

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS



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BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

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BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

CONTENTS

1	INTRODUCTION	4
2	PROCEDURE FOR OBTAINING A QUALITY DECLARATION	5
3	PERFORMANCE ON BASIS OF REQUIREMENTS OF THE BUILDINGS DECREE ...	5
4	TESTING AND CLASSIFICATION.....	5
5	PRODUCTION REQUIREMENTS	5
6	REQUIREMENTS FOR MATERIALS.....	5
7	GENERAL CONDITIONS.....	6
8	PROCESSING INSTRUCTIONS	6
9	TESTS.....	6
10	REQUIREMENTS WITH REGARD TO THE QUALITY SYSTEM.....	6
11	MARKING UNPROCESSED DOOR LEAFS.....	7
12	CONTROL BY SKH	7
13	LIST WITH DOCUMENTS REFERRED TO	8
	APPENDIX I SKH QUALITY DECLARATION	9

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

1 INTRODUCTION

1.1 General

This basis of assessment serves as a foundation for the SKH Quality Declaration for unprocessed door leafs.

1.2 Area of application

This basis of assessment and the SKH Quality Declarations pertain to unprocessed door leafs, for use in a utility purpose as specified in the Buildings Decree (BB Article 1.1). The unprocessed door leafs are used as the basis of wooden exterior doors as referred to in Assessment Directive 0803. If necessary, the area of application will be specified in more detail in the quality declaration, including any limitations and/or conditions of application.

An unprocessed door leaf means a semi-manufactured product from which, after further processing and/or finishing, a wooden exterior door can be made that satisfies the performance requirements of the Assessment Directive 0803.

The unprocessed door leafs can be divided into the following types:

- a. a solid unprocessed door leaf, composed of stiles and rails, whether or not with one or more light openings and possibly a panel construction;
- b. a flush, composed unprocessed door leaf, constructed of a framework of wood. The sections of the framework have a filling. Both sides of the framework with filling have covering. The doors have a provision for stabilisation and they possibly have a light opening;
- c. a plywood unprocessed door leaf, composed entirely from veneer, a flat-shaped stabilisation provision and whether or not with a light opening.

The unprocessed door leafs specified under a, b and c are not fully processed and/or finished and can serve as a basis for the KOMO® attest-with-product certificate AD 0803 'Wooden Exterior Doors'.

	UNPROCESSED DOOR LEAF
Milling for building hardware	Not permitted
Assembly of building hardware	N/A
Paint system	Not permitted
Milling	Not permitted
Assembly of beads	Permitted
Assembly of panels	Permitted
Supply of glass beads	Permitted
Milling recesses	Permitted
Transfer by means of processing instructions	Compulsory
Maintenance instructions	Permitted

The degree to which the unprocessed door leaf is pre-finished can vary and depends on the agreement between manufacturer and end processor.

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

2 PROCEDURE FOR OBTAINING A QUALITY DECLARATION

2.1 Start

The applicant for the quality declaration indicates which variants of the unprocessed door leafs that he manufactures must be included in the quality declaration. He supplies the necessary information for drawing up the technical specification. He indicates which statements in the SKH Quality Declaration must be included and provides substantiation for those statements. Chapters 3 and 4 indicate which statements must be included and which statements are optional.

2.2 Admission inspection

SKH examines whether the statements for inclusion in the quality declaration are consistent with the requirements as stated in chapters 3 and 4.

2.3 Assessment of the quality system of the applicant

SKH tests whether the applicant's quality system is consistent with chapter 10.

2.4 Issue of the quality declaration

The SKH Quality Declaration, in accordance with Appendix 1, is issued following successful completion of the admission test (2.2) and the assessment of the applicant's quality system (2.3).

2.5 External quality assurance

After the SKH Quality Declaration has been issued, SKH carries out controls as described in chapter 12.

3 PERFORMANCE ON BASIS OF REQUIREMENTS OF THE BUILDINGS DECREE

Unprocessed door leafs are not connected to the Building Act.

