



Control Plan to

ETA-24/0471

Date of Control Plan

21.08.2024

**Technical Assessment Body issuing the European Technical Assessment:
LUXEMBOURG INSTITUTE FOR BUILDING AND TECHNOLOGY**

Trade name of the construction product

SIKLA SiFramo for PRS

Product family to which the construction product belongs

Steel components for pallet racking systems

Manufacturer

Sikla Holding GmbH
Ägydiplatz 3
A-4600 Thalheim bei Wels
Austria

Manufacturing plant(s)

Manufacturing plants of SIKLA

This Control Plan contains

4 pages

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This version replaces

1. Manufacturing plant(s)

Profiles and sections	
Plant 1	Welser Profile GmbH, Am Welser Platz 1, 3264 Gresten, Österreich
Plant 2	Voestalpine Sadef nv, Bruggesteeweg 200, 8830 Hooglde, Belgien

Welded parts	
Plant 3	Herpertz Präzision B.Herpertz GmbH & Co. KG, Am Langen Graben 5, 52353 Düren, Deutschland
Plant 4	Ferrovkov Kft., Pálmaház utca 1, 7562 Segesd, Ungarn
Plant 5	ELECO d.o.o., Limbuška cesta 2, 2341 Limbuš, PODRAVSKA, Slowenien
Plant 6	Verzinkerei Sulz GmbH, Neckarwiesen 20, 72172 Sulz am Neckar, Deutschland

2. Tasks of the manufacturer

The following information are required:

No.	Subject/type of control	Test or control method	Criteria	Minimum number of samples	Minimum frequency of control
Factory production control (FPC)					
1	Incoming raw materials	Inspection document 3.1 acc. to EN 1090-2:2008+A1, Table 1	100% compliance to material properties stated in the ETA	acc. To EX2 EN 1090-2:2008+A1 chapter 5.2	acc. To EN 1090-2:2008+A1 chapter 12.2
		Checking of dimensions	Results shall be documented		
2	Essential component dimensions and manufacturing tolerances influencing the performance (e.g. thickness dimensions and tolerances of cross-sections and perforations, etc.)	By suitable measuring instruments	100% compliance with required dimensions and tolerances stated in the drawings (see section 3).	3	Every change of coil or a material-lot or every change of a tooling or a machine
3	Welding	Acc. To EXC2, EN 1090-2:2008+A1, table A.3			
4	BEC characteristics	Acc. To EN 15512:2009, Annex A and H			
5	Check of initial raw material	Acc. To EN 1090-2:2008+A1, chapter 12.2			

2. Tasks of the notified body

The following are the cornerstones for the control plan for the notified body

No.	Subject/type of control	Minimum frequency of control
Initial inspection of the manufacturing plant and od factory production control		
1	The notified body shall ascertain that, in accordance with the prescribed control plan (FPC), the manufacturing plant of the product manufacturer, in particular personnel and equipment, and the factory production control are suitable to ensure a continuous and orderly manufacturing of the steel components for PRS	Before certification
Continuous surveillance, assessment and evaluation of factory production control		
2	It shall be verified by routine inspections of the notified body that the system of factory production control and the specified manufacturing process are maintained.	Once a year

2. Drawings

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The drawings are documented in the file:

“Drawings for control plan - ETA-240471_240821.rar”