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China Compulsory Certification Implementation Detailed-Rules -

Tyre of Motor Vehicle

强制性产品认证实施细则

机动车辆轮胎

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China Quality Certification Centre

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0 Introduction

“China Compulsory Certification Implementation Detailed-Rules” (hereinafter referred to as Detailed-Rules) is compiled based on the requirements of “Implementation Rules for China Compulsory Certification - Tyre of Motor Vehicle” (CNCA-C12-01:2024) (hereinafter referred to as Implementation-Rules). This Detailed-Rules is used together with the Implementation-Rules as supportive document.

The product scope, certification basis of this Detailed-Rules shall comply with relevant provisions of the Implementation-Rules. It shall also be adjusted according to the Notices such as defined directory and directory adjustment that are issued by Certification and Accreditation Administration of China (hereafter referred to as CNCA).

According to the relevant requirements of the Implementation-Rules and quality manuals, procedure documents, work instructions, etc., of China Quality Certification Centre Co., Ltd. (hereinafter referred to as CQC), following the principles of maintaining the effectiveness of product certification, improving quality of product, serving certification companies, and controlling risk of certification, this Detailed-Rules is formulated and issued. Through establishing the classification management requirements of manufacturing enterprises, and combining the classification of manufacturing enterprises, this Detailed-Rules determines the implementation requirements for China Compulsory Certification of motor vehicle tyre products.

0.1 Definition

0.0.1 Testing at Manufacturer’s Premises (abbreviated as TMP mode)

It means that the engineers of designated laboratory use the testing equipment in the factory laboratory to conduct testing. The factory shall dispatch test personnel to provide assistance. The designated laboratory shall audit, approve and issue the test report.

0.1.2 Witnessed Manufacturer’s Testing (abbreviated as WMT mode)

It means that the engineer of designated laboratory witnesses the factory laboratory’s test conditions and all tests completed by using the laboratory’s equipment or according to the test plan submitted; or witnesses the partial test conditions and the test items. Test personnel of the factory laboratory shall provide the original records and draft up the test report together with the engineer of designated laboratory according to relevant provisions. The designated laboratory shall audit, approve and issue the test report.

0.2 Classification management requirements of manufacturing enterprises

CQC collects and sorts-out all the information related to certification products and quality related to manufacturing enterprises; and uses dynamic classification

CQC shall be based on the real-time collection of various types of quality information, according to the above classification principles, to determine the manufacturing enterprises' classification result (category).

CQC may re-determine the category of manufacturing enterprises regularly or irregularly according to the information collected, and carry out dynamic management. In case there is any change, the documents publicized by CQC shall prevail. In principle, the downgrade of enterprise category shall be adjusted according to the classification principles of manufacturing enterprises in Table 1, and the upgrade of enterprise category shall be gradually upgraded in the order of D-C-B-A. If necessary, it can be directly adjusted to the corresponding category after risk assessment.

0.3 Requirements for utilizing test resources of manufacturing enterprises

Applicable to after-certification supervision sampling test. Refer to the relevant public documents of CQC for the requirements for utilizing test resources of manufacturing enterprises for China Compulsory Certification of tyre products.

1 Application scope

This Detailed-Rules apply to new pneumatic tyres for motor vehicles, including passenger car tyres, truck tyres and motorcycle tyres. The original design was for motor vehicle tyres used in motor vehicles of M, N, O, and L categories (refer to GB/T 15089 for definition of vehicle categories).

This Detailed-Rules does not apply to retreaded tyres and tyres specifically designed for racing.

Scope adjustment due to change of relevant laws or regulations, relevant product standards, technologies and industry policies and other factors shall be subject to the notice issued by CNCA and CQC.

2 Terms and definitions

For the purpose of This Detailed-Rules, terms and definitions in the relevant regulations for China compulsory certification, as well as the following terms and definitions, apply.

2.1 ODM (Original Design Manufacturer)

A factory that designs, processes and produces the same products for one or more certification entrusting clients or producers (manufacturers) using the same quality assurance capability requirements, the same product design, production process control and inspection requirements.

2.2 ODM Initial Certification Certificate Holder

5 Division of certification units

In principle, the product produced by the same producer (manufacturer), by the same manufacturing enterprise (site), of the same category [Note 1], of the same structure [Note 2] and of the same series [Note 3] is deemed as one certification unit.

The certification entrusting client submits the certification application conforming to the certification unit classification principle.

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

Note 2: Structure: radial (including all-steel radial, semi-steel radial), diagonal, bias-belted.

Note 3: Series: product series specified in the 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.

