



Turn-only hardware
and
Tilt and turn hardware

Quality assurance

RAL-GZ 607/3

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Preface

The quality assurance of turn-only hardware and tilt and turn hardware has been a voluntary commitment to the quality and further development of these fittings products since 1983. This is proven and demonstrated by the familiar quality mark. The quality and test procedures have been the standard for functioning, lasting and reliable turn-only hardware and tilt and turn hardware since this time.

The revised quality and test procedures in RAL-RG 607/3 take particular note of the European standards on windows and doors (EN 1191) and the corresponding fittings (EN 13126-8) that have now been published. These are the main basis.

These voluntary quality and test procedures go beyond the predefinition of the basic European standards with additional quality requirements and should further highlight the particular quality of the turn-only hardware and tilt and turn hardware. The RAL quality mark can thus only be achieved by a manufacturer who meets the quality requirements set here from the design through to the production.

The requirements included in these quality and test procedures essentially apply independent of any materials.

These new quality and test procedure replace the following regulation:

RAL-RG 607/3 (1995-02) Turn-only hardware and tilt and turn hardware

The Gütegemeinschaft Schlösser und Beschläge e.V. thus creates the preconditions for the successful continuation of the RAL quality assurance of turn-only hardware and tilt and turn hardware.



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1 Scope

These quality and test procedures specify the preconditions and methods for the quality assurance of fittings in accordance with EN 13126-8 taking EN 1191 into account.

The properties of the fittings proven in the initial test are permanently ensured through the implementation and application of the specified measures and tests. The specified requirements go beyond the procedures required in EN 13126-8 and EN 1191 and thus represent a further quality characteristic. This is documented by the marking of the fittings with the RAL quality mark.

These quality and test procedures specify material-independent and material-specific performance features for turn-only hardware and tilt and turn hardware and the quality-determining requirements to ensure the fitness for use, here essentially the permanent functional capability. The manufacturer's product information must be taken into account, in particular the prescribed maintenance, care and service.

The definitions and predefinitions of the guidelines of the Gütegemeinschaft Schlösser und Beschläge e.V. listed below also apply and must be observed.

- § TBDK Fastening load-bearing parts of turn-only hardware and tilt and turn opening fittings
- § VHBH Fittings for windows and French windows: Specifications/Notes on product and liability
- § VHBH Fittings for windows and French windows: Specifications/Notes for final users

These quality and test procedures create a basic requirement for an exchangeability of fittings in structural elements according to EN 14351-1. Further notes on the exchangeability of fittings are listed in Appendix 1.

2 Fundamentals of quality assurance

2.1 Basics

As a basis for the quality assurance, the manufacturer must prove the suitability of the fittings which he produces and submits for the quality assurance through a proof of suitability from a test centre accredited according to DIN EN ISO / IEC 17025 and approved by the Gütegemeinschaft Schlösser und Beschläge e.V.

2.2 Elements of the proof of suitability

- § Test reports according to EN 13126-8 and EN 1191 or alternatively according to the combination test listed in Appendix 2 and a confirmation of the threshold value of 350 N for the bearing capacity of the safety device according to EN 14351-1, issued by a test centre accredited according to DIN EN ISO / IEC 17025 and approved by the Gütegemeinschaft Schlösser und Beschläge e.V.
- § Product documentation with application diagrams for the planned use an/or application (designs, leaf weights, sizes, frame material) of the fittings.
- § A documentation of the in-house production control to be performed (self monitoring).

3 Initial testing, quality mark

3.1 Initial testing

Within the scope of the initial testing for a fittings system, proofs in accordance with EN 13126-8 and EN 1191 or alternatively in accordance with the combination test listed in Appendix 2 as well as a confirmation of the threshold value of 350 N for the bearing capacity of the safety device according to EN 14351-1, issued by a test centre accredited according to DIN EN ISO / IEC 17025 and approved by the Gütegemeinschaft Schlösser und Beschläge e.V. must be submitted. All proofs must hereby be achieved with the maximum leaf weight specified by the fittings manufacturer and the corresponding test formats specified in EN 13126-8. The proof of the mechanical strength of the bearing parts, the minimum strength of the control mechanism and the proof of the corrosion resistance according to EN 13126-8 must also be demonstrated during the execution of the combination test .