4 TESTING AND CLASSIFICATION

The table in chapter 9 shows which tests must be performed by the unprocessed door leaf manufacturer or end processor.

The testing and classification are in accordance with Assessment Directive 0803.

The unprocessed door leafs can additionally be marked with a burglary class if the section below is satisfied.

4.1 Burglar resistance (optional)

The SKH Quality Declaration optionally states the applicability of the burglar resistance class, as determined on the basis of testing by a recognised laboratory. The testing checks whether the stated performance, determined in accordance with NEN 5096, is correct.

The SKH Quality Declaration can state the class of burglar resistance. It is at least resistance class 2. With supplementary requirements in respect of the SKH Publication 98-08, extra processing instructions will have to be included in the SKH Quality Declaration.

5 PRODUCTION REQUIREMENTS

The production requirements are consistent with the requirements in the Assessment Directive 0803.

6 REQUIREMENTS FOR MATERIALS

The material requirements are consistent with the requirements in the Assessment Directive 0803.

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

7 GENERAL CONDITIONS

The company where the unprocessed door leafs are manufactured must provide all unprocessed door leafs that satisfy the technical specifications as determined in the quality declaration with an identification code in accordance with chapter 11 of this publication. For the other general conditions, the AD 0803 is applicable.

8 PROCESSING INSTRUCTIONS

Upon delivery of unprocessed door leafs, processing instructions in accordance with Appendix 2 must also be supplied. They must, in so far as applicable, include the following points:

- transport and storage;
- glazing;
- positioning, size and finish of recesses;
- supplementary conditions for burglar-resistant doors;
- repairs;
- application of paint system;
- repair of paint system;
- application of (safety) fittings.

9 TESTS

The testing programme of the unprocessed door leaf is shown in the table below:

EXTERIOR DOORS			
Tests in accordance with AD 0803	Manufacturer of unprocessed door leaf	Certificate holder of AD 0803	Remarks
Determination of stiffness and strength	X		
Shape stability	X		Concept I handled
Testing water tightness of glazing system		X	
Water tightness and air permeability of door and frame unit		X	
Detection of capillary seams	X	X	Concept I handled
Moisture penetration of stacking sill structure	X		Solid door Concept I handled
Quality of glue bonds	X		Flush door
Shock resistance of sheathing/filling	X		
Shrinkage and expansion in the sheathing	X		
Intruder resistance (optional)	X	X	Deviations from the SKH Publications 98-08 must be demonstrated by the relevant producer

10 REQUIREMENTS WITH REGARD TO THE QUALITY SYSTEM

For requirements with respect to the quality system, the AD 0803 is applicable.

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

11 MARKING UNPROCESSED DOOR LEAFS

Unprocessed door leafs must be given an identification code:

- SKH-Quality Declaration logo;
- certificate number: SKH-... ..;
- performance code according to the table below.



Position	Description	Explanation of code	
1	Suitable for burglar resistance;	0	No performance known
		2	Resistance class 2
		3	Resistance class 3
2	Shape stability class in accordance with NEN-EN 12219		NEN-EN 12219
		0	None
		1	0-8 mm
		2	0-4 mm
		3	0-2 mm

Example identification code:  SKH-000 00

→ Position 2 = Shape stability class

↓ ↓
Cert. no. Position 1 = Burglar resistance class

12 CONTROL BY SKH

SKH carries out controls, unannounced, 6 times a year to ascertain whether there is ongoing compliance with the technical specification, and to ascertain whether manufacturing complies with the specifications laid down by the manufacturer and agreed with SKH and whether the internal quality control system is functioning. At least once per year test samples are taken from production to verify the test results of the holder of the SKH Quality Declaration. The above-mentioned control frequency is permanently equal to the control frequency as specified in the AD 0803. The applicant's country will generally have to be safe in order for SKH to be able to carry out visits for checking purposes. In the event of negative travel advice, the country will not be visited but the unprocessed door leafs will be checked on arrival in the Netherlands.

