A-Z – Guideline
of the Working Group Adhesive Bonding DIN 6701

Foreword

The A-Z Guideline is a compendium of the decisions of the “Working Group Adhesive BondingDIN 6701”. It complements the procedure for acquiring a certificate for carrying out adhesive bonding work on rail vehicles and parts of rail vehicles in accordance with DIN 6701-2 and contains supplementary definitions, temporary regulations, restrictions and interpretations relating to the DIN 6701 series of standards.

When certification bodies (recognised by the German Federal Railway Authority) certify user-companies in accordance with DIN 6701-2, it is mandatory to use the A-Z compendium.

The A-Z Guideline is managed and kept up to date by the working group. Applications for inclusion of items must be sent in written form to the secretary of the working group. (via the Notified Bodies or by email to 'eingabe@din6701.de')

Contents

Versions 2
1. Applications 3
2. Work specimens 3
3. Repairs/Maintenance 4
4. Supervision of bonding work 5
5. Classification 6
6. Personnel Qualification 6
7. Miscellaneous 7
8. Company audits 8

Appendix 1 – Application form 14
Appendix 2 – Certificate form 16
Appendix 3 – code table 18

Version

No. 51 (dated 2022-03-03)

Versions:

Changes since the last version are underlined. The dates the decisions were made and all changes are shown viathe version numbers. The version numbers correspond to the working group meetings.

Version	Meeting	Date	Version	Meeting	Date
1	1st Meeting	23.05.2006	35	35th Meeting	13.06.2016
2	2nd Meeting	26.07.2006	36	36th Meeting	02.12.2016
3	3nd Meeting	10.08.2006	37	37th Meeting	23.03.2017
4	4th Meeting	12.09.2006	38	38th Meeting	07.06.2017
5	5th Meeting	13.10.2006	39	39th Meeting	28.11.2017
6	6th Meeting	20.12.2006	40	40th Meeting	14.03.2018
7	7th Meeting	07.02.2007	41	41st Meeting	13.06.2018
8	8th Meeting	14.06.2007	42	42nd Meeting	22.11.2018
9	9th Meeting	10.12.2007	43	43rd Meeting	07.03.2019
10	10th Meeting	14.11.2008	44	44th Meeting	12.06.2019
11	11th Meeting	09.03.2009	-	45th Meeting	no revision
12	12th Meeting	08.06.2009	-	46th Meeting	no revision
13	13th Meeting	10.09.2009	47	47th Meeting	10.11.2020
14	14th Meeting	14.12.2009	48	48th Meeting	no revision
15	15th Meeting	15.03.2010	49	49th Meeting	28.06.2021
16	16th Meeting	12.07.2010	50	50th Meeting	09.11.2021
17	17th Meeting	20.09.2010	51	51st Meeting	03.03.2022
18	18th Meeting	13.12.2010			
19	19th Meeting	28.03.2011			
20	20th Meeting	19.09.2011			
--	21st Meeting	no revision			
22	22nd Meeting	16.04.2012			
23	23rd Meeting	10.09.2012			
24	24th Meeting	03.12.2012			
--	25th Meeting	no revision			
26	26th Meeting	03.09.2013			
27	27th Meeting	03.12.2013			
28	28th Meeting	06.03.2014			
29	29th Meeting	11.09.2014			
30	30th Meeting	27.11.2014			
31	31st Meeting	10.03.2015			
32	32nd Meeting	16.06.2015			
33	33rd Meeting	10.12.2015			
34	34th Meeting	01.03.2016			

Abbreviations

EBA	German Federal Railway Authority
SAB	Supervisor Adhesive Bonding (equivalent to Deputy of SiC)
SiC	Supervisor Adhesive Bonding in Charge
WG	Working Group Adhesive Bonding DIN 6701

1. Applications

1.1. Classification of safety pictograms

DIN 6701 applies. The SiC specifies a possible classification.

(Revision: 15)

1.2. Laminated safety glass

Other bonded joints and seals involving laminated safety glass are subject to the standard.

