



GRCA FULL MEMBER GRADE (GRC Manufacturer)

Regulations, Membership Procedure and Assessment

The International Glassfibre Reinforced Concrete Association (GRCA)

February 2021

The International Glassfibre Reinforced Concrete Association (GRCA) has relationships with other associations connected with the GRC industry. Further information, together with a full list of GRCA Members, can be found on The International Glassfibre Reinforced Concrete Association (GRCA) website: www.grca.online.

Membership of the GRCA is open to:

- Companies who manufacture or develop GRC products,
- Plant or material suppliers to the industry
- Professional partnerships or consultants
- Other interested parties and associated industry trades.

GRCA Full Member Grade (GRC Manufacturer): Regulations, Membership Procedure and Assessment.

The objective of the Full Member Grade (GRC Manufacturer) of The International Glassfibre Reinforced Concrete Association (GRCA) is to provide an independent means of assessing the capability of the Member to manufacture GRC products in accordance with the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material' and the GRCA 'Practical Design Guide for Glass Reinforced Concrete', and other international best practice and recognised procedures as may be deemed to be appropriate by the GRCA and approved by its Council.

Although The International Glassfibre Reinforced Concrete Association (GRCA) ensures every care has been taken in the preparation of this document and the operation of the Full Member Grade membership requirements, including but not exclusively assessments, audits and certification, no liability for negligence or otherwise can be accepted by The International Glassfibre Reinforced Concrete Association (GRCA), or the members of its working parties, its servants, agents or assessors.

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**GRCA FULL MEMBER GRADE (GRC MANUFACTURER):
REGULATIONS, MEMBERSHIP PROCEDURE AND ASSESSMENT**

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FOREWORD

The International Glassfibre Reinforced Concrete Association (GRCA) has a long history of setting and maintaining standards for all things appertaining to the worldwide GRC industry. In order to promote these standards further, the GRCA has previously introduced the Approved Manufacturer Scheme (AMS), which set high standards by which GRC manufacturers should be judged. In a further development of these standards in the manufacture of GRC by the GRCA Members, the Approved Manufacturer Scheme (AMS) has now been replaced by the introduction of a higher grade of membership for GRC manufacturing Members of Full Member Grade (GRC Manufacturer) of The International Glassfibre Reinforced Concrete Association (GRCA).

The objective of the Full Member Grade (GRC Manufacturer) of The International Glassfibre Reinforced Concrete Association (GRCA) is to provide an independent means of assessing the capability of the Member to manufacture GRC products in accordance with the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material' and the GRCA 'Practical Design Guide for Glass Reinforced Concrete', and other international best practice and recognised procedures as may be deemed to be appropriate by the GRCA and approved by its Council.

The awarding of the Full Member Grade (GRC Manufacturer) of The International Glassfibre Reinforced Concrete Association (GRCA) by the GRCA Governing Body to GRC manufacturers is recognition of the belief that the systems operated by the Member are fully compliant with these Regulations and shall remain fully compliant throughout the period covered by their Certificate of Registration.

The awarding of the Full Member Grade (GRC Manufacturer) of The International Glassfibre Reinforced Concrete Association (GRCA), and the issuing of a Certificate of Registration, by the GRCA Governing Body is a guide to the expected performance of the Member, and is not, and shall not be deemed to be, any warranty, guarantee or verification of the performance, standards and consistency which the Member has or will achieve in its systems, operations and products.

All specifiers and users of GRC products should take all steps and precautions deemed necessary by them, to verify the GRCA findings and to assure themselves that the GRC manufacturer and their products are fit for the intended usage as envisaged by the specifiers and users.

Although The International Glassfibre Reinforced Concrete Association (GRCA) ensures every care has been taken in the preparation of this document and the operation of the Full Member Grade membership requirements, including but not exclusively assessments, audits and certification, no liability for negligence or otherwise can be accepted by The International Glassfibre Reinforced Concrete Association (GRCA), or the members of its working parties, its servants, agents or assessors.

PART 1: INTRODUCTION

1. These Regulations relate to the GRCA's Full Member (GRC Manufacturer) grade for the registration of GRC manufacturing companies, partnerships and individuals into the Full Member grade of GRCA membership. The Regulations were set up with the active support of the GRC manufacturing industry.