The final result of unit division is to be confirmed by the CQC product certification engineer after specific review of each product information. If necessary, the certification entrusting client and the CQC product certification engineer can discuss the unit merger and splitting scheme.

6 Certification entrusting

6.1 Proposal and acceptance of certification application

The certification entrusting client shall fill in the required enterprise information and product details, and submit to CQC for certification entrusting via the Internet (www.cqc.com.cn). CQC shall review the certification entrusting according to relevant requirements and issue a notice of acceptance or rejection within 2 working days, or require the certification entrusting client to make corrections and resubmit the certification entrusting again.

When certification entrusting is accepted, the certification entrusting client shall provide CQC with required certification entrusting materials (see Attachment 1 of this document for details).

The certification entrusting client shall be responsible for the authenticity of the materials provided.

CQC manages and saves the certification materials provided by the certification entrusting client, and has the duty of confidentiality.

Manufacturers or manufacturing enterprises shall abide by the requirements in attachments of the Implementation-Rules and Attachment 5 of this document to establish, implement and sustainably maintain the conformity of production control system; make sure that the certified products sustainably satisfy the requirements of compulsory product certification.

The factory on-site inspection for conformity of production is an evaluation by the certification body on whether the conformity of production control system of the manufacturer or manufacturing enterprise meets the certification requirements. The initial on-site inspection shall be completed within one year after the type test is qualified.

If the type test fails after the initial factory on-site inspection is passed and the production process needs to be adjusted, a supplementary on-site inspection of the factory is required.

7.1.2 Technical review of documents

CQC shall conduct a technical review of the certification entrusting documents, test reports, conformity of production control plans and confirmatory materials submitted by the certification entrusting client in accordance with the requirements of Attachment 4 of this document, and formulate a certification plan based on the review conclusions.

Manufacturers or manufacturing enterprises shall abide by the requirements in attachments of the Implementation-Rules and Attachment 5 of this document to formulate the conformity of production control documents, and submit them to the certification body for review. When conformity of production control plan formulated by the factory is approved, the certification authority shall establish factory on-site inspection plan for conformity of production. The plan shall include the products to be inspected, sites and scope.

7.1.3 Factory on-site inspection for conformity of production

Factory on-site inspection for conformity of production is carried out by the producers and/or manufacturing enterprises after the conformity of production control document has passed the review. CQC shall assign an inspection team to the site of conformity of production control to conduct on-site inspection of the enterprise's quality assurance capabilities and conformity of production.

7.1.3.1 Inspection range

Factory inspection for conformity of production shall cover all departments, places, activities and processes related to the quality of the products entrusted with certification, and shall cover the category and structure of the products entrusted with certification.

When a manufacturing enterprise has subcontracted its production process, CQC can carry out extended inspections on subcontracting sites outside the manufacturing enterprise.

If necessary, CQC inspection team can be extended to the certification entrusting client, producers (manufacturers), etc. for inspection.

7.1.3.2 Inspection requirements

During factory inspection for conformity of production, manufacturing enterprises shall have products of different categories entrusted with certification in production.

CQC delegates an inspection team to make the on-site inspection of conformity of production according to attachments of the Implementation-Rules.

When carrying out the factory on-site inspection, the factory inspection team shall randomly sample qualified products at the processing site to carry out following inspections, including but not limit to:

- (1) Inspection of conformity of the marks of certified products and “Table of Technical Parameters of Motor Vehicle Tyre Products”;
- (2) Inspection of conformity of tread pattern between the certified product and the "Tread List";
- (3) On-site designated test of certified products (selected from the items specified in the conformity of production plan submitted by the factory).

7.1.3.3 Factory on-site inspection time for conformity of production

For certification entrusting that requires factory on-site inspection, CQC delegates an inspection team covering the motor vehicle tyre industry to carry out on-site inspection for manufacturing enterprises.

The number of inspector days is determined according to the manufacturing enterprise (place), inspection content, units of certified products entrusted, and the number of product specifications covered, and due consideration is given to the scale of the manufacturing enterprise, which is generally 4 ~ 6 person days per processing place.

7.1.4 Inspection conclusion

If no nonconforming items or minor nonconforming items are found in the factory on-site inspection, and the site has completed rectification and confirmed by the inspection team, the factory inspection results are evaluated as qualified.

If there are nonconforming items in the factory on-site inspection, and rectification can be allowed within a time limit (not exceeding 3 months). Manufacturing enterprises shall take corrective actions and report the rectification materials to CQC.

rectification of the enterprise. The duration for retest is the same as the duration for type test.