(Revision: 10, 11, 27, 30, 37)

1.3. FRP

DIN 6701 does not apply when a bonded part is wrapped by the laminate and all the forces are taken up by the laminate itself. If the laminate cannot take up all the forces by itself DIN6701 will apply.

(Revision 28, 37)

1.4. Bonded parts in pressure vessels area

Bonded parts at pressure vessels are subject to the standard DIN 6701.

(Revision: 40)

2. Work specimens

2.1 Organisations for testing bonded joints (Test labs)

Companies or laboratories who offer services for testing bonded joints, design validation, processing properties and process monitoring must demonstrate their suitability for thesetasks (e.g. a certificate of competence).

Note: With regards to demonstration of suitability, see also under “Miscellaneous: Externaltesting laboratories

(Revision 17, 22)

2.2. Work specimens for repair work

These work specimens are required. The nature and number of the work specimens aredetermined by the SiC.

The SiC decides where the specimen should cure/harden.

(Revision 14, 17, 37, 43)

3. Repairs/Maintenance

3.1. Maintenance

Maintenance in the sense of DIN6701 refers to components which have suffered damage inuse. According to the ECM guideline, this applies outside the warranty.

(Revision 36)

3.2. Repair carried out by the manufacturer after expiration of warranty

When carrying out repair work according to class A1 and A2, a bonding supervisor of at least level 2 is required on site.

(Revision 23, 28, 37)

3.3. Commissioning of third parties

For this scope, the bonding supervisor may supervise several sites.

The Safety Directive 2016/798 / EU stipulates the responsibility for the maintenance of theECM (the responsible maintenance body). The vehicle must be held by means of a maintenance system in a safe condition, that is, the ECM must ensure by methods and processes that the requirements of DIN670 are complied with.

The competences and responsibilities in the contractual relationship between the commissioning party (purchaser) and the commissioned third party must be clearly defined.

(Revision 7, 9, 37, 50)

3.4. Repair carried out by the manufacturer for warranty

When carrying out repair work according to class A1 and A2, a bonding supervisor of at least level 2 is required on site.

(Revision 7, 9, 16, 28, 37)

3.5. Transfer of a rail vehicle

Apart from the certified company, repair work to bonded joints is permissible to allowtemporary operability and ensure safe transfer of a rail vehicle to a certified site.

(Revision 22)

3.6. Change of adhesive system for repair compared to that indicated in the repair manual

The proof of equal safety must be provided in accordance with § 2 EBO.The operator/manufacturer of the vehicle is responsible. Relevant proof (calculations, drawings, work instructions, etc.) must be presented on request

(Revision 14)

3.7. Third parties contracted to undertake bonding work

Commissioned third parties who carry out repair work require SAB with qualification levels according to the new productionIn singular cases, repair work can also be carried out in company workplaces which are notcertified in accordance with DIN6701. In this case, the SiC of the commissioned third party must ensure that all conditions for undertaking the adhesive bonding work are met.

The personnel used to carry out the repair work must be qualified to at least level 3.

(Revision 7, 12, 20, 33, 37)

4. Supervision of bonding work

4.1. Change of SAB (person relinquishing the position of SAB)

If the requirements of DIN 6701 are no longer fulfilled, then within 1 month the company must submit a plan for supervising the adhesive bonding work in compliance with the standard.

(Revision 13, 43)

4.2. Qualifications of the SIC

For a transition period, persons who are undertaking EAE/EAS training can also be appointed as SiC if the training already has started by the time of the company audit.

If the training has not started by the time of the company audit and only a registration for EAE/EAS training was signed, the SiC must at least be qualified to level 2 (for requirementSiC level 1) or level 3 (for SiC level 2).

In this case, the period of validity of the certificate must be limited to this transition period,until the SiC is fully qualified.

(Revision 13, 15, 37)

4.3. Appointment of company owners, managing directors and production managers

Company owners, managing directors and production managers can be appointed as SIC in the areas of design, process planning, purchasing, trade and assemblyas well as commissioning of third parties for class A1.

