BS EN 15683-2:2013

BSI Standards Publication

Glass in building — Thermally toughened soda lime silicate channel shaped safety glass

Part 2: Evaluation of conformity/Product standard

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National foreword

This British Standard is the UK implementation of EN 15683-2:2013.

The UK participation in its preparation was entrusted to Technical Committee B/520/1, Basic and transformed glass products.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

ISBN 978 0 580 80206 5

ICS 81.040.20

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 December 2013.

Amendments issued since publication

Date	Text affected

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 15683-2

December 2013

ICS 81.040.20

English Version

Glass in building - Thermally toughened soda lime silicate channel shaped safety glass - Part 2: Evaluation of conformity/Product standard

Verre dans la construction - Verre de silicate sodo-calcique profilé de sécurité trempé thermiquement - Partie 2 : Evaluation de la conformité/Norme de produit

Glas im Bauwesen - Thermisch vorgespanntes Kalknatron-Profilbau-Sicherheitsglas - Teil 2: Konformitätsbewertung/Produktnorm

This European Standard was approved by CEN on 30 May 2013.

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Foreword

This document (EN 15683-2:2013) has been prepared by Technical Committee CEN/TC 129 “Glass in Building”, the secretariat of which is held by NBN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2014, and conflicting national standards shall be withdrawn at the latest by June 2014.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directives.

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

EN 15683 is composed of the following parts:

— EN 15683-1, *Glass in building — Thermally toughened soda lime silicate channel shaped safety glass — Part 1: Definition and description*

— EN 15683-2, *Glass in building — Thermally toughened soda lime silicate channel shaped safety glass — Part 2: Evaluation of conformity/Product standard*

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European Standard covers the evaluation of conformity and the factory production control of thermally toughened soda lime silicate channel shaped safety glass for use in buildings.

This also includes requirements subject to regulation.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 356, *Glass in building — Security glazing — Testing and classification of resistance against manual attack*

EN 410, *Glass in building — Determination of luminous and solar characteristics of glazing*

EN 572-1, *Glass in building – Basic soda lime silicate glass products — Part 1: Definitions and general physical and mechanical properties*

EN 572-7, *Glass in building — Basic soda lime silicate glass products — Part 7: Wired or unwired channel shaped glass*

EN 673, *Glass in building — Determination of thermal transmittance (U value) — Calculation method*

EN 1063, *Glass in building — Security glazing — Testing and classification of resistance against bullet attack*

EN 1096-1, *Glass in building — Coated glass — Part 1: Definitions and classification*

EN 1096-2, *Glass in building — Coated glass — Part 2: Requirements and test methods for class A, B and S coatings*

EN 12600, *Glass in building — Pendulum test — Impact test method and classification for flat glass*

EN 12758, *Glass in building — Glazing and airborne sound insulation — Product descriptions and determination of properties*

EN 12898, *Glass in building — Determination of the emissivity*

EN 13501-1, *Fire classification of construction products and building elements — Part 1: Classification using data from reaction to fire tests*

EN 13501-2, *Fire classification of construction products and building elements — Part 2: Classification using data from fire resistance tests, excluding ventilation services*

EN 13501-5, *Fire classification of construction products and building elements — Part 5: Classification using data from external fire exposure to roofs tests*

EN 13541, *Glass in building — Security glazing — Testing and classification of resistance against explosion pressure*

EN 15683-1:2013, *Glass in building — Thermally toughened soda lime silicate channel shaped safety glass — Part 1: Definition and description*

3 Terms and definitions

For the purpose of this document, the terms and definitions given in EN 15683-1:2013 and the following apply.

3.1
initial type testing
determination of the performance of a product (characteristic, durability), on the basis of either actual tests or other procedures (such as conventional, standardised, tabulated or general accepted values, standardised or recognised calculation methods, test reports when made available, …), in accordance with this document that demonstrates compliance with this document

3.2
test report
document that covers the results of tests undertaken on a representative sample of the product from production or on a prototype design of the product

3.3
product description
document that details the relevant parameters, e.g. process conditions, structure, etc., for defining a product that complies with the standard and which includes specific reference(s) to characteristics that are modified by the production process

3.4
significant change
variation in performance beyond the permitted tolerance for the characteristic

3.5
plank
length of channel shaped glass

4 Requirements

4.1 Product description

For conformity purposes, the thermally toughened soda lime silicate channel shaped glass manufacturer is responsible for the preparation and maintenance of the product description. This description shall describe the product and/or product families.

Disclosure of the product description shall be at the discretion of the thermally toughened glass manufacturer or his agent except in the case of regulatory requirements.

The description shall contain at least a normative part. The description may also contain an informative part, when the manufacturer foresees further development of the product.

The normative part of the description shall contain the following minimum information:

— a reference to EN 15683-1 and EN 15683-2 and all other standards with which the manufacturer claims compliance;

— the spectrophotometric properties and durability of coated glass, i.e. coated glass that conforms with EN 1096-1 and EN 1096-2, when those properties are changed, intentionally or unintentionally, by the thermal toughening process.

The definition of product families shall be consistent with the normative part of the product description.

The substitution of materials shall maintain the conformity with the product description. The substituting material can be added to the product family and also the product description when compliance has been demonstrated.

4.2 Conformity with the definition of thermally toughened soda lime silicate channel shaped safety glass

Products shall conform to the definition and fulfil the requirements of thermally toughened soda lime silicate channel shaped safety glass as defined in EN 15683-1.

4.3 Determination of the performances of characteristics

4.3.1 Characteristics of thermally toughened soda lime silicate channel shaped safety glass

4.3.1.1 General

The characteristics of thermally toughened soda lime silicate channel shaped safety glass are those of the glass substrate (see 4.3.1.2).

4.3.1.2 Characteristics of channel shaped glass used for thermally toughened soda lime silicate channel shaped safety glass

Planks shall be made of unwired channel shaped glass products according to EN 572-1 and EN 572-7. The panes may be coated according to EN 1096-1 and EN 1096-2, and/or enamelled according to EN 15683-1.