If the time for sample type testing, rectification and retesting is extended due to weather or other reasons, it will not be taken into account.

7.2.6 Type test report

CQC shall formulate the unified format of type test report.

The laboratory shall issue type test reports in the unified format. The laboratory and its related personnel shall be responsible for correctness of the content and test conclusions of the type test reports made by them.

7.3 Evaluation and approval of certification results

Certification organization shall comprehensively evaluate type test result, initial inspection result, and other related materials/information. For those that meet the certification requirements, if the evaluation is approved, then certificate shall be issued according to certification unit.

When the type test fails and the initial inspection fails, CQC makes a nonconformity decision and the certification is terminated. After the certification is terminated, if the certification entrusting client still wants to entrust the certification, the certification entrusting shall be applied again.

7.4 Certification time-limit

Not more than 90 days from the date of accepting the certification entrusting to the time when the certification certificate is issued, including type test time, initial inspection time, post-inspection report submission time (if applicable), certification result evaluation and approval time, and certificate production time. The completion time of the above certification activities does not include the time of nonconformity rectification and re-testing. In the case of non-compliance with the certification requirements, CQC shall notify the client and explain the reasons.

This document does not make clear the certification process and time limit, which are subject to the relevant CQC procedure documents and work instructions. CQC will control the certification time limit and complete related work according to the requirements of relevant procedure documents and work instructions, and the certification entrusting client, producers, and manufacturing enterprises shall cooperate.

The certification entrusting client, producers (manufacturers), and manufacturing enterprises shall actively cooperate and assist in the implementation of certification. The certification timeout - due to the entrusting client failing to submit materials in time, failing to accept on-site inspection as planned, failing to submit non-conformity

submitted by the enterprise cannot be accepted for more than five consecutive years. In the fifth year, samples must be sent to the designated laboratory for testing.

The test reports for rolling resistance and relative grip performance on wet roads shall meet the following requirements: Test reports issued by designated testing agencies that meet the requirements of certification standards between two factory inspections.

The inspection reports for test items other than rolling resistance and relative grip performance on wet roads shall meet the following requirements: For Category A and Category B enterprises, the reports shall be reports of national or provincial quality supervision spot checks or compulsory product certification type tests between two factory inspections in accordance with the certification standards. The inspection items shall at least include all items except the mark inspection.

8.3.3 Sampling test items and requirements

The sampling test items and requirements shall be according to Article 7.2.4 of this document.

8.3.4 Utilization of factory test resources

For Category A or B enterprises, provided that the manufacturing enterprises meet all requirements of certification standards, “Implementation Rules for China Compulsory Certification - Utilization requirements of Manufacturing Enterprise Test Resources and Other Certification Result”, and the conditions required by Article 0.3 of this Detailed-Rules, and agree to use the test resources for on-site test, manufacturers or manufacturing enterprises may apply for on-site test. After CQC’s approval, the designated laboratory may send qualified staffs to carry out on-site test by utilizing the factory test resources. On-site test shall be made according to Article 8.3.3 of this document; designated laboratory shall issue test report when the test is qualified.

If the manufacturer or manufacturing enterprise has utilized the factory resources for testing for at least 5 consecutive years, in principle, the samples shall be sent to designated laboratory for testing, so as to avoid systematic risks.

8.4 Market sampling test or inspection

8.4.1 Principle of market sampling test or inspection

CQC carries out market sampling for enterprises when necessary on the basis of enterprise classification management and certification risk.

8.4.2 Contents of market sampling test or inspection

CQC establishes market sampling test or inspection plan by selecting some or all of the test items from type test items, according to quality condition of different products. Samples shall be sampled by designated personnel from certified products in the market

(including at warehouse or at user-site), and shall be sent to the designated laboratory for test or inspection.

When taking samples from the market, the certification entrusting client, producers (manufacturers), and manufacturing enterprises shall actively cooperate, such as providing sales information of certified products, and information of product users, distributors, and sales network. At the same time, confirm the authenticity of the samples on site and bear the sample transportation costs.

8.5 Frequency and time of after-certification supervision

8.5.1 Frequency of after-certification supervision

In principle, manufacturing enterprises shall be subject to supervision, after first-time certified or after the initial factory inspection, according to the basic frequency specified in Table 4.

When following cases happen, manufacturing enterprises shall increase the supervision-frequency on basis of basic supervision-frequency:

- (1) Serious quality problem happens to the certified products (such as failed to pass national-level or provincial-level quality sampling inspection); the quality is complained by customers and causes serious influence, which is determined to be the liability of the certification entrusting client/manufacturer/manufacturing enterprise.
- (2) CQC has reasons to doubt the conformity of certified products for standard safety requirements.
- (3) When classification result (category) of manufacturing enterprise degrades.

