CE MARKING ACCORDING TO EN 13986

The harmonized Standard EN 13986 defines wood-based panels for use in construction and sets its essential characteristics. It describes appropriate test methods to determine these characteristics for uncoated and coated (veneered or painted) wood-based panels, characterizes procedures for assessment and verification of the constancy of performance1) of wood-based panels as well as the demands on their labeling.

The requirements according to EN 13986 do not apply for wood-based panels for use outside of construction.

1) The systems for verification of the constancy of performance of wood-based panels are described in EN 13986, Annex ZA, table ZA.1

Requirements for CE-Marking

- Determination of the product type on the basis of type testing (possibly with involvement of a notified test laboratory)
- Setting up a factory production control
- Creation of a declaration of performance by the manufacturer

Additional requirements to systems 1 and 2+

- Initial inspection of the factory and factory production control by a notified body
- Continuous surveillance of factory production control by a notified body
- Creating a certificate for attesting the conformity of the factory production control (system 2+) and the constancy of the product (system 1)
Content of the Quality assurance system for the factory production control

**Quality Management Manual**
- Name and address of the manufacturer
- Scope and purpose of the Quality Management system
- Organizational structure (flowchart)
- Responsibilities (flowchart)
- Designation of Quality Manager
- Production process (flowchart, etc.)
- Qualification of all participants
- Education / training plans
- Description of the quality control
- Description of documentation
- Handling of non-compliant products
- Archiving
- Declaration of Performance
- Marking of the product
- Dealing with complaints
- List of machinery and equipment
- Calibration schedule

**Serial operational procedures (SOP)**
- Responsibilities
- Document storage
- Signature policies

**Working Instructions**
- Incoming goods inspection
- Handling and storage of incoming products
- Work instruction for the individual work shops
- Final control
- Handling of defective products
- Marking
- Packaging
- Shipping

**Production Documentation / Control Cards**
- Date
- Time
- Order number
- Client (if possible)
- Name of the operator
- Working step
- Quality control
- Signature of responsible person

**Declaration of Performance**
The manufacturer shall establish on the basis of the technical documentation a declaration of performance for each product type. Examples of performance explanations can be found at: Regulation (EU) Nr. 305/2011 in Annex III.

**CE-marking**
- The CE marking shall be affixed visibly, legibly and indelibly on the product by the producer or his authorized representative located in the EU
- For systems that require a certifying (notified) body the identification number must be specified.
- Further information for CE-marking can be found after Regulation (EU) Nr. 305/2011 in articles 8 and 9