3.2 Quality mark

The fittings manufacturer can submit the proofs of the quality committee when applying for a quality mark. This suggests to the Executive Board of the Gütegemeinschaft Schlösser und Beschläge e.V. that the quality mark be awarded. The regulations specified by the Gütegemeinschaft Schlösser und Beschläge e.V. for the supervision (see under 5) must be observed by the manufacturer.

4 Initial visit

The initial visit serves to determine the personnel and manufacturing preconditions for the production of fittings in accordance with EN 13126-8 on the basis of these quality and test procedures. The initial visit by the testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. includes an assessment of the existing in-house production control. The initial supervision always involves an initial visit.

5 Supervision

5.1 Self monitoring – in-house production control

5.1.1 General remarks

The fittings manufacturer agrees to introduce a system for in-house production controls that ensures the constant properties of the fittings. He must appoint an employee responsible for quality assurance who has the corresponding powers, knowledge and experience in the manufacturing process for the fittings. This employee is responsible for the correct execution of the in-house production controls.

If the in-house production control discovers inadmissible deviations, the in-house production control officer must immediately initiate measures to eliminate the deviations or defects.

The following tests must be performed within the scope of the in-house production control:

- § Incoming goods inspection,
- § Production control,
- § Testing the marking.

Suitable facilities and equipment must be available to perform the in-house production control. The AQL value 1.5 in the random sample S2 of ISO 2859-1 or alternatively suitable measures to ensure AQL 1.5 applies for the number of samples.

5.1.2 Incoming goods inspection

The following points must be observed for the incoming goods inspection area:

- § Receiving inspection of the materials
- § Strength tests (corner bearing/stay arm bearing/gear),
- § Test of the structural elements for dimensional accuracy,
- § Smooth running of the gear/corner guides.

Certificates of conformity according to EN 10204, at least according to Section 2.1, or inspection certificates according to EN 10204, Section 3.1 are allowed.

5.1.3 Production control

Production control serves to ensure the constant properties of the fittings. The AQL value 1.5 in the random sample S2 of ISO 2859-1 or alternatively suitable measures to ensure AQL 1.5 applies for the number of samples 1.5.

The following points must be observed for the production control area:

- § Strength tests (corner bearing/stay arm bearing/gear),
- § Test of the structural elements for dimensional accuracy,
- § Smooth running of the gear/corner guides.

5.1.3.1 Permanent function test

The permanent function test should be carried out and documented at least once a year. The requirements of EN 13126-8, Section 7.3 or 7.4 and of EN 1191 or alternatively the combination test according to Appendix 2 must be met. The combination test can be performed on a test body with seals. In this case the seal used must generate a counterforce of at least 20 N for each locking point.

5.1.3.2 Corrosion protection

The fulfilment of the requirements on corrosion protection according to EN 13126-8 Section 5.7 must be proven at least every 3 months by corrosion tests or the corresponding stipulations in 5.1.2.

5.1.4 Testing the marking

The marking must be carried out in accordance with EN 13126-1 Section 9.

5.1.5 Overview of self monitoring

Self monitoring			
Test	corresponds to	Number	Test interval
Incoming goods inspection	5.1.2	AQL 1.5 or suitable measure to ensure AQL 1.5	
Production control	5.1.3		
Permanent function test	5.1.3.1	All fittings within the scope of the quality mark	At least once a year
Corrosion protection	5.1.3.2	All fittings within the scope of the quality mark	Quarterly (or proof according to 5.1.2)
Marking	5.1.4	----	

5.2 External control – regular test

5.2.1 Interval and content

The external control through a regular visit on site is carried out twice a year in the supervised location (production plant or sales organisation) by a testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V.