For the characteristics listed in Table 1, for thermally toughened soda lime silicate channel shaped safety glass, generally accepted values or calculated values shall be used.

Since the majority of the characteristics of Table 1 are not changed significantly by the thermal toughening process they shall be used for thermally toughened soda lime silicate channel shaped safety glass. The exceptions shall be the characteristic bending strength $f_{g,k}$ and the resistance against sudden temperature changes and temperature differentials.

Table 1 — Information on the characteristics of basic channel shaped glass, according to EN 572-1, used for the production of thermally toughened soda lime silicate channel shaped safety glass

Characteristic	Symbol	Unit
- Density	ρ	kg/m³
- Hardness (knoop hardness in accordance with ISO 9358)	$HK_{0,1/20}$	GPa
- Young's modulus	E	Pa
- Poisson's ratio	μ	Dimensionless
- Characteristic bending strength	$f_{g,k}$	Pa
- Resistance against sudden temperature changes and temperature differentials		K
- Specific heat capacity	c	J/(kg·K)
- Coefficient of linear expansion	α	K^{-1}
- Thermal conductivity (for U-value)	λ	W/(m·K)
- Mean refractive index to visible radiation	n	Dimensionless
- Emissivity	ε	Dimensionless
- Light transmittance	τ_v	Dimensionless
- Solar direct transmittance	τ_e	Dimensionless
- Total energy transmittance	g	Dimensionless

If some coatings, i.e. coated glass conforming with the EN 1096 series, when thermally toughened change their radiometric properties the manufacturer shall refer to the following for the determination of the appropriate characteristics, etc.:

— 4.3.2.12 for the emissivity;

— 4.3.2.13 for the light transmittance and reflectance;

— 4.3.2.14 for the solar energy transmittance;

— EN 1096-2 for the durability of A, B and S coatings.

4.3.2 Determination of characteristics of thermally toughened soda lime silicate channel shaped safety glass products

4.3.2.1 General

If the thermally toughened glass manufacturer wishes to claim that any performance characteristic is independent of the production equipment used then the factory production control system shall be in accordance with this document including his specific process control conditions.

4.3.2.2 Safety in the case of fire - Resistance to fire

Fire resistance shall be determined and classified in accordance with EN 13501-2.

4.3.2.3 Safety in the case of fire - Reaction to fire

Reaction to fire shall be determined and classified in accordance with EN 13501-1.

Thermally toughened soda lime silicate channel shaped safety glass products are products/materials that do not require to be tested for reaction to fire (e.g. products/materials of Classes A1 according to Commission Decision 96/603/EC, as amended by 2000/605/EC).

4.3.2.4 Safety in the case of fire - External fire behaviour

Where the manufacturer wishes to declare external fire performance (e.g. when subject to regulatory requirements), the product shall be tested and classified in accordance with EN 13501-5.

4.3.2.5 Safety in use - Bullet resistance: shatter properties and resistance to attack

Bullet resistance shall be determined and classified in accordance with EN 1063.

NOTE Thermally toughened soda lime silicate channel shaped glass will usually not be classified as bullet resistant.

4.3.2.6 Safety in use - Explosion resistance: impact behaviour and resistance to impact

Explosion resistance shall be determined and classified in accordance with EN 13541.

NOTE Thermally toughened soda lime silicate channel shaped glass will usually not be classified as explosion resistant.

4.3.2.7 Safety in use - Burglar resistance: shatter properties and resistance to attack

Burglar resistance shall be determined and classified in accordance with EN 356.

NOTE Thermally toughened soda lime silicate channel shaped glass will usually not be classified as burglar resistant.

4.3.2.8 Safety in use - Pendulum body impact resistance: shatter properties (safe breakability) and resistance to impact

Pendulum body impact resistance shall be determined and classified in accordance with EN 12600.

NOTE Thermally toughened soda lime silicate channel shaped glass cannot be classified for pendulum body impact resistance as the test method only applies to flat glass.

A system incorporating thermally toughened soda lime silicate channel shaped glass may be tested and impact performance determined.

4.3.2.9 Safety in use - Mechanical resistance: Resistance against sudden temperature changes and temperature differentials

The resistance against sudden temperature changes and temperature differentials is a generally accepted value that is given in EN 15683-1 and shall be ensured by compliance with this document.

4.3.2.10 Safety in use - Mechanical resistance: Resistance against wind, snow, permanent load and/or imposed loads of the glass unit

The mechanical strength/profile bending strength of thermally toughened soda lime silicate channel shaped safety glass is a characteristic value that is given in EN 15683-1 and shall be ensured by compliance with this document.

As long as on the concerned construction or building site no part of prEN 16612 is applicable for the design, then the current method of determining mechanical resistance in the country of destination shall be applied.

The manufactured or supplied type, i.e. thickness, width and flange height, and length (H) of thermally toughened soda lime silicate channel shaped safety glass shall conform to the ordered type and length (H).

4.3.2.11 Protection against noise - Direct airborne sound reduction

The sound reduction indexes shall be determined in accordance with EN 12758. However, the information supplied with the incoming glass may be used as the thermal toughening process does not alter the values.

4.3.2.12 Energy conservation and heat retention - Thermal properties

The thermal transmittance value (U-value) shall be determined by calculation in accordance with EN 673 with:

— emissivity ε: the declared value of the glass manufacturer; if the information is not available, the emissivity shall be determined in accordance with EN 12898;

— nominal thickness of the glass panes.

Subject to 5.2.1, the information supplied about the thermal properties of the incoming glass may be used if the thermal toughening process does not alter the values.

4.3.2.13 Energy conservation and heat retention - Radiation properties: Light transmittance and reflectance

The light transmittance and reflectance shall be determined in accordance with EN 410.

