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Sales@ChineseStandard.net

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China Compulsory Certification Implementation Rules - Motor Vehicle Tires

强制性产品认证实施规则

机动车辆轮胎

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0 Introduction

This Rules is established based on the safety risk and certification risk of motor vehicle tires. It stipulates the basic principles and requirements for the implementation of China Compulsory Certification for motor vehicle tires.

This Rules can be used with other general rules issued by Certification and Accreditation Administration (CNCA), such as “China Compulsory Certification Implementation Rules - Manufacturing Enterprise Classification Management, Certification Mode Selection and Determination”, “China Compulsory Certification Implementation Rules - Utilization of Manufacturing Enterprise Test Resource and Other Certification Results”, “China Compulsory Certification Implementation Rules - Factory Inspection General Requirements”.

The certification body shall compile detailed rules for certification implementation according to the general implementation rules and this Rules and implement them accordingly.

The certification client shall be able to bear the related quality and legal responsibilities such as the recall, “three guarantees” of the certification entrusted product.

Manufacturing enterprise and importer shall ensure that their certified products produced or imported are capable of sustaining the compliance with the certification and are compatible with the requirements of the standards.

For China Compulsory Certification activities implemented in the ODM mode, it shall also comply with the relevant requirements of “Supplementary Provisions on the ODM Mode Involved in China Compulsory Certification Implementation Rules”.

1 Application scope

This Rules applies to new pneumatic tires for motor vehicles, including passenger car tires, truck tires, and motorcycle tires. Its original design is intended for motor vehicle tires used on motor vehicles of the M, N, O, and L categories (see GB/T15089 for the definition of vehicle category).

This Rules does not apply to retreaded tires and tires specifically designed for racing.

Due to the changes in the laws, regulations or related product standards, technology, industry policies and other causes which may change the applicable scope, the announcement released by CNCA shall be final and conclusive.

2 Certification basis

GB 9743 Passenger Car Tyres, GB 9744 Truck Tyres, and GB 518 Motorcycle Tyres.

In principle, the standards used for certification testing shall be the latest versions issued by the National Standardization Administration. When it is necessary to add new applicable standards or use other versions of the standards, it shall be executed according to the applicable relevant standards issued by the Certification and Accreditation Administration (CNCA).

3 Certification modes

The basic certification mode of implementing the China Compulsory Certification for motor vehicle tires is:

Enterprise quality assurance capability and product conformity inspection + type test + after-certification supervision;

Note: The quality assurance capability and product conformity inspection of motor vehicle tire products are carried out in accordance with the production conformity inspection method;

The “after-certification supervision” above refers to 1 or various combinations of the 3 modes – after-certification follow-up inspection, factory on-site sampling test, or sampling test in the market.

The certification body shall, in accordance with the requirements of “China Compulsory Certification Implementation Rules - Manufacturing Enterprise Classification Management, Certification Mode Selection and Determination”, implement classification management for manufacturing enterprises, and based on the results of classification management, add relevant elements such as production site sampling test or inspection, market sampling test or inspection, as appropriate on the basis of the basic certification mode to determine the certification mode that can be applied to the certification client.

4 Classification of certification units

In principle, products of the same producer (manufacturer), the same manufacturing enterprise (location), the same category [Note 1], the same structure [Note 2], and the same series [Note 3] are one certification unit.

The certification client shall put forward the certification entrusting based on the principle of unit classification.

Note 1: Category: passenger car tire, truck tire, motorcycle tire.

Note 2: Structure: radial, bias, bias belted.

Note 3: Series: Refer to product series specified by standards “Size designation, dimensions, inflation pressure and load capacity for passenger car tyres” (GB/T 2978), “Size designation, dimensions, inflation pressure and load capacity for truck tyres” (GB/T 2977), and “Series of motorcycle tyres” (GB/T 2983), and / or relevant industry technical documents.

5 Certification entrusting

The certification body shall, in accordance with the requirements of the “Compulsory Product Certification and Implementation Rules - Factory Quality Assurance Capability Requirements” and “China Compulsory Certification Implementation Rules - Factory Inspection General Requirements”, specify the enterprise quality assurance capability and product conformity control in the certification implementation detailed-rules.

The certification client and manufacturing enterprise shall establish, implement and continuously maintain their production conformity control system in accordance with the requirements of the attachment to this Rules to ensure that the certified products continuously satisfy product standards and certification requirements.

The certification body shall conduct a conformity check on the enterprise's production conformity control system, and the inspection shall cover the products entrusted for certification and their processing sites. If necessary, the certification body may conduct extended inspections at locations other than the manufacturing enterprise.

For certified producers / manufacturing enterprises, the certification body may appropriately adjust and simplify the timing and content of the enterprise's production conformity inspection and specify them in the certification implementation detailed-rules.

For certified producers / manufacturing enterprises, when re-locating or building a new manufacturing enterprise within the same producer, if it is declared that it complies with relevant laws and regulations, has a sound quality management system, and its products meet the standard requirements, the certification body may “issue the certificate first and then inspect the factory”. In principle, the enterprise quality assurance capability and product conformity inspection shall be completed within 3 months after the issuance of the certificate.