In the case of manufacturers who have a certified QM system according to the standards series EN ISO 9001:2000, the regular visit need only be carried out once a year and includes:

- § Check of the in-house production control
- § Check of the personnel and manufacturing preconditions
- § Check of the measuring equipment used for obvious defects and the presence of valid calibration certificates and service reports for the measuring equipment. The inspections of the measuring equipment must be documented.
- § Check of the procedure for recording and processing customer complaints

5.2.2 Sampling

Random, representative storage locations in current production or the stores are checked during each regular test and tested in accordance with EN 13126-8 Section 5.2.2. It must be ensured that sampling is possible on the day of the regular test. If in exceptional cases sampling is not possible for production technology reasons on the day of the regular test, the manufacturer must take samples from the next current production and send these to the testing centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. The samples should then be clearly identified with the abbreviation of the employee responsible for the selection. During the next regular test, however, sampling must be carried out from current production and the stores.

5.2.3 Supervision report

A supervision report is drawn up on the results of the regular test. If one or more measured values are outside the set limits, the cause of this deviation must be identified and rectified at short notice. Following rectification of the defect the testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. decides whether further quality-assurance measures (e.g. a special test) are necessary. The testing and monitoring centre reports on the external controls in the quality committee. The test reports themselves are not published for competition reasons.

5.2.4 Rectification of defects – special test

Special tests may be necessary due to:

- § a negative assessment of a regular visit or
- § the receipt of complaints from the market as regards the quality-marked products

5.2.5 Deadline for the rectification of defects

The period set for the rectification of defects discovered during the regular test should not normally be longer than one month. The period set to rectify defects discovered during special tests is 3 months.

5.3 Repeat test – validity of the quality mark

The quality mark is initially valid for a period of 5 years. Proofs to the same extent as the initial tests (please refer to Point 3.1) have to be rendered after this period within the scope of repeat tests if the manufacturer wishes to retain the quality mark.

If the repeat tests or parts thereof are not passed after 5 years, the manufacturer must immediately initiate corrective measures that are suitable to achieve the proofs. The procedure is analogous to that described in 5.2.5. The testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. specifies the period until a renewed repeat test.

If the evidence of conformity can be proven without problems during renewed repeat tests after the set period, the quality mark is valid for a further 5 years until the next repeat test.

6 Marking with the quality mark

6.1 Marking of turn-only hardware and tilt and turn opening fittings

Turn-only hardware and tilt and turn hardware that comply with these quality and test procedures can be identified with the quality mark of the Gütegemeinschaft Schlösser und Beschläge e.V.

6.2 Using the quality mark

The implementing rules for the award and use of the locks and fittings quality mark according to Appendix 4 apply exclusively for the use of the quality mark.



7 Changes

Changes to these quality and test procedures require the written approval of RAL. They only come into force after a suitable period following notification of the quality mark users by the Executive Board.

Appendix 1 – Exchangeability of fittings

Rules on the exchangeability of fittings systems in structural elements according to EN 14351-1 certified in accordance with this program

ser. no.	Property	Rules	Exchangeability
1	Resistance to wind load	Comparative test on calibrated test bench; Test format according to original initial type test (ITT)	yes, with positive results; equivalent or better class
2	Resistance to snow load	not present	no
3	Fire behaviour	not present	no
4	Protection against fire from outside	not present	no
5	Watertightness under heavy rain	Comparative test on calibrated test bench; Test format according to original initial type test (ITT)	yes, with positive results; equivalent or better class
6	Hazardous substances	not present	no
7	Shock resistance	Comparative test on test bench; Test format according to original initial type test (ITT)	yes, with positive results; equivalent or better class
8	Bearing capacity of safety devices	Comparative test	yes, with positive results
9	Ability to release	not present	no
10	Sound insulation	yes taking into account ser. no. 13	yes
11	Coefficient of thermal transmission	no effect	yes
12	Radiation properties	no effect	yes
13	Air permeability	Comparative test on calibrated test bench; Test format according to original initial type test (ITT)	yes, with positive results; equivalent or better class
14	Operating forces	Comparative test with calibrated test equipment; Test format according to original initial type test (ITT)	yes, with positive results; equivalent or better class
15	Mechanical strength	yes	with comparable fastening of the load-bearing fittings parts
16	Ventilation	no effect	yes
17	Bullet resistance	not present	no
18	Explosives resistance	not present	no
19	Permanent function	yes	yes, see Appendix 3
20	Differential climate behaviour	no effect	yes
21	Forced entry resistance	not present	no

The assessment of the results, the exchangeability and their use within the scope of EN 14351-1 lies within the responsibility of the window manufacturer and/or in the terms of contract of the system manager in the case of shared- or cascading-systems.