Subject to 5.2.1, the information supplied about the radiation properties of the incoming glass may be used if the thermal toughening process does not alter the values.

4.3.2.14 Energy conservation and heat retention - Radiation properties: Solar energy characteristics

The solar energy transmittance and reflectance shall be determined in accordance with EN 410.

Subject to 5.2.1, the information supplied about the radiation properties of the incoming glass can be used if the thermal toughening process does not alter the values.

4.4 Durability

When products conform to the definition of thermally toughened soda lime silicate channel shaped safety glass as 4.2, then the characteristics' performances in 4.3.2 are ensured during an economically reasonable working life.

The durability of glass products including their characteristics, shall be ensured by the following:

— compliance with this document;

— compliance with instructions from the glass product manufacturer or supplier.

The manufacturer shall supply specific installation instructions or make reference to appropriate technical specifications.

NOTE The durability of glass products depends on:

— building and construction movements due to various actions;

— building and construction vibrations due to various actions;

— deflection and racking of the glass support due to various actions;

— glass support design (e.g. drainage of infiltrated water in the rebate, prevention of direct contact between glass support members and glass);

— accuracy of glass support and glass support member dimensions;

— quality of installation of the glass support into or onto the buildings or constructions;

— glass support expansion due to adsorbed moisture from the air or other sources;

— the quality of installation of the glass product into or onto its support.

4.5 Dangerous substances

National regulations on dangerous substances may require verification and declaration on release, and sometimes content, when construction products covered by this standard are placed on those markets.

In the absence of European harmonised test methods, verification and declaration on release/content should be done taking into account national provisions in the place of use.

NOTE An informative database covering European and national provisions on dangerous substances is available at the Construction web site on EUROPA accessed through: *http://ec.europa.eu/enterprise/construction/cpd-ds/*.

5 Evaluation of conformity

5.1 General

The evaluation of conformity shall be based on:

a) factory production control;

this shall include the following:

1) inspection of samples taken at the factory in accordance with a prescribed test plan;

2) initial inspection of the factory and of factory production control;

3) continuous surveillance and assessment of the factory production control.

b) initial type testing of the product.

There may be a need to involve a third party, with 1b, 1c, and/or 2, for the purpose of regulatory marking (see Annex ZA).

5.2 Initial type testing of the product (see 5.1, b))

5.2.1 General

5.2.1.1 General

All the product's characteristics shall be initial type tested to verify they are in conformity with the requirements of this document. In addition, instead of performing any actual testing, initial type testing may make use of:

— generally accepted and/or conventional and/or standardised values, in the Clause 2 referenced standards, or in publications that are referred to in these standards;

— standardised calculation methods and recognised calculation methods in Clause 2 referenced standards, or in publications that are referred to in these standards;

— test report(s) on the basis of 5.2.1.3 when made available except for the characteristics listed in 5.2.2;

— where components are used whose characteristics have already been determined, by the component manufacturer, on the basis of conformity with other product standards, these characteristics need not be reassessed providing they remain unchanged by the manufacturing process;

— release of dangerous substances may be assessed indirectly by controlling the content of the substance concerned;

— durability may be assessed indirectly by controlling the production processes according to this document;

Products CE marked in accordance with appropriate harmonised European specifications may be presumed to have the performances stated with the CE marking.

There may be a need to involve a third party for the purpose of regulatory marking (see Annex ZA).

When actual testing is required then the initial type testing (ITT) shall be undertaken on a sample representative of the product taken from direct production or a prototype, any plant and/or line.

Whenever a change occurs in the raw material or the production process (subject to the definition of the family), which would change significantly one or more of the characteristics, the type tests shall be repeated for the appropriate characteristics.

5.2.1.2 Multiple lines/sites

If a manufacturer operates one and/or more lines and/or sites, the following can reduce the requirement for multiple initial type testing (ITT):

a) The manufacturers' technical file for a product shall specifically covers all sites and/or lines of the same manufacturer[1)];

b) The manufacturer shall establish a direct relationship between production control, initial type testing and on-going internal audit testing;

c) The manufacturer has a responsible individual designated to ensure product compliance based on:

   1) the operation of a consistent factory production control system on all applicable sites and/or lines;

   2) the manufacturer having obtained evidence that shows the product to be consistent, with respect to both product characteristics and intended use characteristics;

   3) the manufacturer has in place an internal auditing scheme, including product consistency.

5.2.1.3 Historic data

Tests previously performed in accordance with the provisions of this document (same product, same characteristic(s), same or more onerous test method, sampling method and attestation of conformity) may be taken into account.

1) The terms 'manufacturer' and 'producer' are understood as being synonymous (see CPD working document NB-CPD/02/019-issued 24 April 2002 – page1).

5.2.2 Initial type testing of thermally toughened soda lime silicate channel shaped safety glass

5.2.2.1 General

To establish if a product conforms to the definition of thermally toughened soda lime silicate channel shaped safety glass, initial type testing shall consist of:

a) mechanical strength measurement in accordance with EN 15683-1;

b) fragmentation test in accordance with EN 15683-1.

5.2.2.2 Test specimens

The test specimens needed for the initial type test shall be processed from unwired channel shaped glass according to EN 572-1 and EN 572-7 in accordance with this document. The product shall be tested in both directions, i.e. flange in tension and web in tension.

The number of test specimens is as follows:

a) For mechanical strength measurement, they are given in Table 2 a) for thermally toughened soda lime silicate channel shaped glass, Table 2 b) for coated thermally toughened soda lime silicate channel shaped glass, Table 2 c) for enamelled thermally toughened soda lime silicate channel shaped glass.

b) For fragmentation, 5 test specimens per type are required.