6.2 Type test

6.2.1 Type test plan

Certification body shall formulate the type test plan, after auditing the materials. And INFORM the certification client.

Type test plan includes all samples' requirements and quantity, test standard items, laboratory information, etc.

Type test samples shall be selected according to the most unfavorable conditions of the tire, and the certification body shall clearly specify the principles for judging the most unfavorable conditions in the certification implementation detailed-rules.

6.2.2 Sample requirements of type test

The certification body shall, according to the classification management of the manufacturing enterprise, specify the specific requirements for sampling / sample sending in the certification implementation detailed-rules. In general,

according to the requirements of certification body, samples of type test shall be submitted by the certification client with representative samples for test. When necessary, certification body may adopt on-site sampling/seal-samples method to obtain the samples.

The certification client shall ensure that the samples provided by it are normally produced and confirmed to be consistent with the actual products produced. The certification body and / or laboratory shall inspect the authenticity of the samples provided by the certification client. If laboratory has any doubt on the authenticity of the samples, it shall explain the situation to certification body and handle accordingly.

6.2.3 Type test items and requirements

The type test items shall comply with the requirements of the relevant clauses in the standards for certification and shall be determined by the certification body in conjunction with the laboratory based on the technical parameters of the product entrusted for certification.

6.2.4 Implementation of type test

The type test shall be performed after the certification body confirms that the entrusting materials submitted by the certification client meet the requirements and develops a test plan. The type test shall be completed in a laboratory designated by the Certification and Accreditation Administration (CNCA).

The laboratory shall conduct the type test to the samples. It shall be ensured that the test conclusions are true and correct. Laboratory shall integrally record the whole test and archive for retaining, so that the test process and results are traceable.

6.2.5 Type test report

Certification body shall specify a unified form of the type test report.

After the type test is completed, the laboratory shall, in time, provide the type test reports to certification body and certification client. The content shall be accurate, clear, and complete. The certification client shall ensure that it is able to provide the complete and valid type test report to the certification body and laws enforcement authorities during the after-certification supervision.

6.3 Certification evaluation and decision

The certification body shall conduct a comprehensive evaluation of the type test conclusions, the enterprise quality assurance capability, product conformity inspection conclusions and relevant materials / information, and make a certification decision. For those who meet the certification requirements, a certification certificate will be issued; for those who fail to meet the certification requirements, the certification commission will not be approved, and the certification will be terminated.

6.4 Time limit of the certification

The certification body shall formulate the specific contents and requirements of factory on-site sampling test in the certification implementation detailed-rules.

If the manufacturing enterprise is qualified with “China Compulsory Certification Implementation Rules - Utilization of Manufacturing Enterprise Testing Resource and Other Certification Results” and other testing conditions for certification standard requirements, then certification body can use the testing resources of the manufacturing enterprise to conduct the test and recognize the relevant results. If the manufacturing enterprise is not qualified with the above testing resources, samples shall be sent to the designated laboratory for testing. Certification body shall, in certification implementation detailed-rules, clearly specify the specific requirements and procedures for using the testing resources of the manufacturing enterprise to implement testing.

7.3 Market sampling test

If it adopts “market sampling test” to implement the supervision, the certification client, producer, and manufacturing enterprise shall cooperate; and confirm the samples that are sampled from market.

The certification body shall formulate the contents and requirements of market sampling test in the certification implementation detailed-rules. The certification body shall formulate the sampling test plan according to the product characteristics. Designated personnel will take samples from certified products in the market (including at whole-vehicle factory or at user-site etc.) according to sampling test plan.

7.4 Frequency and time of after-certification supervision

Based on manufacturing enterprise classification management, the certification body shall adopt different frequency of after-certification supervision to different types of manufacturing enterprises and reasonably determine the supervision time. Detailed principles shall be specified in the certification implementation detailed-rules.

7.5 Records of after-certification supervision

Certification body shall appropriately record and archive the whole process of after-certification supervision, so that the certification process and results are traceable.

7.6 Evaluation of after-certification supervision

The certification body shall comprehensively evaluate the conclusion of after-certification follow-up inspection, conclusion of sampling test, and relevant materials / information. If the evaluation is PASS, it may continue to maintain the certificate and use of certification mark. If the evaluation is Not-PASS, the certification body shall cancel / suspend / revoke the certificate according to the corresponding situations; and announce it publicly.

8 Certificate

8.1 Maintenance of the certificate

This Rules covers the 5 year valid period of product certificate. Within the valid period, the validity of the certificate is maintained by depending on the “after-certification supervision” of the certification body.

Before the certification is expired, if it needs to continue to use, the certification client shall put forward the certification entrusting within 90 days before the expiry date. If the newest “after-certification supervision”, within the certificate validity, is PASS, then certification body shall directly renew the certificate.