Appendix 2 – Combination test EN 13126-8 and EN 1191

A.1. General predefinitions

- § The test element should be mounted in the surrounding frame as is normal in everyday practice. (5-10 mm air all round between frame and case; compression-proof backing in the area of the fastenings. Fastening points normally 150 mm from the corners; Further bolted connection points usually at intervals of 400 – 600 mm),
- § Fastening of the structural element to the test bench by means of a surrounding frame of metal (e.g. steel or aluminium),
- § Test formats according to the predefinitions in EN 13126-8, Section 5.1,
- § Test with the maximum leaf weight specified by the fittings manufacturer,
- § Wood, PVC, aluminium or a combination of these materials are used for the test body. The fastening system should be determined and documented according to the material,
- § The leaf weight is adjusted by fitting a correspondingly heavy block set glazing according to the rules. Alternatively, a sufficiently rigid timber, plastic, steel or composite timber board with additional weights according to EN 13126-8 can be used,
- § The test is carried out on a test body without seals according to the predefinitions of EN 13126-8 with a counterforce of 20 N for each locking point.
- § The reference speed is determined at the closing edge of each leaf (leaf groove).

A.2. Test procedure for turn-and-tilt as well as tilt and turn hardware

Preparation of the test body, performance of the measurements and documentation according to EN 13126-8 and EN 1191.

Depending on the switching rhythm of the fitting being tested, the turn-and-tilt or tilt-and-turn opening cycles are carried out according to **A.2.1** or **A.2.2**.

A.2.1. 15,000 turn-and-tilt cycles (for turn-and-tilt opening fittings)

The cycles are to be carried out as follows for fittings with the switching rhythm „turn-and-tilt “:

- § **Start of a cycle:** The starting position is the closed position,
- § turn the fitting into the tilt position,
- § open the leaf in the direction of the tilt position*,
- § reach the tilt final position with 0.5 m/s*,
- § close the leaf from the tilt final position towards the closed position*,
- § reach the closed position with 0.5 m/s*,
- § turn the fitting into the closed position,
- § turn the fitting into the turn position,
- § open the leaf in the turn position (100 mm) according to the predefinitions in EN 13126-8,
- § close the leaf from the turn position (100 mm) towards the closed position according to the predefinitions in EN 13126-8,
- § reach the closed position according to the predefinitions in EN 13126-8,
- § **End of a cycle:** turn the fitting into the closed position,
- § Lubrication and adjustment according to EN 13126-8,
- § Assumption criteria according to EN 13126-8 and EN 1191.

A.2.2. 15,000 Tilt-and-turn cycles (for tilt and turn hardware)

The cycles are to be carried out as follows for fittings with the switching rhythm "tilt-and-turn" (also called "tilt before turn"):

- § **Start of a cycle:** The starting position is the closed position,
- § turn the fitting into the turn position,
- § open the leaf in the turn position (100 mm) according to the predefinitions in EN 13126-8,
- § close the leaf from the turn position (100 mm) towards the closed position according to the predefinitions in EN 13126-8,
- § reach the closed position according to the predefinitions in EN 13126-8,
- § turn the fitting into the closed position,
- § turn the fitting into the tilt position,
- § open the leaf in the direction of the tilt position*,
- § reach the tilt final position with 0.5 m/s*,
- § close the leaf from the tilt final position towards the closed position*,
- § reach the closed position with 0.5 m/s*,
- § **End of a cycle:** turn the fitting into the closed position,
- § Lubrication and adjustment according to EN 13126-8,
- § Assumption criteria according to EN 13126-8 and EN 1191.