The scope of repair is considered like production. In this case the restrictions apply forsmall-scale bonding work.

(Revision 39)

5. Classification

5.1. Bonded joints without safety requirements

Bonded joints without safety requirements are not subjected to the standard.

(Revision 7, 10, 22, 37)

6. Personnel Qualification

6.1. Recognition of the KGL qualification of the former GDR

Weeks 0 and I of the KGL training course qualifications are recognised as equivalent toqualification level 3 (EAB) for adhesive bonding with code F or L.

(Revision 8, 15, 20)

6.2. Supply of temporary workers (Employee leasing)

Temporary workers for bonding work (temporary employment) are subject to the same qualification requirements as permanent staff. Temporary employment is involved if the employee is subject to the hirer's right to issue instructions. Product liability in this case remains with the hirer. As soon as the product liability is taken over by an external companyfor which the employee works, it is a matter of commissioning a third party in accordance with DIN 6701-2.

(Revision 12, 47)

6.3. Extensive technical knowledge (Level 1: equivalent qualification)

Proof via a written and oral examination before an examination committee of the WG Composition of the examination committee: 3 representatives of the “Workgroup Adhesive Bonding DIN 6701” with assistance of the EBA.

(Revision 13, 20, 28)

6.4. Specific knowledge according DIN 6701-2:2015 table 3

The footnote “d” of table 3 of DIN 6701-2:2015 (or proof of specific knowledge) is specifiedby: ”or comparable specific *technical* knowledge” (corresponds to qualification level 2 according table 1 of DIN 6701-2:2015).

For the area of application 4 (purchasing, trading and assembly) following is valid for the Deputy of SiC for class A1 and A2: if constant availability of SIC is required, otherwise a non-equal authorized Deputy without adhesive bonding related qualification level is possible, which ensures that no bonding decisions are made during the absence of the SiC.

This regulation has to be implemented by the companies until 30 September 2018.

(Revision 36)

6.5. Qualification of the Deputy SiC in case of commissioning of third parties

A deputy without adhesive bonding qualification can be appointed in the scope of

commissioning of third parties if it is ensured that the SiC is involved in the commissioning and the SiC is present at the execution.

(Revision 41, 42)

6.6 Recognition of the DVS Adhesive Bonding Technologist as SAB Level 1

A DVS bonding technologist according to DVS 3304 is considered as a comparable qualification for a SAB level 1, but without the competence in the process step of design for bonded components of class A1.

(Revision 51)

7. Miscellaneous

7.1. Design and production documentation

Design and production documents (e.g. drawings, orders for parts) for the parts / railvehicles in the production must comply with DIN 6701.

(Revision 19)

7.2. Handling materials containing silicone

In areas where classified adhesive joints are made, only pasty silicone adhesives, lubricants and sealants as well as cured silicone materials are permitted if it can be ensured that there is no risk of carry-over.

(Revision 20)

7.3. Silicone-free release agents

Silicone-free release agents, such as Teflon spray, are only permitted if a risk of carry-over into the bonding area can be excluded.

(Revision 22)

7.4. Release procedure concerning adhesive bonding

A class assignment on the drawing is suffices. The release must be recorded (for example electronically). It must be ensured that subsequent releasers (e.g. design department) confirm the decision.

(Revision 19)

7.5. Certification of adhesive manufacturers

A certification within the scope of design is necessary for adhesive manufacturers who design the bonded joint for a user-company and carry out the approval of the joint dimensions.

(Revision 17, 37)

7.6. Contract Review

In the case that it is not evident if DIN 6701 must be fulfilled, the contractual partners haveto determine whether this is the case or not.

(Revision 30)

7.7. External test laboratories

If no official certificate of competence is available, the user-company must check the following criteria when commissioning a test laboratory to test bonded joints of classes A1and A2:

- Personnel (organisation structure / responsibilities of those undertaking the testing work / certification of personnel operating testing equipment, certification in the areaof adhesive bonding (e.g. for own specimen preparation))
- Testing equipment (regular monitoring, testing using own and other guidelines, reportpreparation, traceability of the data)
- Workplace conditions (cleanliness, climate, limitations on access)
- Management of samples and products that are provided.