Table 2 a) — Number of test specimens distributed over the product range

Product range	**Number of test specimens for the mechanical strength measurement**
– Thickness 6 mm, flange height 41 mm, minimum width	≥ 2
– Thickness 6 mm, flange height 41 mm, maximum width	≥ 2
– Thickness 7 mm, flange height 60 mm, minimum width	≥ 2
– Thickness 7 mm, flange height 60 mm, maximum width	≥ 2
TOTAL	≥ 10
NOTE When the production range consists of: - a single thickness, all specimens are of the same thickness; - a single width, all specimens are of the same width.	

Table 2 b) — Number of test specimens of coated channel shaped glass, distributed over the product range

Emissivity ε of incoming glass product	Product range	Number of specimens for the mechanical strength measurement
> 0,25 to ≤ 1	Thickness 6 mm, flange height 41 mm, minimum width	≥ 2
	Thickness 6 mm, flange height 41 mm, maximum width	≥ 2
	Thickness 7 mm, flange height 60 mm, minimum width	≥ 2
	Thickness 7 mm, flange height 60 mm, maximum width	≥ 2
Total		(min.10)
> 0,1 to < 0,25	Thickness 6 mm, flange height 41 mm, minimum width	≥ 2
	Thickness 6 mm, flange height 41 mm, maximum width	≥ 2
	Thickness 7 mm, flange height 60 mm, minimum width	≥ 2
	Thickness 7 mm, flange height 60 mm, maximum width	≥ 2
Total		(min.10)
NOTE Tests according to this table are valid for all coated glasses within the respective emissivity ranges.		

Table 2 c) — Number of test specimens of enamelled channel shaped glass, distributed over the product range

Type of surface design	Product thickness range	Number of specimens for the mechanical strength measurement
Fully enamelled	Thickness 6 mm, flange height 41 mm, minimum width	≥ 2
	Thickness 6 mm, flange height 41 mm, maximum width	≥ 2
	Thickness 7 mm, flange height 60 mm, minimum width	≥ 2
	Thickness 7 mm, flange height 60 mm, maximum width	≥ 2
Total		Minimum 10
NOTE 1 This table covers all enamelled designs.		
NOTE 2 Mechanical test undertaken with enamelled surface in tension.		

Strength measurements outcomes are expressed in force per unit of area and independent from the thickness. Therefore, strength measurements may be performed on a collection of test specimens with different thickness.

5.2.2.3 Test results

a) When the mechanical strength is measured, no measured value shall be below that given in 9.4 of EN 15683-1:2013. However, if one value falls below then the manufacturer shall ensure that the results relate to a 5 % probability of breakage at the lower limit of the 95 % confidence interval.

b) In the fragmentation test, no test specimen shall exhibit a fragmentation assessment that does not meet 8.5 of EN 15683-1:2013.

5.2.3 Initial type testing of characteristic's performances

All characteristics in 4.3.2 shall be subjected to initial type testing in accordance with 5.2.

Optimising thermal toughening settings specifically for one characteristic may affect negatively the optimised settings for a different characteristic. When performance of both characteristics will be declared, the affected characteristic shall be subject to a further type test.

5.3 Factory production control and inspection of samples in accordance with a prescribed test plan (see 5.1, a) 1) and 2)

Factory production control (FPC) means the permanent internal control of production exercised by the manufacturer.

All elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures. This production control system documentation shall ensure a common understanding of quality assurance and enable the achievement of the required product characteristics and the effective operation of the production control system to be checked.

Factory production shall be according to Annex A of this document.

NOTE A factory production control system similar to EN ISO 9001 made product specific to this document is deemed to satisfy the requirements of this clause.

There may be a need to involve a third party for the purpose of regulatory marking (see Annex ZA).

Annex A of this document also summarises the tests that shall be carried out by the manufacturer as part of the production control in the factory, and as further testing of samples taken at the factory in accordance with a prescribed test plan.

5.4 Initial inspection of factory and of factory production control (see 5.1, a) 2)

The initial inspection of the factory and of the factory production control shall be limited to the parameters listed in Table 3 in conjunction with Annex A.

There may be a need to involve a third party for the purpose of regulatory marking (see Annex ZA).

Table 3 — Characteristics of interest for the factory production control

Nr	Characteristic	Interested parameter related to the characteristic	For details, refer to
A	Resistance to fire Reaction to fire External fire behaviour	- checking incoming glass - checking process control - product control after toughening - labelling outgoing glass product	Annex A
B	Release of dangerous substances	- checking incoming materials	Annex A
C	Bullet resistance Explosion resistance Burglar resistance Pendulum body impact resistance Resistance against sudden temperature Changes and temperature differentials Wind, snow, permanent and imposed load resistance of the glass unit	- checking incoming glass - checking process control - product control after toughening - labelling outgoing glass product	Annex A
D	Direct airborne sound reduction Thermal properties Radiation properties: – light transmittance and reflection – solar energy characteristic	- checking incoming glass - checking process control - product control after toughening - labelling outgoing product	Annex A

5.5 Continuous surveillance and assessment of the factory production control (see 5.1, a) 3)

The continuous surveillance and assessment of the factory production control shall cover the parameters listed in Table 3 in conjunction with Annex A.

There may be a need to involve a third party for the purpose of regulatory marking (see Annex ZA).

The frequency of production surveillance shall be twice per year for new production facilities or for facilities that do not already have an established factory production control system in accordance with this document.

When assessment of FPC fails to identify major non-conformances during four successive assessments, the frequency may be reduced to once a year.

When a major non-conformance is recorded, the inspection shall be repeated within two month. The frequency of production surveillance shall return to, or remain at twice a year. When the repeated inspection also results in a major non-conformance, then the production shall be subject within two months to a repeated initial inspection of the factory and of the factory production control together with a surveillance inspection. When this repeated initial inspection and surveillance inspection also results in a major non-conformance, then the products are considered as no longer conforming to this document.

6 Marking and labelling

6.1 General

All voluntary marking and/or labelling shall comply with C.3.

Care shall be taken to ensure that any voluntary marking and/or labelling does not cause confusion with respect to the mandatory requirements.