SKH will make use of staff members with the education, knowledge and experience in accordance with the following table to inspect/audit and assess.

Certification staff	Level of education	Knowledge and experience
Assessor	Higher Vocational Education (HBO)	Constructional or equivalent Production and application of wooden exterior doors or equivalent
Auditor	Intermediate Vocational Education (MBO)	Production and application of wooden exterior doors or equivalent
Member with power of decision	Higher Vocational Education (HBO)	Management experience or equivalent Certification or equivalent Accreditation or equivalent

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

13 LIST WITH DOCUMENTS REFERRED TO

AD 0803	Wooden exterior doors
SKH-Publication 98-08	Intruder-resistant wooden façade elements
NEN 5096	Intruder resistance
NEN-EN 1121	Doors - Behaviour when installed between two sets of climatic conditions - Test method
NEN-EN 12219	Doors - Influences of climate - Requirements and classification

For the correct publication date of an Assessment Directive, please see the website of SBK: <http://www.bouwkwaliteit.nl>; for the correct date of the SKH Publication, please see the website of SKH: <http://www.skh.org>.

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

APPENDIX I SKH QUALITY DECLARATION

SKH

Visiting address:

'Het Cambium', Nieuwe Kanaal 9c, 6709 PA Wageningen, The Netherlands

Postal address:

PO Box 159, 6700 AD Wageningen, The Netherlands

Telephone: +31(0)317 45 34 25

Email: mail@skh.org

Fax: +31(0)317 41 26 10

Website: http://www.skh.org

SKH QUALITY DECLARATION

SKH

hereby declares that the unprocessed door leafs produced by

«Company name»

«address»

«postal code» «city/town»

satisfy the product description and product performance
given in Appendix 1 of this
SKH Quality Declaration.

With due observance of the processing instructions
included in Appendix 2 of this SKH Quality Declaration,
the unprocessed door leafs can be used
as basis of wooden exterior doors in accordance with the AD 0803
'Wooden exterior doors'.

The **Product name** are produced at «Company name».

SKH evaluates the Internal Quality Control System of the manufacturer
and takes samples for verification.

This SKH Quality Declaration is effective as of «Effectivedate» and
will only be revoked if it is proved that there is no longer compliance with
the product description and product performance
as specified in Appendix 1 of this
SKH Quality Declaration and laid down in the
SKH Basis for Assessment 001 dated **XXX**.

This SKH Quality Declaration consists
of **Number** pages including appendices.

Validity can be checked on <http://www.skh.org>.

On behalf of SKH:

Director

H.J.O. van Doorn

Number

Date

SKH-«certificate number»

«date»

This SKH Quality Declaration remains the property of SKH



BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

APPENDIX 1*

**BELONGING TO SKH QUALITY DECLARATION
'UNPROCESSED DOOR LEAFS', NUMBER **Number****

1 Versions

Unprocessed door leaves have a maximum height of @@ mm, a maximum width of @@ mm and a thickness of @@ mm

Unprocessed door leaves:

- a solid unprocessed door leaf, composed of stiles and rails, whether or not with one or more light openings and possibly a panel construction;
- a flush, composed unprocessed door leaf, constructed of a framework of wood. The sections of the framework have a filling. Both sides of the framework with filling have covering. The doors have a provision for stabilisation and they possibly have a light opening;
- a plywood unprocessed door leaf, composed entirely of veneer, a flat-shaped stabilisation provision and whether or not with a light opening.

2 Marking

Unprocessed door leaves must be given an identification code:

- SKH-Quality Declaration logo;
- certificate number: SKH-... ..;
- performance code according to the table below.