(Revision 22)

7.8. Standard correction DIN 6701-3

The title of Chapter A 3.4 of DIN 6701-3:2015 reads correctly: "Compression test for Determination of the adhesive behavior under compressive stress". The current heading is incorrect and identical to the heading of Chapter A 3.5.

(Revision 44)

7.9. Further training of the bonding personnel

As a guideline for continuous further training, the personnel carrying out the bonding process should be able to prove that they have completed 4 h to 8 h and supervisory personnel 8 h to 16 h. The complexity of the tasks, the responsibilities of the personnel in the bonding process and the scope of application should to be considered.
The date, duration, content and instructor must be verified.

(Revision 50)

8. Company audits / certification

8.1. Version of standard used for certification

The standards series DIN 6701-2, -3, -4 in the version 12/2015 applies.

(Revision: 34, 35, 37, 47)

8.2. Application for issue of a certificate

For the homologation and surveillance an application as shown in Annex 1 (changed) isneeded, together with a business description.

The certification body has to check that the application complies with the requirements of DIN 6701.

(Revision: 8, 20, 27, 29, 31, 33, 34, 35, 37)

8.3. Example of a bonded joint

During company audits in the areas of production and repair, companies must manufacture or repair at least one bonded joint of the applied class. This shall be agreed with the certification body in advance. When commissioning third parties, sample bonding may be waived at the discretion of the certification body.

(Revision: 26, 31, 32, 37, 42)

8.4. Scope of the company audit

For company audits, the quality requirements on user-companies must be reviewed usingTable “Tasks” of DIN 6701-2.

Company audits will be carried out randomly on selected applications or processes.

The scope of a company audit may include:

- Details on the application for certification and company description
- Knowledge and understanding of generally accepted engineering practice (DIN 6701, other standards, guidelines, and technical bulletins);
- Company organization, authorities, responsibilities, rules for deputizing;
- Technical discussions with SAB, qualifications of the employees, training;
- Specifications, list of requirements, purchasing, sales, contracting third parties;
- Classification, design, sizing, project planning, planning documentation and verification;
- Production, repairs/maintenance;
- Production conditions, workspace;
- Storage and logistics, incoming goods inspection;
- Production documents, work instructions;
- Quality assurance, testing, work specimens;
- Traceability,
- Measuring equipment monitoring.

(Revision: 5, 15, 26, 33, 37)

8.5. Surveillance

During the term of validity of the certificate the certification body supervises the company.

During the term of validity of the certificate, a minimum of one surveillance audit by the certification body is obligatory. In some cases, additional monitoring may be undertaken.

(Revision: 6, 31)

8.6. Surveillance audit

The execution of a surveillance audit has the same quality standards as the

certificationaudit, although it usually takes only half the time.

The company bears the costs of the monitoring audit in accordance with the relevant fees of the certification body.

(Revision: 7)

8.7. Reports

The certification body is obliged to forward the audit reports to the company and the EBA.The forwarding of partial or incomplete reports is not permitted, neither is the passing of reports to non-authorized third parties.

(Revision: 7)

8.8. Details on the certificate

The details on the certificate must correspond to those given on the sample certificate inAnnex 2 (changed).

(Revision: 8, 15, 20, 22, 26, 31, 32, 33, 36, 37)

8.9. Validity of the certificate

The certificate is valid for the site of the user-company, the scope (class and code),specified supervisors and is bound by any restrictions on the certification.

The certificate is valid for a maximum of three years. (See also 8.15).

In reasoned cases, the certification body can make the validity of the certificate subject to different requirements (e.g. use of other SAB, other testing, use of other personnel to undertake the bonding work, additional quality assurance tests, production monitored by thecertification body).

(Revision: 26, 49)

8.10. Scope of validity

Within the certified classes (A1, A2, A3), unless otherwise indicated on the certificate, the scope of validity is not restricted to certain assemblies or parts.

The specification of the scope of validity must be entered in accordance with the code table(see Annex 3).

