

Relevant changes in Technical Appendix version Jan. 2023 compared to 2020

Chapter number refer to the version of 2023

No changes in appendix C, G, H, J

Appendix A profiles

A.1 Scope - CAT.1 includes “any material for inner webs”; CAT.2 only PVC-U matrix with glass fibers.
According modifications in clause A.2.2.x.

A.2.1.1 Nomenclature of the materials – revised: introduction of rPVC, delete ERMa/RMa.

A.2.2.4.1 Tolerances - for non-critical dimensions tolerances can be enlarged.

A.2.2.12 Behaviour after heat storage – failure definitions defined more accurate.

A.2.2.14 Artificial weathering – PMMA always to be weathered “S12”.

A.2.2.14.2 Resistance to weathering – requirement for CHARPY defined more accurate.

A.2.2.17 New parameter introduced: direct solar reflectance instead of HBU. Threshold 18% (instead on 66 °C HBU). According revision of P.3.21 and changes in D.4.5.

A.3.2.2 Registration of non-white formulations – extent of tests defined more accurate.

A.3.2.3 Change of formulation – changing PVC-U brand is not considered a formulation change.

A.3.2ff Chapter numbers have been shifted.

A.3.4.4 External tests on the profile – clarifications integrated.

A.4.1 Factory production control of compounds Table A-9 –requirements for non-white UV reduced material included (extent like white virgin material).

A.4.1 Factory production control of profiles Table A-10 – reduced frequency for behavior after heat storage 1x/48 hrs (like CSTB)

A.4.2 Several changes concerning the external monitoring:

Subclause a) Regulations concerning the “on-site-test”, former written in the paper “implementation rules” are included into the text of the this chapter.

Subclause d) New: “accompanied manufacturer testing” replaces the external test of d1) weldability and d2) colour test for non-white profiles

d1) Weldability/pressure bending test on welded corner is regularly and exclusively tested at the manufacturer. Results are filed to prove the compliance to the requirements. In case of nonconformity, repeat test performed by inspection body (external laboratory).
Validation of the manufacturers test once in two years (4 audits) by a test performed by the inspection body.

Table A-11 External monitoring of the formulation

Proof of the weldability by “short-term welding factor” instead of pressure bending test on welded corner.

Colour deleted as a formulation identification value; instead, colour of white profiles is tested every half year during profile testing (for non-white profiles see “accompanied manufacturers test”).

Table A-12 External monitoring of the profile

New: Colour test for white profiles (for non-white see “accompanied manufacturers test”)

Weldability/corner test to be done as “accompanied manufacturers test”. In case of repeat test applies: preparation of test samples (welding) by the test body (former footnote in tab. A-12 is deleted)

A.4.3. Repeat test – in special cases not to be performed as full test.

New chapter A.5 Suspension and resumption of quality assurance.

Appendix B compounds for compact gaskets as well as compact gaskets

B.2.3, B.5.2.3, B.5.3.2, B.7.2.1 Hardness – changing the test procedure to Shore A (from IRHD) to match with DIN 7861-1

B.4 and B.12 Slightly different requirements apply in testing, when focusing on a “RAL only”-certification versus a certification for both, RAL and CSTB.

B.7.2.2 Factory production control

functional tests defined more accurate.

Table B-15 - colour test frequency reduced for compounds where carbon black is used.

Appendix D films (foils)

D.3 Classification of films - separation between lacquered and non-lacquered films.

D.4.5 Introduction of the direct solar reflectance instead of the heat build up (HBU).

New threshold 18% (instead former 66 °C).

Classification (acc. former tab. D-2) is deleted.

In this context: Revision of P.3.21 “testing of coloured surfaces”.

D.4.6 Resistance to artificial weathering – separate requirements according to the damaging mechanism of the surface.

D.5.1 Type test – subclause b) New requirement added for lacquered films.

Appendix D Adhesives

E.1 - Scope defined more accurate

Appendix F Lamination process

F.4.8 Characteristics of laminated profiles – test requirement “dimensions of layers” is deleted.

F.5.1 Type test for laminating companies – Table F-1: The aspect “dimensions” is deleted.

Appendix P Test methods

P.2.2 Indicating the results defined more accurate. See also requirements for test reports.

P.3.ff Dated reference to standards deleted. Always the most current version of the test procedure is valid.

Some test procedures are defined more accurate.

Several sections of “the test report must include” are revised.

P.3.14 Samples must be broken max. 72 hrs after welding. The test body is responsible for preparation (cutting and welding) the specimen (footnote 1 in Table A-11 deleted).

P.3.21 Introduction of the direct solar reflectance instead of the heat build up (HBU). Several modification in the text.