Position	Description	Explanation of code	
1	Suitable for burglar resistance;	0	No performance known
		2	Resistance class 2
		3	Resistance class 3
2	Shape stability class in accordance with NEN-EN 12219		NEN-EN 12219
		0	None
		1	0-8 mm
		2	0-4 mm
		3	0-2 mm

Example identification code:  SKH-000 00

 Position 2 = Shape stability class
 Cert. no. Position 1 = Burglar resistance class

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

APPENDIX 1*

BELONGING TO SKH QUALITY DECLARATION 'UNPROCESSED DOOR LEAFS', NUMBER **Number**

3 Supplementary specification for burglar resistance

Unprocessed door leafs for burglar-resistant wooden exterior doors are suitable for finishing in accordance with the AD 0803 and SKH Publication 98-08. If there are deviations from the SKH Publication 98-08, the burglar resistance must be proven. If supplementary requirements are made of the unprocessed door leafs, the processing instructions in Appendix 2 will be amended accordingly.

4 Performance on the basis of requirements in AD 0803

5.1 Strength and stiffness; AD 0803, Article 5.1

The door leaf can withstand, determined in accordance with section 10.1.1 of AD 0803, a breaking strain of > 10 kN. The permanent deformation is, determined in accordance with section 10.1.1 of AD 0803, < 0.3 mm.

5.2 Water tightness of joints between parts that make up a built-up sill construction; AD 0803 Article 5.2

The water tightness of the joints between the sections making up a built-up sill construction, determined in accordance with Article 10.2 of AD 0803, is water tight to a test pressure of 300 Pa.

5.3 Shape stability; AD 0803, Article 5.4

5.3.1 Shape stability under influence of moisture

The doors, determined in accordance with testing climate c of NEN-EN 1121, satisfy class 0, I, II or III in accordance with the table below.

Class	Requirements in mm as per NEN-EN 12219
0	None
I	0-8
II	0-4
III	0-2

5.4 Exclusion of moisture from outside; AD Article 5.5

Exclusion of moisture from outside has not been investigated.

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

APPENDIX 1*

BELONGING TO SKH QUALITY DECLARATION 'UNPROCESSED DOOR LEAFS', NUMBER **Number**

6 SUGGESTIONS FOR THE USER

6.1 When the unprocessed door leafs are delivered, inspect whether:

- that what was delivered is what was agreed on;
- the markings and the method of marking are correct;
- the products do not display visible defects as a result of transport and suchlike.

If it is decided to reject the doors on the basis of the above, contact must be made with:

«**Company name**»

and if necessary with:

SKH

'Het Cambium',

Nieuwe Kanaal 9c, 6709 PA Wageningen, The Netherlands

PO Box 159, 6700 AD Wageningen

Telephone: +31(0)317 45 34 25

Email: mail@skh.org

Fax: +31(0)317 41 26 10

Website: <http://www.skh.org>

6.2 SKH Quality Declaration

The manufacturer is obliged to ensure that the customer at work has a copy of the full quality declaration.

6.3 Application and use

The conditions of application in this SKH Quality Declaration must be complied with. The unprocessed door leafs are used as the basis of wooden exterior doors that are intended for (residential) building as (part of the) façade filling. The unprocessed door leafs do not have a load-bearing function and are not intended to contribute to the stability of the building construction. Use is further described in Appendix 2 Transport, storage and processing in accordance with the processing instructions that are included in this SKH Quality Declaration.

6.3 Validity check

Check whether the quality declaration is still valid: visit the SKH website:
<http://www.skh.org>

BASIS OF ASSESSMENT FOR UNPROCESSED DOOR LEAFS

APPENDIX 2*

**BELONGING TO SKH QUALITY DECLARATION
'UNPROCESSED DOOR LEAFS', NUMBER **Number****

1 Finishing the unprocessed door leaf

@@@

2 Transport and storage

During transport and during storage, the unprocessed door leafs must be protected sufficiently against weather influences, damage and suchlike and be so supported that no unacceptable deformation can occur. The storage area must have effective ventilation, so that the moisture content present in the doors is maintained.