(Revision: 8, 15, 37)

8.11. Changes during the period of validity

The certification body must be informed immediately if there is a change to the company address, class of certificate, SAB and deliberate change or addition to the “main function ofthe bonded joint”. After the certification body checks the situation, the certificate is changedaccordingly.

The certification body must be informed if there is a change or addition to any of the areas for which the certificate is valid: “pre-treatment methods”, “production processes”, “test methods”, “degree of mechanisation” and if there are changes to main processes. The certification body decides whether to check the changes on-site and whether it is necessaryto change the certificate.

(Revision: 8, 22)

8.12. Revoking certificates

The certification body can revoke a certificate if:

- there are serious shortcomings, which are not immediately rectified, in the execution of the adhesive bonding work that falls under the DIN 6701 series of standards;
- there are serious shortcomings with the supervision of the adhesive bonding work that falls under DIN 6701;
- an appointed SiC is no longer present/available;
- there is no valid proof of the qualifications of the personnel carrying out the adhesive bonding work as specified in DIN 6701;
- other requirements laid down in the DIN 6701 series of standards are no longer fulfilled;
- the period of validity has expired;
- the user-company resigns the certificate.

(Revision: 26)

8.13. Short form of the certificate (deed)

If desired a short form of the certificate will be issued to the company. This is only valid in conjunction with the certificate

(Revision: 8, 20)

8.14. Internet register

The certification bodies are obliged to keep details of the issued certificates in an online register (https://www.din6701.de). The certificates are automatically no longer displayed 90days after the expiry date (but are not deleted).

(Revision: 13, 37)

8.15. Audit adjournment

In principle, it is not possible to extend the validity of a certificate. In exceptional cases, if timely agreement of an audit date is not possible, a certificate can be extended for a maximum of 3 months without a company audit. The company is informed of this in writing. The new expiry date of the certificate must be entered in the online database. The validity ofthe new certificate shall be reduced by the amount of time overrun. The validity of two consecutive certificates is therefore six years.

(Revision: 13, 24, 49)

8.16. Waiting period

The issuer of this certificate can refuse to reissue a “certificate for bonding rail vehicles andparts of rail vehicles" to an applicant for a period of 2 – 5 years if:

1. The certification body, in relation to a company keeping an existing certificate or acquiring a new certificate, is deceived with false facts or with the distortion/concealment of real facts in order to suggest that the conditions for keepingor acquiring a certificate are satisfied by that company.

2. This is particularly the case if:
    a. a qualified SiC is no longer present;
    b. no valid proof of the qualifications of the people carrying out the adhesive bondingwork, in accordance with this standard, is available;
    c. this is not reported, so breaching the obligation to notify the certification body.
3. The length of the waiting period is subject in some cases to the decision of the EBAand the WG

The imposition of a waiting period is reported in writing to the applicant.

(Revision: 16, 28, 37)

8.17. Approved bonding areas

There must be a list of the bonding areas approved by the vKAP. The designation of theadhesive areas in the certificate is reserved to the recognized body.

(Revision: 37)

8.18. Number of auditors

For the following scope of combinations two auditors are mandatory for testing at initialcertification, recertification audits and extension audits:

- Production + construction, at class A1
- Repair + construction, for class A1

For all other combinations for bonding class A1, as well as for all scopes and their combinations of classes A2 and A3 one auditor is intended. For audits of companies withsmall-scale bonding work also one auditor is intended, regardless of the scope and class.In surveillance audits one auditor is provided in each case.

(Revision: 39)

8.19. Escalation in the event of failure to remedy deviations by the deadline

In the case of first certification and recertifications, certificates can be issued for a limited period of time to enable companies to obtain a certificate despite non-critical deviations. These non-critical deviations must then be implemented by the defined date; the certificatecan then be extended for the full term if the recheck of non-critical deviations is positive.

In the case of surveillance audit, the non-critical deviations must also be implemented bythe company accordingly. If the defined time to remedy these deviations is exceeded, theNotified Body is entitled to suspend the certificate or to shorten the duration of the certificate.