NOTE All marking and/or labelling of product to demonstrate compliance with the regulatory requirement is detailed in Annex ZA.

6.2 Product marking

The thermally toughened soda lime silicate channel shaped safety glass product shall be marked in accordance with Clause 10 of EN 15683-1:2013.

6.3 Product characteristics

The manufacturer or his agent shall organise a system of references that allows for the following:

— the identification of exactly which characteristics have to be assessed (see 4.3.2);

— those characteristics that will be assessed;

— the values, classes, categories, etc. that have been determined for those characteristics.

This system shall be documented as part of the evaluation of conformity.

6.4 "Characteristic/performance identification paper"

The manufacturer shall prepare a “characteristics/performance identification paper” based on the information collected on the product characteristics (see 6.3). This document shall be part of the manufacturer's technical file and is the basis for the accompanying information as required for regulatory purposes.

The "characteristics/performance identification paper" can be a catalogue in any media format (paper, disk, website, etc.), always identifiable by the reference that accompanies the marking with the product. The catalogue shall contain the values or classes of the characteristics for which a performance is declared. If no performance is declared, an indication of no performance determined (NPD) shall be made.

NOTE See condition of use of NPD in Annex ZA.

The catalogue should not contain any information other than that relevant to the “characteristics/performance identification paper”.

Annex A
(normative)

Factory production control

A.1 Factory production control requirements

A.1.1 General

The FPC system shall consist of procedures, regular inspections and tests and/or assessments and the use of the results to control [raw and other] incoming materials or components, equipment, the production process and the product.

NOTE An FPC system conforming with the requirements of EN ISO 9001 and made specific to the requirements of this standard is deemed to satisfy the requirements of this standard.

A.1.2 Organisation

A.1.2.1 Responsibility and authority

The responsibility, authority and the interrelation of all personnel who manage, perform and verify work affecting conformity shall be defined, particularly for personnel who have the organisational freedom and authority to:

a) initiate action to prevent the occurrence of product non-conformity;

b) identify and record any product non-conformance.

A.1.2.2 Management representative for factory production control

The manufacturer shall appoint a management representative who, irrespective of other responsibilities, shall have defined authority and responsibility for ensuring that the requirements of this document are implemented and maintained.

A.1.2.3 Management review

The production control system shall be reviewed by the manufacturer's management at appropriate intervals in accordance with the manufacturer's control to ensure its continuing suitability and effectiveness. Records of such reviews shall be maintained for a minimum of 5 years.

A.1.3 Control system

A.1.3.1 General

The manufacturer shall establish and maintain a documented system as a means of ensuring that the product conforms to EN 15683-1. The following requirements hereafter shall be fulfilled.

A.1.3.2 Personnel

The manufacturer shall use appropriately trained personnel for the operation and inspections of all production and inspection equipment.

A.1.3.3 Documentation

The manufacturer's documentation and procedures shall be relevant to the production and process control of the thermally toughened soda lime silicate channel shaped safety glass, and shall adequately described in a manual which shall include:

a) the organisational structure, responsibilities and authorities of the management with regard to product conformity;

b) the procedures for specifying and verifying the incoming materials;

c) the manufacturing, production control and other techniques, processes and systematic actions that will be used;

d) the inspections that will be carried out before production, the inspections and tests during and after production, and the frequency at which they will be carried out;

e) required records of the inspections, test and assessments;

f) non-conformity situations requiring corrective action and the action taken.

Unless otherwise indicated in national regulation, records shall be kept for a minimum of one year after manufacturing the product.

A.1.3.4 Test equipment

Calibration of test equipment necessary for factory production control shall be documented.

NOTE The precision of calibration required is implied by the accuracy of the test method and tolerances specified.

A.1.3.5 Inspection and testing

Clause A.3 designates the inspections and tests by means of tables: the requirements and records are normative.

Frequencies shall be regarded as a minimum frequency.

A.2 Marking

The manufacturer shall establish, document and maintain procedures for marking of the products. The product shall be marked in accordance with the established documents.

For tracing purposes, the manufacturer shall establish and maintain the records required in Clause A.3.

A.3 Inspection and testing tables of thermally toughened soda lime silicate channel shaped safety glass production

A.3.1 Information to the Table A.1

Table A.1 consists of three sections:

— section 1: Incoming material;

— section 2: Production control, including material control prior to thermal toughening;

— section 3: Product control after toughening.

When a manufacturing process is such that one or more of the listed inspections or tests are not applicable or physically not possible, the concerned inspection or test may be ignored.

The inspections and/or tests on incoming materials shall be carried before use.

In the case of non-conforming materials, action shall be taken so that:

— non- conforming raw materials cannot be used;

— non-conforming products cannot be delivered.

The required records in Table A.1 may be any document, e.g. order documents, production documents, logbook, etc., as described in the FPC procedures and associated documentation.

For those criteria where no record is required this situation shall only apply until a complaint regarding that criteria is received. Records shall subsequently be kept to show that corrective action has been successful.

The machinery and equipment used for manufacturing the products are checked at periods consistent with the manufacturers' documented process control against defined parameters, maintained and adjusted for optimal results.

A.3.2 Product control

The inspection and testing of thermally toughened soda lime silicate channel shaped safety glass shall be undertaken after the completion of the manufacturing process (see EN 15683-1).

A.3.3 Use of proxy testing

A manufacturer may employ a test method/method of evaluation other than those referred to in Table A.1. However, it is the manufacturer's responsibility to prepare suitable documentation describing such tests and their correlation with the recommended method to ensure that the appropriate characteristic is as claimed.