Increased supervision-frequency shall be made without prior notice.

For discontinuous production, the certification entrusting client or manufacturing enterprises shall consciously submit production schedule to CQC for convenience of after-certification supervision.

8.5.2 Time of after-certification supervision

Time for after-certification follow-up factory on-site inspection depends on type and quantity of certified products, and takes factory scale into consideration. Generally, it is 1 ~ 4 man-days for each factory.

For production on-site or market sampling test, test shall be done within 30 working days since the samples are determined as qualified by designated laboratory.

and/or relative grip performance on wet roads are unqualified, three times the unqualified items may be retested and the average of the three times retest results shall be taken. If the average value is qualified, the supervision sampling inspection is judged to be PASS; if the average value is unqualified, the supervision sampling inspection is judged to be NOT-PASS.

Except for the tests of rolling resistance and relative grip performance on wet roads, if the product supervision sampling test is unqualified, the certificate of the unit where the sample is included is suspended. If the type and structure of the sample involves multiple units, a supplementary sampling test shall be carried out on all the units covered by the sample. During the supplementary sampling test, sampling shall be carried out by unit group (excluding the unit where the unqualified sample is included), and it shall take samples of at least one specification from each unit group for all-item test except for the rolling resistance and relative grip performance on wet roads. If the test result is unqualified, all certificates of the unit group represented by the sample are suspended.

For the tests of rolling resistance and relative grip performance on wet roads, if the product supervision sampling test is unqualified, the certificate of the unit where the sample is included is suspended. If the tread group/tread involves other units, at least one specification of other units shall be randomly selected for testing of rolling resistance and relative grip performance on wet roads. If the enterprise agrees, a more stringent supplementary sampling method may also be used. If the test result is unqualified, all certificates for other units represented by the sample are suspended.

8.6.3 Comprehensive evaluation

The comprehensive evaluation of after-certification supervision results includes evaluation of follow-up inspection, evaluation of production on-site sampling test and/or evaluation of market sampling test.

If the evaluation of after-certification supervision results is PASS, CQC sends a notice of approval to maintain the certification certificate to the certification entrusting client, permitting the continued use of certification certificate and certification mark. If any of the evaluation results is Not-PASS, the evaluation of after-certification supervision results is Not-PASS; CQC decides to suspend or revoke the certification certificate according to the corresponding situation.

9 Certification certificate

9.1 Maintenance of the certification certificate

The validity of the product certification certificate under coverage of this document is 5 years. Within the valid period, the validity of the certificate is maintained by depending on the “after-certification supervision” of the certification body.

When the certification certificate is going to be expired and needs to be extended, the certification entrusting client shall submit the certification entrusting 90 days prior to the expiration. The certificate can be directly replaced with a new one provided the last after-certification supervision within the validity period of certificate is qualified. If the certification certificate expires and the certification entrusting client does not apply for renewal, the certification body will cancel its certificate. The type test report and factory inspection report corresponding to the canceled certification certificate are no longer valid.

9.2 Contents and use of the certification certificate

The contents and use of the certification certificate shall comply with those required by “China Compulsory Certification Management Method”, “Certificate and Certification Mark Management Regulations” and “China Compulsory Certification Certificate Management Requirements”. According to the certification standard requirements, the certification certificate shall also include tyre specification mark, load index/layer, speed symbol, summary description of tread group and related tread name/code (when applicable).

9.3 Changes of the certification certificate

9.3.1 Basic requirements for changes of certification certificate

After the certification certificate is obtained, when the following changes are involved, the certification entrusting client shall submit a change entrusting to CQC, and the change may be implemented only after CQC has approved it.

- (1) Changes of the content of the certification certificate: name and/or address of the certification entrusting client, manufacturer (producer), manufacturing enterprise; name and model of product; implementation rules, certification standards, validity period of the certificate;
- (2) Technical changes of certified products (design, parameters, critical components) which may affect the compliance with relevant standards or conformity of type test samples; or changes of the content of “Table of Technical Parameters” and “Tread List”;

Note: When the type A parameters in “Table of Technical Parameters” in Attachment 2 of this document have changed, a certification change entrusting must be submitted before the change; type B parameters are subject to record management where engraving and production can be carried out first, and the certification change entrusting can be submitted before supervision to complete the record.

- (3) Changes of conformity of production control plans, production conditions, relocation etc. of the factory that may affect the conformity of production;

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