(Revision 47)

8.20 Submissions

Submissions on certifications or certification procedures (e.g. objections or complaints) aswell as on the decisions of the A-Z-Collection can be sent to the working group at the P.O.Box 'eingabe@din6701.de'.

(Revision 49)

8.21. Commissioning of third parties with services of the process steps design an process planning

The procurement of design services and process planning is assigned to the process step commissioning of third parties. The required specification for the commissioning of third parties is to be released by a SAB of the commissioning party. If further bonding-related services are subcontracted, the responsibilities are to be clearly regulated.

The adhesive bonding competence must also be demonstrated in accordance with the requirements of the standard if manufacturing or repair work is commissioned and the commissioning party having no own workshop or no own personnel capacities.

Adhesive bonding competence must also be demonstrated in accordance with the requirements of the standard if manufacturing or repair work is commissioned and the commissioning party does not have its own workshop or personnel capacities.

(Revision 51)

Appendix 1 – Application form

Application
for the issuance of a certificate for adhesive bonding of rail vehicles and parts in accordance with DIN 6701

For the attention of: *[Certification body]*

company:
street, no.:
ZIP code, town,
http://
contact:

phone:
fax.:
E-mail:

The application is being made for the productionfacility:
(only specify if different from above)street, no.:
ZIP code, town,

Application for certification for the following areas:		**class**
	Design of bonding	
	Process planning of bonding	
	Production of bonding	
	Repairworks of bonding	
	Purchasing, trading and assembly of work pieces with classified bonding joints	
	Third party contracting for bonding	

Application:

- ☐ First application
- ☐ Follow-up application (Recertification), expiry of current certificate on:
- ☐ Due to change of the following requirements:

Have you already been certified in accordance with DIN 6701 by another certification body?

- ☐ Yes (please state the certification body):
- ☐ No

Supervisor in charge of adhesive bonding work (SiC):

First name, name:
Date of birth:
E-Mail address and phone no. of SiC:
Qualification level of adhesive bonding:

- ☐ European adhesive engineer (EAE)
- ☐ European adhesive specialist (EAS)
- ☐ European adhesive bonder (EAB)
- ☐ none / under education / application for education is available
- ☐ _ the SiC is an „external“ person
  If the SiC is external: he is also supervisor in following companies/sites:

Deputy of the supervisor in charge of adhesive bonding work (First Deputy):

First name, name:
Date of birth:
E-Mail address and phone number of deputy:

- ☐ the deputy of the supervisor in charge of adhesive bonding has equal rights (otherwise „no equal rights“)

Qualification level of adhesive bonding:

- ☐ European adhesive engineer (EAE)
- ☐ European adhesive specialist (EAS)
- ☐ European adhesive bonder (EAB)
- ☐ none / under education / application for education is available
- ☐ _ the person supervising the adhesive bonding an „external“ person

If the deputy is external: he is also supervisor in following companies/sites:

The company
- declares to observe the standard series DIN 6701 and the applicable technological standards,
- agrees that details will be published in the online register DIN 6701 (company, scope of application, personnel information about SIC and SAB [name, birth date, qualification], remarks).
- accepts the rules of the working group bonding DIN 6701 (A-Z-Guideline),
- accepts the necessary surveillance by the certification body for the period of validity,

Declaration of liability of applicant
The application becomes contractually binding upon submittal of the completely signed and stamped application to the certification body. As from thereon, the certification body is regarded as being authorized to carry out all steps and procedures required for the certification in accordance with DIN 6701-2.