Table A.1 — Inspection and test table for thermally toughened soda lime silicate channel shaped safety glass

Section 1: Incoming material					
Ref.	Material, inspection or test	Recommended method (Decision to be made by manufacturer)	Requirement	Recommended minimum frequency	Record
1.1	Incoming material glass				
1.1.1	Identification, including packaging and label	Visual	See purchase specification	Each delivery	Yes
1.1.2	Thickness	Visual	See purchase specification	Each delivery	Yes
1.2	Other materials, e.g. ceramic frit, paint				
1.2.1	Delivery documentation	Visual	See purchase specification	Each delivery	Yes
1.2.2	Chemical analysis	Visual	See purchase specification	Each delivery	Yes

Table A.1 *(continued)*

Section 2: Production control, including material control prior to thermal toughening					
Ref.	Material, inspection or test	Recommended method (Decision to be made by manufacturer)	Requirement	Recommended minimum frequency	Record
2.1	Prior to toughening				
2.1.1	Type, i.e. width, flange height,	Visual	See customer order	1 Product type per order	Yes
2.1.2	Thickness	Measurement	See customer order	1 Product type per order	Yes
2.1.3	Edge work	Visual	See customer order	1 Product type per order	Yes
2.2	Process control				
2.2.1	Relevant process conditions of oven and/or chiller and cooling as described in the manual	See manual instruction	See production instructions	Continuously [a]	Yes
2.2.2	In case of coated or enamelled glass: Identification of position of the coating/enamel	Visual	See production instructions	When required	No

[a] Continuously means a frequency based on an assessment of the requirements of the process used by the manufacturer that will give assurance that product characteristics will comply with the initial type test.

Table A.1 *(continued)*

Section 3: Product control after toughening					
Ref.	Inspection or test	Recommended method (decision to be made by manufacturer)	Requirement	Recommended minimum frequency	Record
3.1	Product				
3.1.1	Overall bow,	Measurement on test specimen or current production	See EN 15683-1 or customer order	1 test per day [b]	Yes
3.1.2	Dimensions,	Measurement on current production	See customer order	1 test per day	Yes
3.1.3	Fragmentation	Measurement (Annex B) on test specimens	See EN 15683-1	Minimum 1 test specimen (H = 2 100 mm; B = width) daily [b]	Yes
[b] The test shall be undertaken to ensure that all glass types and thicknesses manufactured in one week are tested during that week.					

Annex B
(informative)

Tests for factory production control

B.1 Fragmentation test

B.1.1 Requirements

For the requirements, refer to EN 15683-1.

B.1.2 Test method

Fragmentation tests should be performed in accordance with EN 15683-1.

Annex C
(informative)

Provisions for voluntary involvement of third party(ies)

C.1 General

A manufacturer may employ third party(ies) for conformity assessment, which may involve a combination of initial type testing, inspection of factory production control, continuous surveillance and auditing of the product. The results of the conformity assessment by the bodies acting for regulators may be used by third party(ies) in carrying out their assigned tasks.

C.2 Voluntary tasks for third parties

A third party may be voluntarily contracted to perform the initial type testing, inspection of factory production control, continuous surveillance and auditing of the product.

Where a third party is voluntarily involved in the evaluation of conformity of the thermally toughened soda lime silicate channel shaped safety glass products covered by this document then the assessment should be in accordance with Clause 5, Evaluation of Conformity in this document.

A manufacturer may also voluntarily involve a third party in the control of characteristics, e.g. visual aspects, colour, etc., that are over and above the characteristics that are required for regulatory purposes.

C.3 Marking and labelling

The format of the label and position should be agreed between the body involved and the manufacturer.

All marks and/or labels of a voluntary nature should be so affixed as not to be confused with those marks and/or labels that are required for regulatory purposes.

In order to prevent confusion with any regulatory marking and/or labelling any marking and/or labelling associated with the involvement of third party(ies) on a voluntary basis should be accompanied with the following warning: "This marking/labelling has no relationship with any product characteristic covered by any legal marking and/or labelling".

Annex ZA
(normative)

Clauses of this European Standard addressing the provisions of EU Construction Products Directive

ZA.1 Scope and relevant characteristics

This European Standard has been prepared under a mandate M/135 “Flat glass, profiled glass and glass block products” given to CEN by the European Commission and the European Free Trade Association.

The clauses of this European standard shown in this annex meet the requirements of mandate M/135 given under the EU Construction Products Directive (89/106/EEC).

Compliance with these clauses confers a presumption of fitness of the thermally toughened soda lime silicate channel shaped safety glass product characteristics covered by this annex for the intended uses herein; reference should be made to the information accompanying the CE marking.

This annex has the same scope as Clause 1 of this standard with regard to the products covered. It establishes the conditions for the CE marking of thermally toughened soda lime silicate channel shaped safety glass intended for the use indicated below and shows the relevant clauses applicable (see Table ZA.1).

Construction Product: Thermally toughened soda lime silicate channel shaped safety glass

Intended uses: In buildings and construction works

The requirement on a certain characteristic is not applicable in those Member States where there are no regulatory requirements on that characteristic for the intended end use of the product. In this case, manufacturers placing their products on the market of these Member States are not obliged to determine nor declare the performance of their products with regard to this characteristic and the option “No performance determined” (NPD) in the information accompanying the CE marking (see ZA.3) may be used. The NPD option may not be used, however, where the characteristic is subject to a threshold level.

