

**Klaasja kihiga kaetud keraamilised torud ja  
liitmikud ning toruühendused drenide ja  
kanalisatsioonitorustike jaoks. Osa 2: Kvaliteedi  
kontrollimine ja proovivõtt**

Vitrified clay pipes and fittings and pipe joints for  
drains and sewers - Part 2: Quality control and  
sampling

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 295-2:2000 sisaldab Euroopa standardi EN 295-2:1991+A1:1999 ingliskeelset teksti.

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English version

Vitrified clay pipes and fittings and pipe joints  
for drains and sewers - Part 2: Quality control  
and sampling

Tuyaux et accessoires en grès et  
assemblages de tuyaux pour les réseaux  
de branchement et d'assainissement -  
Partie 2: Contrôle de la qualité et  
échantillonnage

Steinzeugrohre und Formstücke sowie  
Rohrverbindungen für Abwasserleitungen  
und -kanäle - Teil 2:  
Güteüberwachung und Probenahme

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## Foreword

This part of the European Standard for vitrified clay pipes is the second of three parts which were drafted by WG2 "Vitrified clay pipes" of the Technical Committee CEN/TC 165 "Waste Water Engineering", Secretariat of which is held by DIN.

"Vitrified clay pipes and fittings and pipe joints Part 1: Requirements" contains the complete specification, "Vitrified clay pipes and fittings and pipe joints Part 3: Test methods" contains the necessary statements on the testing methods.

On drafting this standard the provisional results already available of CEN/TC 165/WG1 "General requirements on pipes, fittings, pipe joints including sealings and manholes" were taken into account. When further results are received, any necessary amendment will be made.

In accordance with the Common CEN/CENELEC Rules, the following countries are bound to implement this European Standard:-

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

Vitrified clay pipes in permanent or in temporary contact with water intended for human consumption will not affect the quality of that water. Therefore this standard does not contravene the EC-Council Directives 75/440, 79/869, 80/778.

This standard takes into account the essential requirements of the EC-Council Directive for construction products (89/106) and the Draft Directive on the treatment of municipal waste water (COM (89) 518).

## 1 General

### 1.1 Object and field of application

This part of this European Standard specifies requirements for manufacturer's internal quality control, third party assessment and inspection.

NOTE: Where reference is made to clauses in EN 295-1 and EN 295-3 it is clearly stated.

### 1.2 References

EN 295-1	1991	Vitrified clay pipes and fittings and pipe joints for drains and sewers : Part 1: Specification.
EN 295-3	1991	Vitrified clay pipes and fittings and pipe joints for drains and sewers : Part 3: Test Methods.
EN 29002	1987	Quality Systems - Model for quality assurance in production and installation.
EN 45011	1989	General criteria for certification bodies operating product certification.
EN 45012	1989	General criteria for certification bodies operating quality system certification.
ISO 2859-1	1989	Sampling procedures for inspection by attributes : Part 1 Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection.
ISO 2859-2	1989	Sampling procedures for inspection by attributes : Part 2 Sampling plans indexed by limiting quality (QL) for isolated lot inspection.
ISO 3951	1989	Sampling procedures and charts for inspection by variables for percent nonconforming.
ISO/DIS10012	1990	Measurement and calibration systems.

## 1.3 Definitions

### 1.3.1 Batch.

A clearly identifiable collection of units manufactured essentially from the same materials and under the same conditions (see 3.2.2, 3.5.2 and 3.9.1 as appropriate).

### 1.3.2 Isolated batch.

A clearly identifiable collection of unassessed units not exceeding 3200 in number manufactured essentially from the same materials but not necessarily all manufactured or fired at the same time.

## 1.4 Internal quality control and third party assessment

### 1.4.1 Quality supervision

Quality supervision shall comprise internal control (1.4.2) and third-party assessment and inspection (1.4.3).

### 1.4.2 Internal control

Internal quality control shall comprise continuous inspection carried out by the manufacturer as part of an approved third party assessment to ensure compliance with the requirements of EN 295 under a quality system complying with EN 29002.

### 1.4.3 Inspection and audits by third party assessors

The third party inspection shall be carried out at least twice a year without previous notice.

The assessors shall visit the manufacturer's works to inspect testing and to check records. In addition, the third party assessor shall carry out audits according to Table 1.

The third party assessors shall comply with the requirements of EN 45011 and EN 45012.

## 1.5 Sampling of fired ware (EN 29002 : 1987 Clause 4.9)

### 1.5.1 Selection of samples

The samples of fired ware for testing shall be selected at random.