_____ _____

(Place, date) **(Stamp, name and signature of applicant**

Please enclose:
- General description of the company
- Organisational scheme (with identification of SiC’s position in the company)
- Description of adhesive bonding work (including assembly and classes)
- List of further supervisors for adhesive bonding technology (including their tasks and responsibilities)

Appendix 2 – Certificate form

Certification in accordance with DIN 6701 to demonstrate the suitability of the user-company for manufacturing adhesive bonds on rail vehicles and parts of rail vehicles	**Logo** **Certification body** **in accordance with DIN 6701**

The production facility at ***XXXX***

of the company ***XXXXX***

has been certified to carry out adhesive bonding work for

Class A(X)

in accordance with **DIN 6701-2, -3, -4:2015**

Area of validity

Main function of the bonded joints:

Pre-treatment methods*: *- Not applicable*

Production methods*: *XXX*

Test methods*: *XXX*

Degree of mechanization*: *XXX*

* From the code table in Annex 3 to the A-Z compendium

Supervisor in Charge (SiC): *XXXX*

Equally authorized deputy supervisor: *XXXX*

Other deputy supervisor: *XXXX*

Remarks: *- s. reverse*

Certification no.: *Certification body/6701/class/N,F/year/no*
Issued on: *dd/mm/yyyy*
Change on: *dd/mm/yyyy*
Valid until: *dd/mm/yyyy*

This document is only valid in combination with the actual registration of the certificate in the Online-Register

_____
(Head of certification body, name, signature and stamp)

Remarks

General Regulations

The new application has to be submitted to the certification body at least **two months** before the certificate expires ifthe suitability of the user-company shall be certificated furthermore.

Changes within the time of validity of the certificate

If the address of the user-company or company site, the class of the certificate, supervisors or the area of validity change, the certification body must be informed immediately. The certification body decides about the necessity of an inspection on the site and change of the certificate.

The certification body must be informed if there are changes or additions to main processes or to any of the areas for which the certificate is valid under “pretreatment methods”, “production processes”, “test methods” and “degree of mechanisation”. The certification body decides whether to check the changes on-site and whether it is necessary to change the certificate.

Withdrawal of the certification

Authority or the certification body can withdraw certification if:

1) There is a serious shortcoming in the execution of the adhesive bonding work as required by this standard;
2) There is a serious shortcoming in the supervision of the adhesive bonding work (except for part class A3) as required by this standard;
3) There is no authorised supervision of the adhesive bonding work;
4) The employees carrying out the adhesive bonding work at the practical level do not have valid qualification certificates as required by this standard;
5) Other conditions required by this standard are no longer fulfilled;
6) The period of validity has expired;
7) The user-company does not have certification.

The user company must confirm attention of the withdrawal in written form towards the certification body. The certification body has to inform the German railway authority EBA.

Distribution

1. Submitter (original)
2. EBA, German railway authority (copy)
3. Folder (copy)

Appendix 3 – Code table

Group	Description	Code
Main function	Force transfer using high-modulus adhesives	F
	Balancing of substrate deformation using low-modulus	D
	Sealing	S
	Bonding large areas (lamination)	L
	Others (please describe):	
Surface pre-treatment	Blasting	BL
	Etching, Anodisation	ET
	Plasma treatment (LP plasma, AP plasma, corona, flame	PL
	Laser treatment	LS
	Others (please describe):	
Production methods	Processing of solvent or water based systems (primers,	SO
	Processing of 2-C adhesives	TK
	Processing of 1-C moisture/humidity activated systems	HU
	Processing of heat-curing adhesives	HE
	Processing of hotmelt adhesives	HM
	Processing of radiation-curing adhesives	RA
	Processing of anaerobically curing adhesives	AN
	Lamination or processing of pressure sensitive adhesives	LA
	Others (please describe):	
Test methods	Destructive test methods	DT
	Non-destructive test methods	NDT
	Visible inspection (with test instructions)	VIS
	Application monitoring with electronic data processing	DC
	Tests with dynamic mechanic loads (fatigue)	CY
	Crash/impact tests	IM
	PhySiCal-chemical ageing tests (e. g. climate test, UV, salt,.)	PC
	Rheology measurements	RH
	Spectroscopic analyses (e. g. IR, UV-VIS, …)	RS
	Thermal analysis methods (DSC, DMA, TGA, etc.)	TA
	Wetting tests	WT
	Others (please describe):	
Mechanisation level	Fully mechanised/automated	VM
	Partly mechanised	TM
	Manual	M