Table ZA.1 – Relevant clauses for thermally toughened soda lime silicate channel shaped safety glass and intended use in buildings and construction works

Product: Thermally toughened soda lime silicate channel shaped safety glass as covered under the scope of this standard **Intended use: In buildings and construction works**			
Essential Characteristics	**Requirements in this and other European Standard(s)**	**Mandated Levels and/or classes**	**Notes**
Safety in the case of fire –			
Resistance to fire (for glass for use in a glazed assembly intended specifically for fire resistance)	4.2, 4.3.1 and 4.3.2.2	All	Minutes
Reaction to fire	4.2, 4.3.1 and 4.3.2.3	Any	Euroclasses
External fire performance (for roof coverings only)	4.2, 4.3.1 and 4.3.2.4	Any	Euroclasses
Safety in use –			
Bullet resistance: Shatter properties and resistance to attack	4.2, 4.3.1 and 4.3.2.5	-	Classes of convenience
Explosion resistance: Impact behaviour and resistance to attack	4.2, 4.3.1 and 4.3.2.6	-	Classes of convenience
Burglar resistance: Shatter properties and resistance to attack	4.2, 4.3.1 and 4.3.2.7	-	Classes of convenience
Pendulum body impact resistance: Shatter properties(safe breakability) and resistance to impact	4.2, 4.3.1 and 4.3.2.8	-	Classes of convenience
Mechanical resistance: Resistance against sudden temperature changes and temperature differentials	4.2, 4.3.1 and 4.3.2.9	-	K and/or °C
Mechanical resistance: Resistance against wind, snow, permanent and imposed load and/or imposed loads of the glass unit	4.2, 4.3.1 and 4.3.2.10	-	Width, flange height, thickness (mm, mm, mm)
Protection against noise: Direct airborne sound reduction	4.2, 4.3.1 and 4.3.2.11	-	dB
Energy conservation and heat retention:			

Thermal properties	4.2, 4.3.1 and 4.3.2.12	-	$W/(m^2 \cdot K)$
Radiation properties:			
– light transmittance and reflectance	4.2, 4.3.1 and 4.3.2.13	-	Fractions or %
- solar energy characteristics	4.2, 4.3.1 and 4.3.2.14	-	Fractions or %
Release of dangerous substances	4.5		

ZA.2 Procedure(s) for the attestation of conformity of thermally toughened soda lime silicate channel shaped safety glass products

ZA.2.1 System(s) of attestation of conformity

The systems of conformity for thermally toughened soda lime silicate channel shaped safety glass indicated in Table ZA.1, are in accordance with the Decision of the Commission 2000/245/EC of 2000-02-02 as amended by 01/596/EC and as given in Annex III of the mandate for “Flat glass, profiled glass and glass block products”, is shown in Table ZA.2 for the indicated intended use(s) and relevant level(s) or classes:

Table ZA.2 – System(s) of attestation of conformity

Product(s)	Intended use(s)	Level(s) or class(es)	Attestation of conformity system(s)
Thermally toughened soda lime silicate channel shaped safety glass	For used in a glazed assembly intended specifically to provide fire resistance	Any	1
	For uses subject to reaction to fire regulations	Euroclass A1[a]	4
	For uses subject to external fire performance regulations	Products requiring testing ---------- Products "deemed to satisfy" without testing	3 ---------- 4
	For use as anti-bullet, or anti-explosion glazing ---------- For other uses liable to present "safety-in-use" risks and subject to such regulations	- ---------- -	1 ---------- 3
	For uses relating to energy conservation and/or noise reduction	-	3
	For uses other than those specified above	-	4

System 1: see Directive 89/106/EEC (CPD) Annex III.2.(i), without audit-testing of samples.

System 3: see Directive 89/106/EEC (CPD) Annex III.2.(ii), Second possibility.

System 4: see Directive 89/106/EEC (CPD) Annex III.2.(ii), Third possibility

[a] Products/materials that do not require to be tested for reaction to fire (e.g. products/materials of Classes A1 according to Commission Decision 96/603/EC, as amended 2000/605/EC)

The attestation of conformity of the thermally toughened soda lime silicate channel shaped safety glass in Tables ZA.1. shall be based on the evaluation of conformity procedures indicated in Table ZA.3.1 to Table ZA.3.3 resulting from the application of the clauses of this or other European Standard indicated therein.

Where more than one table applies for the product, i.e. because its intended use makes different characteristics relevant, Table ZA.3.1 has to be read in conjunction with subsequent tables in order to determine which characteristics assigned by the manufacturer in Table ZA.3.1 are type tested by a notified test lab (system 3) and which by the manufacturer (system 4).

Table ZA.3.1 — Assignment of evaluation of conformity tasks for thermally toughened soda lime silicate channel shaped safety glass under system 1

Tasks		**Content of the task**	**Evaluation of conformity clauses to apply**
Tasks for the manufacturer	Factory production control (FPC)	Parameters related to all relevant characteristics of Table ZA.1	5.3
	Further testing of samples taken at factory	All relevant characteristics of Table ZA.1	Annex A
	Initial type testing	All relevant characteristics of Table ZA.1, except: - resistance to fire - anti-bullet - anti-explosion	5.2
Tasks for the notified body	Initial type testing	Resistance to fire Anti-bullet Anti-explosion	5.2
	Initial inspection of factory and FPC	Parameters related to all the characteristics of Table ZA.1 relevant for the intended uses, in particular: - resistance to fire - anti-bullet - anti-explosion	5.4
	Continuous surveillance, assessment and approval of FPC	Parameters related to all relevant characteristics of Table ZA.1, in particular: - resistance to fire - anti-bullet - anti-explosion	5.5

Table ZA.3.2 — Assignment of evaluation of conformity tasks for thermally toughened soda lime silicate channel shaped safety glass under system 3

Tasks		**Content of the task**	**Evaluation of conformity clauses to apply**
Tasks for the manufacturer	Factory production control (FPC)	Parameters related to all relevant characteristics of Table ZA.1	5.3
	Initial type testing	All other relevant characteristics of Table ZA.1 other than those shown below	5.2
Tasks for the notified body	Initial type testing	External fire performance Burglar resistance Pendulum body impact resistance Direct airborne sound insulation Thermal properties Radiation properties: – light transmittance and reflection – solar energy characteristics	5.2

Table ZA.3.3 — Assignment of evaluation of conformity tasks for thermally toughened soda lime silicate channel shaped safety glass under system 4

Tasks		**Content of the task**	**Evaluation of conformity clauses to apply**
Tasks for the manufacturer	Factory production control (FPC)	Parameters related to all relevant characteristics of Table ZA.1	5.3
	Initial type testing	All relevant characteristics of Table ZA.1, in particular External fire performance	5.2

ZA.2.2 EC Certificate and Declaration of Conformity

In case of products with system 1: When compliance with the conditions of Annex ZA of this standard is achieved, the certification body shall draw up a certificate of conformity (EC Certificate of Conformity), which entitles the manufacturer to affix the CE marking. This certificate shall include:

— name, address and identification number of the certification body;

— name and address of the manufacturer, or his authorised representative established in the EEA, and place of production;

— description of the product (type, identification, use, …);

— provisions to which the product conforms (i.e. Annex ZA of this standard);

— particular conditions applicable to the use of the product (e.g. provisions for use under certain conditions, etc.);

— the number of the certificate;

— conditions and period of validity of the certificate, where applicable;

— name of, and position held by, the person empowered to sign the certificate.

