

Company: Bodesa UAB, J.Basanavičiaus g. 166 LT-76123 Šiauliai, Lithuania.

Contact person: Ernestas Baruskas

Place and time: Remote audit via Teams. 10.11.2020 (10:00 – 12:00) and 11.11.2020 (10:00 – 12:00)

Auditor: Olavi Üits

Standards: EN 1279-1:2018; EN 1279-2:2018; EN 1279-3:2018; EN 1279-4:2018; EN1279-6:2018; EN 1279-5:2018; EN 13501-2: 2016;

Legislation: EU Regulation No 305/2011.

1. Technical description of product

The directory of applicable statutory and regulatory requirements	The directory of standards is established. Updates received from LSD. List of regulation is established 1IPR5. No changes in standards regarding IGU production.
Internal standards of company	The description of insulating glass unit's production is established. Standard IST4524122-3. <i>Remark 1: Will be updated in January 2021, some changes according to EN 1279-1:2018</i>
The technical documentation of production (drawings, technical specification and installation and maintain instruction)	Technical specification is accordance with AGC technical specification and is described on the Bodesa UAB website.

2. Control of documents

Control of documents required by the FPC system	Documents' control procedure is established. No changes.
Control of records	List of records is established. Nothing is disposed so far. 10 years is the required limit. No changes.

3. Responsibilities and tasks connected with FPC

Responsibilities connected with FPC	Organizational structure ATD19-25, 01.09.2020
Responsible persons for FPC	Direktor Edvinas Šima
The responsible person for all production stages	Production manager Mindaugas Štabokas.
The personnel experiences and training	1IPR1 personnel procedure. The training plan of personnel has established. Records of personnel trainings and table of skills are maintained. Each worker has training plan and records kept. Workers are given documentation to study and they must give an exam every year. No changes.

4. Design and development

Control the design and development	Sharing ITT system.
Design and development validation	ITT results of AGC and Glas Trösch are used.

5. Incoming material control

Specification of incoming components	Procedure of incoming raw material control is established. The company has got documents of conformity made available by suppliers (certificates, declarations of performance, data sheets etc.).
The inspection of purchased products	The instructions are available, and inspection is carried out before and during manufacturing process.
Evaluating and selecting of suppliers	List of approved suppliers is compiled. For glass suppliers the last evaluation is made in September 2020.

6. Production process control

The production provision and documentation, working instruction	The production provision is in accordance with technical description of insulating glass unit's production. The work instructions and tests instructions are available in every work station. No changes.
Identification and traceability of product	The products are identified and traceable throughout the manufacturing process. The half-finished materials as product are labelled. Traceability for all materials possible. No changes.
Control of subcontracting	Cutting of Pyrobel glass not possible.
Storage of product	Preservation of incoming and final products is performed in internal premises.
Customer property	Not used.

7. Monitoring and measurement

Establishing of test/measurement plan	Test/measurement plan according to EN1279-6 has established and followed. <i>Non-conformity 1: Comparison with the EN 1279 new 2018 versions should be documented and test/measurement plan revised.</i> There are some deviations from EN1279-6 but overall confidence is received that end products meet the requirements. The number of samples met the requirements. One overall product control report is made for each day. Product control is divided between two persons.
Product type testing	Product type testing regarding fire resistance has performed by accredited laboratory. The type tests of insulating glass according to EN 1279-3 and EN 1279-4 have been performed by accredited laboratory.
Monitoring during manufacturing process	The inspection and testing plan are established, and records kept.
Final monitoring of product criteria and documentation (conformity to standard requirements)	The verification is carried out on finished products also according to a frequency laid down in test/control plan.
Maintaining of monitoring and test results	Records of results of monitoring and test results are maintained.
Register of measuring testing equipment and calibration	The records of measuring equipment control are available. Measuring equipment is calibrated by AB Vilniaus Metrologijos Centras.
Inspection and maintenance of equipment	Inspection and maintenance of equipment are carried out and recorded in accordance with the manufacturer's written procedure.

	Maintenance instructions are available. Records of maintenance are kept.
--	--

8. Service provision control

Warranty terms	Warranty terms are written in maintenance instruction.
Marking	Product marking contains also the number of order – traceability.

9. Control of nonconforming product

Reclamations to suppliers	If nonconforming materials are detected during incoming material control, they are returned to supplier.
Non-complying products	The procedure of control of nonconforming product is established. Non-complying products are recorded as they occur, and records kept for the period defined in procedure. Corrective actions are recorded. Each glass unit line has its own pallet for non-conforming products. Non-complying products are registered in the work station where they are detected. Each non-conformity is analysed, and corrective actions taken. Overall cost of non-complying products is low.
Clients' complaints	The complaints of customers have been registered and records are kept for the period defined in procedure.
Recording of complaints	All complaints are recorded. All reclamations are analysed weekly.

10. Planning of the improvement actions, reviewing these actions and reviewing the effectiveness of the corrective actions taken

Management review	Carried out on annually.
Assessment of improvement actions	For non-complying products have applied the necessary corrective action.

11. Summary

BODESA UAB has working system of FPC. One nonconformity (*marked in red cursive*) were found. One remark was made (*marked in blue curisve*) and should also taken in consideration. Auditor suggests to issue the certificates provided the corrective actions are taken to eliminate discovered nonconformities.

The corrective action plan shall be sent to olavi.ueits@kiwa.com in 12.12.2020 at latest,

The next planned surveillance audit of FPC will be carried out in April 2021.

Report is drawn 12.11.2020

Report is drawn by:



Olavi Üits
Conformity Assessment Department