8.2 Contents and use of the certificate

The contents and use of the certification certificate shall comply with “China Compulsory Certification Management Regulations”, “Measures for the Management of Certification Certificates and Certification Marks” and “Compulsory Product Certification Certificate Management Requirements”. In accordance with the requirements of the certification standards, the contents of the certification certificate shall also include the tire specification mark, load index / level, speed symbol, a summary description of the pattern group and related pattern name / code (when applicable).

8.3 Change / extension of the certificate

After obtaining the certificate, when there is a change in the content of the certificate, main parameters or other matters specified by the certification body, or when the certification client needs to extend the product scope covered by the already obtained certificate, the certification client shall put forward a change / extension entrusting to the certification body. Only after the approval of the certification body may the change / extension be implemented.

The certification body shall, on the premise of controlling risks, clearly specify the change / extension requirements in certification implementation detailed-rules and conduct technical review, testing and / or inspection (when applicable) of the change / extension. The change / extension may only be approved after passing the evaluation.

Certification changes for some parameters can be approved by the certification technical person in charge of manufacturing enterprise confirmed by the certification body, and the corresponding records shall be kept and reported to the certification body for filing. The certification body shall clearly specify the scope of filing parameters and the requirements for the certification technical person in charge in the certification implementation detailed-rules, conduct verification during after-certification supervision, and carry out verification tests when necessary.

8.4 Certificate's cancellation, suspension and withdrawal

Certificate's suspension, cancellation and withdrawal shall be implemented in accordance with “China Compulsory Certification Management Regulations” and “Compulsory Product Certificate Cancellation, Suspension and Withdrawal Implementation Rules”, and relevant provisions of certification body.

of certification standards;

- c. Establish a documented procedure, to ensure proper storage and use of the CCC marks;
- d. Establish a documented procedure, to ensure that non-conforming products and certified products are not engraved with the CCC marks without being recognized by the certification body after the change.

The person in charge of quality shall have sufficient competence for the job. The person in charge of quality may also be the person in charge of certification technology.

2.2 Factory shall establish documented regulations, to ensure the consistency of mass-produced certified products and type test samples; to ensure the proper storage and use of certification marks.

2.3 Factory shall formulate the documentation provisions on necessary products that are to test, inspection, methods, frequency, deviation range, analysis of results, record and maintenance according to implementation rules. And identify the critical components, raw materials, critical manufacturing process, and testing process according to certification standard, and determine the control requirements.

The provisions shall include the content, methods, frequency, deviation range, recording methods and maintenance requirements of the test items (consistent with the type test items) and / or relevant inspections. For test items other than rolling resistance and relative grip performance on wet roads, at least each certified unit with production volume (ODM certificate and its initial certificate are deemed to be the same unit) shall be tested once within one year. The frequency of testing rolling resistance and relative grip performance on wet roads shall be based on different types of tires, and at least one pattern shall be selected for testing each year.

Note: Tires are divided into the following three types:

C1: Passenger car tires;

C2: Micro and light truck tires with single tire load index ≤ 121 and speed rating N or above;

C3: Micro and light truck tires with single tire load index ≤ 121 and speed rating M or below, or micro and light truck tires or truck tires with single tire load index > 121 .

For those critical components, raw materials, critical manufacturing process, testing process, and pattern design and change that are not conducted in the factory site, it shall be specifically listed out in plan. And explain the actual department and actual location of the control.

For items that are specified by production conformity plan in certification standard, the factory's control provisions must not be lower than the standard

requirements.

2.4 Factory shall formulate provisions and requirements on products test of relevant equipment and staffs in 2.3.

2.5 When the factory finds that there is a non-conformity in the product, the relevant provisions for it to conduct more inspections and take all necessary measures, so as to resume the production conformity as soon as possible.

2.6 When the factory finds that there is a non-conformity in the product, the provisions on the traceability and disposal measures adopted.

2.7 Documented provisions for product verification performed by the factory to ensure consistency of the mass-produced certified product's structure and technical parameters with qualified samples for type test.

3 Production conformity initial on-site inspection

Initial factory inspection is the inspection that is targeted to the factory and audited by certification body to determine the implementation situation of production conformity control document.

4 Performance report of production conformity control document

Performance report of production conformity control document is the file description about the performance of production conformity control document by the factory every year. The report shall describe item-by-item the efforts and important changes of production conformity control. For production inconformity, it needs to emphasize and describe the reasons, handling and traceable results, and the adopted corrections and preventive measures.

5 Supervision inspection of production conformity

Factory inspection team shall examine the implementation report and situation of production conformity control document, on site of the production conformity control, and according to requirements of certification body. During the supervision inspection, factory shall guarantee that:

5.1 Inspectors shall be able to obtain the experiment record and production record, during supervision inspection every time.

5.2 If the experiment condition is appropriate, inspector can choose samples randomly and make test in factory's laboratory. The experiment items and minimum quantity of samples can be made based on factory's self-inspection requirements.

5.3 If the level of control is unsatisfactory, or if the validity of the test contained in the production conformity control document independently performed by the manufacturing enterprise needs to be verified, after the approval of certification body, the inspectors shall take samples and send them to the testing body for test.

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Contact: Wayne Zheng, Sales@ChineseStandard.net

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