment process as part of monitoring

During the validity period of the conformity certification, the WPK is monitored at least once by OFI CERT in terms of meeting the requirements in DIN 6701.

An inspection on site is conducted for this purpose. OFI CERT will arrange for this after approx. 1.5 years with the user business which is to be monitored. The application here is on the basis of the certification agreement.

In terms of the assessment fundamentals, reference is made to section 3.4 and for certification, reference is made to section 3.5.

5 Re-issue of the conformity certification

After three years and therefore following the expiry of the validity period of the certificate of conformity, an extension of the WPK inspection of the user company by OFI CERT is possible.

This is to be applied for at OFI CERT with the documents indicated in section 0 and section 3.2, at the latest 6 months before expiration of the certificate of conformity validity period.

In terms of the assessment fundamentals, reference is made to section 3.4 and for the certification process, reference is made to section 3.5.

6 Change of assessment fundamentals (standards)

If the fundamentals for assessment change, upon which the certificate of conformity is based (e.g. revision of the standard), the OFI CERT certification authority must inform the certificate holder that this can entail a fee-based review within a set period of time. Expiration of this period of time can result in revocation or deletion of the certificate.

7 Revoking the certificate

According to "A-Z Collection", OFI CERT revokes a certificate if

- there are serious deficiencies in the proper execution of bonding work in terms of the fundamental documents (section 2.2),
- there are serious deficiencies in the bonding supervising (except component class A3) in terms of the fundamental documents (section 2.2),
- no recognised bonding supervisor (except component class A3) is still available,
- no valid proof of qualifications of the bonding staff is available,
- other prerequisites are no longer met in terms of the basic documents (section 2.2),
- the validity period has expired or
- the user business waives the certificate.

Annex A – Summary of the documents required for the certification

Documents required for certification:

- Filled-out form signed by the company "Application for certification according to DIN 6701" of OFI-CERT;
- General operational description of the user operation;
- List of bonding work (cf. section 3.2) with reference to:
 - Indication of the assemblies with a reference to the classes;
 - Name of materials / surfaces;
 - Filled-out code table (analogous to DIN 6701-2:2015, Table A.1);
- org chart from which the position of the bonding supervisor is derived;
- List of the bonding supervisor entities with a distribution of tasks and responsibilities

Annex B – Process of Certification (informativ)

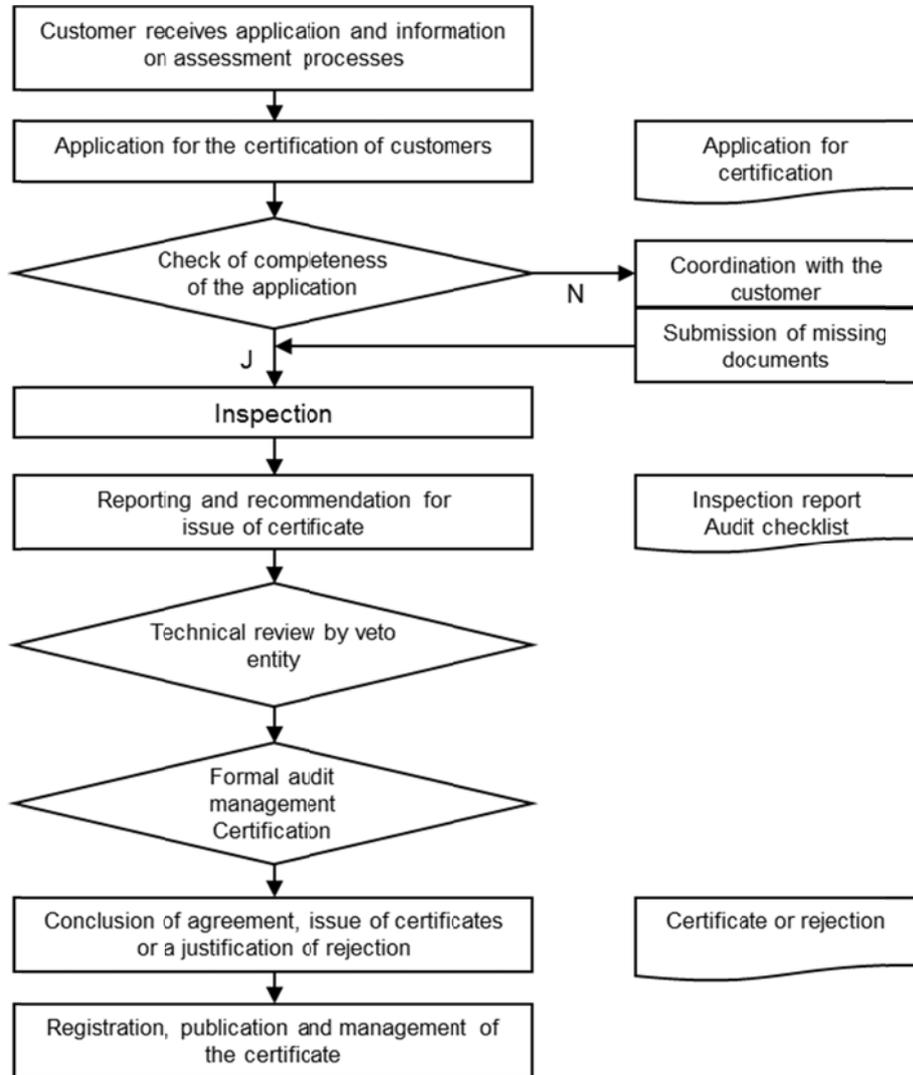


Figure 1: Certification process - simplified