A.2.3. 10,000 turning cycles (for turn-and-tilt as well as tilt and turn hardware)

The turning cycles are to be performed after the turn-and-tilt or tilt-and-turn cycles according to A.2.1 or A.2.2 as follows:

- § **Start of a cycle:** The starting position is the closed position of the leaf; the fitting is in the turn position,
- § open the leaf in the direction of the turn position*,
- § reach the 90° turn final position with 0.5 m/s*,
- § close the leaf from the turn final position towards the closed position*,
- § **End of a cycle:** reach the closed position with 0.5 m/s*,
- § Lubrication and adjustment according to EN 13126-8,
- § Assumption criteria according to EN 13126-8.

A.2.4. Additional tests according to EN 13126-8

All additional tests according to EN 13126-8 are to be performed after the turning cycles:

- § Test with additional load 1,000 N
- § Soffit test
- § Groove obstacle test

Assumption criteria in each case according to EN 13126-8.

A.3. Test procedure for turn-only hardware

Preparation of the test body, performance of the measurements and documentation according to EN 13126-8 and EN 1191

A.3.1. 25,000 turning cycles

- § the switchings at the fitting are to be carried out according to the predefinitions of EN 13126-8,
- § **Start of a cycle:** The starting position is the closed position of the leaf; the fitting is in the turn position,
- § open the leaf in the direction of the turn position*,
- § reach the 90° turn final position with 0.5 m/s*,
- § close the leaf from the turn final position towards the closed position*,
- § **End of a cycle:** reach the closed position with 0.5 m/s*,
- § Lubrication and adjustment according to EN 13126-8,
- § Assumption criteria according to EN 13126-8.

A.3.2. Additional tests according to EN 13126-8

Additional tests according to EN 13126-8 are to be performed after the turning cycles:

- § Test with additional load 1 000 N,
- § Soffit test,
- § Groove obstacle test,

Assumption criteria in each case according to EN 13126-8.

* Taking into account the tolerances and corresponding diagrams for the reference speed according to EN 1191.

Appendix 3 – Exchangeability in the permanent function property

Exchangeability of fittings in the permanent function property according to (Appendix 1, ser. no. 19)

- § The fittings systems must meet all of the requirements of the given certification program.
- § The fittings and fastening systems must be technically comparable*.
- § The performance features (permissible leaf weight and number of cycles) of the fittings system to be replaced must be at least equivalent to the fittings system used for the initial type test according to EN 14351-1.

An exchangeability of certified fittings systems is given if these rules for structural elements according to EN 14351-1, for which proof already exists according to EN 1191, are observed.

- * The technical comparability of fittings systems is understood as meaning the equivalence of certified fittings with respect to the intended purpose (plastic profiles and/or wooden profiles and/or aluminium profiles and/or mixed systems) and the maximum possible leaf weight. If equivalent values are available for both properties the technical comparability is given.

Appendix 4 – Implementing rules

for the award and use of the locks and fittings quality mark

A.4. Basis of quality

The basis of quality for the quality consists of the quality and test procedures for turn-only hardware and tilt and turn hardware RAL-RG 607/3. These may be supplemented and further developed to accommodate any technical progress.

A.5. Awarding the quality mark

The Gütegemeinschaft Schlösser und Beschläge e.V. grants manufacturers of turn-only hardware and tilt and turn hardware the right to use the locks and fittings quality mark on request.

The application should be sent in writing to the office of the Gütegemeinschaft Schlösser und Beschläge e.V.

The application will be considered by the quality committee. Samples of the manufacturer's products will be taken by a testing office accredited in accordance with DIN EN ISO / IEC 17025 and approved by the Gütegemeinschaft Schlösser und Beschläge e.V. and these will be tested in accordance with the quality and test procedures. It issues a test report on the test result that will be sent to the applicant and the managing director. The testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. may inspect the applicant's premises within the scope of an initial visit.

The costs of the tests will be borne by the applicant.