In case of products under system 3: When compliance with the conditions of this annex is achieved, the manufacturer or his agent established in the EEA shall prepare and retain a declaration of conformity (EC Declaration of Conformity), which entitles the manufacturer to affix the CE marking. This declaration shall include:

— name and address of the manufacturer, or his authorised representative established in the EEA, and place of production;

— description of the product (type, identification, use,...), and a copy of the information accompanying the CE marking;

— provisions to which the product conforms (i.e. Annex ZA of this standard);

— particular conditions applicable to the use of the product, (e.g. provisions for use under certain conditions, etc);

— name and address of the notified laboratory(ies);

— name of, and position held by, the person empowered to sign the declaration on behalf of the manufacturer or his authorised representative.

In case of products under system 4: When compliance with this annex is achieved, the manufacturer or his agent established in the EEA shall prepare and retain a declaration of conformity (EC Declaration of Conformity), which entitles the manufacturer to affix the CE marking. This declaration shall include:

— name and address of the manufacturer, or his authorised representative established in the EEA, and place of production;

— description of the product (type, identification, use,...), and a copy of the information accompanying the CE marking;

— provisions to which the product conforms (i.e. Annex ZA of this standard);

— particular conditions applicable to the use of the product (e.g. provisions for use under certain conditions, etc.);

— name of, and position held by, the person empowered to sign the declaration on behalf of the manufacturer or of his authorised representative.

NOTE Duplication of information between the declaration and certificate can be avoided by cross-reference between documents when one contains more information than the other.

The above-mentioned declaration and certificate shall be presented in the official language or languages of the Member State in which the product is to be used.

ZA.3 CE marking and labelling

The manufacturer or his authorised representative established within the EEA is responsible for the affixing of the CE marking. The CE marking symbol to affix shall be in accordance with Directive 93/68/EC and shall be shown on the thermally toughened soda lime silicate channel shaped safety glass (or when not possible it

may be on the accompanying label, the packaging or on the accompanying commercial documents, e.g. a delivery note). The following information shall accompany the CE marking symbol:

a) identification number of the certification body (only for products under system 1);

b) name or identifying mark and registered address of the producer;

c) the last two digits of the year in which the marking is affixed;

d) number of the EC Certificate of Conformity (only for products under system 1);

e) reference to this European Standard;

f) description of the product: generic name, material, dimensions, … and intended use;

g) information on those relevant essential characteristics listed in Table ZA.1 which are to be declared presented as:

   1) declared values and, where relevant, level or class (including “pass” for pass/fail requirements, where necessary) to declare for each essential characteristic as indicated in "Notes" in Table ZA.1;

   2) as an alternative, standard designation(s) alone or in combination with declared values as above; and

   3) “No performance determined” for characteristics where this is relevant.

The “No performance determined” (NPD) option may not be used where the characteristic is subject to a threshold level. Otherwise, the NPD option may be used when and where the characteristic, for a given intended use, is not subject to regulatory requirements in the Member State of destination.

When a standard designation is used, this should give information on all the relevant mandated characteristics; if all are not covered, then values for those not covered should be additionally given. Care should be taken, however, that using standard designations does not bring information on non-harmonised characteristics into the CE marking.

Figure ZA.1 gives an example of the information to be given on the product, label, packaging and/or commercial documents.

CE	*CE conformity marking, consisting of the "CE"-symbol given in Directive 93/68/EEC.*
AnyCo Ltd, PO Box 21, B-1050 **13**	*Name or identifying mark and registered address of the producer* *Last two digits of the year in which the marking was affixed*
EN 15683-2	*No. of European Standard*
Thermally toughened soda lime silicate channel shaped safety glass, intended to be used in buildings and construction works	*Description of product and Information on regulated characteristics*

Characteristics

Resistance to fire	**NPD**
Reaction to fire	**A1**
External fire performance	**NPD**
Bullet resistance	**NPD**
Explosion resistance	**NPD**
Burglar resistance	**NPD**
Pendulum body impact resistance	**NPD**
Resistance against sudden temperature changes and temperature differentials	**200K**
Wind, snow, permanent and imposed load resistance	**6mm, 262 mm, 41 mm**
Direct airborne sound insulation	**30 -1 -2 dB**
Thermal properties	**5,6W/(m^2K)**
Radiation properties:	
light transmission and reflection	**0,85/0,10**
solar energy characteristics	**0,84/0,11**

Figure ZA.1 — Example CE marking information for system of attestation 3

NOTE The identification of the notified body is only relevant for system 1.

Bibliography

[1] EN 357, *Glass in building — Fire resistant glazed elements with transparent or translucent glass products — Classification of fire resistance*

[2] EN 572-9:2004, *Glass in building — Basic soda lime silicate glass products — Part 9: Evaluation of conformity/Product standard*

[3] EN ISO 9001, *Quality management systems — Requirements (ISO 9001)*

[4] ISO 9358, *Optics and optical instruments — Veiling glare of image forming systems — Definitions and methods of measurement*

[5] prEN 16612, *Glass in building — Determination of the load resistance of glass panes by calculation and testing*

[6] Commission Decision 96/603/EC, as amended by 2000/605/EC

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