If the test is positive the Executive Board awards the applicant the quality mark at the suggestion of the quality committee. This award will be certified. If the test is negative the quality committee will defer the application. It must substantiate the deferral.

A.6. Use

Quality mark holders may only use the quality mark for products that comply with the quality and test procedures.

The Gütegemeinschaft alone is entitled to define the design and proportions of the quality mark and to notify the quality mark holder of these. The quality mark holder agrees to produce or have produced means of marking according to the specified instructions.

The Executive Board may issue special instruction for the use of the quality mark in advertising and joint advertising.

The quality committee can resolve that the quality mark be used in different ways for various product groups.

Quality mark holders who have had their quality mark withdrawn must return the award certificate. All means of marking for the quality mark must be withdrawn from use. The same applies if the right to use the quality mark otherwise expires.

A.7. Supervision

The Gütegemeinschaft is entitled and obliged to supervise quality mark holders to ensure that they observe the quality and test procedures.

Each quality mark holder himself must ensure that he complies with the quality and test procedures. He has a duty to carry out a statistical quality control. He must perform and record the self monitoring diligently. The testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. can inspect the records at any time. The quality mark holder subjects his products to the monitoring tests of the testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. He bears the costs of the tests.

The testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. can request or take samples at any time from the quality mark holder's premises. It can also take samples on the market or from buyers. Requested samples must be provided without delay. The testing and monitoring centre approved by the Gütegemeinschaft Schlösser und Beschläge e.V. can visit the factory at any time during normal working hours.

A report must be drawn up on every test result. The managing director of the Gütegemeinschaft and the quality mark holder each receive a copy.

If complaints are received about products bearing the quality mark the complaining party bears the costs of the tests should the complaint prove unjustified; if the complaint is justified the costs will be borne by the pertinent quality mark holder.

A.8. Penalty for infringements

The Executive Board can impose the following penalties on quality mark holders in the event of infringements:

- § An instruction will be issued for minor infringements. A minor infringement is given if certain existing regulations are violated but this has no direct effect on the operational safety of the turn-only hardware or turn-and-tilt opening fittings.
- § A warning and/or contract penalty will be pronounced for moderate infringements. A moderate infringement is given if certain existing regulations are violated and the operational safety of the turn-only hardware and tilt and turn opening fittings is reduced compared to the applicable regulation, but is not in principle called into question.
- § A quality mark will be withdrawn in the event of serious infringements. Serious infringements are given if certain existing regulations are fundamentally and negligently or deliberately violated so that the operational safety of the turn-only hardware and tilt and turn hardware is no longer given.

Quality mark holders who violate sections A.6 or A.7 may be warned.

A contract penalty up to 10,000 euros can be imposed in each single case instead of a warning. The contract penalty is due within 14 days after the notification has been served and has become incontestable, payable to the Gütegemeinschaft Schlösser und Beschläge e. V.

Warnings or contract penalties can be combined.

Quality mark holders who repeatedly or seriously violate Sections A.6 or A.7 will have their quality mark temporarily or permanently withdrawn. The same applies for quality mark holders who delay or hinder the tests.

The person concerned must be heard before any measures are taken.

In urgent cases the director of the Gütegemeinschaft Schlösser und Beschläge e.V. can temporarily withdraw the quality mark with immediate effect. This must be confirmed within 14 days by the Executive Board.

A.9. Complaints

Quality mark holders can lodge a complaint with the quality committee against penalty notifications within 4 weeks of their receipt.

If the quality committee rejects the complaint the complainant can appeal to a court of arbitration within 4 weeks of receipt of the notification. The corresponding section in the articles of incorporation of the Gütegemeinschaft applies in this case.

A.10. Reissue

Quality mark holders whose quality mark has been withdrawn can only get it back after three months at the earliest. The procedure is determined according to Section A.4. However, the Executive Board can impose additional conditions.

A.11. Changes

These implementing rules have been approved by RAL. Changes, including those of an editorial nature, require the prior written approval of RAL before they become effective. They only come into force after a suitable period following notification by the Executive Board.