The GRCA's Regulations, Membership Procedure and Assessment do not replace any contractual relationship between a Full Member and any of the said Full Member's clients.

2. Definitions: For the purpose of these Regulations:

Regulations: shall mean this documented 'GRCA Full Member Grade (GRC Manufacturer): Regulations, Membership Procedure and Assessment' requirements.

GRCA: shall mean The International Glassfibre Reinforced Concrete Association.

GRC: shall mean Glassfibre Reinforced Concrete as recognised by the GRCA.

Member: shall mean any company, partnership or individual that has been accepted in to the GRCA as a GRCA Member. A GRCA Member may be a company or individual involved in a trade associated with the GRC industry, a GRC manufacturer in their first year of GRCA membership prior to Full Member Assessment, or a Full Member

Full Member: shall mean any company, partnership or individual that has been accepted in to the Full Member grade of GRCA membership, and whose operations remain fully compliant with these Regulations.

Governing Body: shall mean the GRCA Council or nominated sub-committee.

Scheme Manager: shall mean the GRCA Administration.

Production Facility: shall mean any place / site / plant involved in the manufacture of GRC.

Quality Control Manual / Plan: shall mean a document(s) that sets out the quality assurance practices, which must include all the requirements of the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material' and the GRCA 'Practical Design Guide for Glass Reinforced Concrete'.

Assessor: shall mean a person or company nominated by the GRCA to carry out an Assessment.

Assessment: shall mean the annual assessment carried out by an Assessor relating to either an upgrade to the Full Member grade by a new GRC manufacturing Member, or the continued membership of the Full Member grade of GRCA membership by a Full Member.

Assessment Report: shall mean the report issued by an Assessor following an Assessment, including the Assessor's recommendations.

Designated Date: shall mean the annually occurring date by when an Assessment is due to maintain the Full Member grade and Certificate of Registration.

Certificate of Registration: shall mean a certificate issued by the GRCA recognising that the systems operated by the Full Member have been assessed and approved in accordance with these Regulations.

Full Member Symbol: shall mean the GRCA's Full Member symbol / logo.

"SPEC": shall mean the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products'.

"MOT": shall mean the 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material'.

"GUIDE": shall mean the GRCA 'Practical Design Guide for Glass Reinforced Concrete'.

3. The Governing Body of the Regulations is the sole authority by which Certificates of Registration may be granted.
 - (a) The Governing Body may delegate any Assessment to its nominated Assessor, including for investigating any breach of these Regulations.
 - (b) The Assessor will only be responsible for Assessment Recommendations or outline reports to the Governing Body, and it shall have no authority over any outcome of any such Assessment or investigations.

4. Certificate of Full Member Registration
 - (a) A GRC manufacturing Full Member who satisfies the Governing Body that it is in compliance with the Regulations, has a bona fide business, and shall give such undertakings as required, shall, subject to the Regulations, be entitled to a Certificate of Registration.
 - (b) The Certificate of Registration is renewable annually. If a Full Member does not intend to renew its Certificate of Registration, it shall notify the Governing Body 60 days prior to the expiry date as shown on the Certificate of Registration. The Certificate of Registration is not transferable without written permission of the Chair of the GRCA.
 - (c) The Certificate of Registration shall state the address of the Production Facility assessed under these Regulations, and the Certificate shall not apply to other Production Facility owned, operated, utilised or sourced from by the Full Member.

5. A Full Member shall:
 - (a) Only use the Certificate of Registration and Full Member Symbol when a valid Certificate of Registration is in force.
 - (b) Notify the GRCA of all Production Facilities they use for the production of GRC, and immediately notify the GRCA if production is commenced at a Production Facility not previously notified to the GRCA and/or not Assessed under these Regulations.
 - (c) Only use the Certificate of Registration and Full Member Symbol in respect to Production Facilities Assessed under these Regulations.
 - (d) Maintain a Quality Control Manual / Plan system in accordance with the Regulations.
 - (e) Not vary the manufacturing processes under which the Certificate of Registration is issued unless it is confirmed in writing by the Scheme Manager that the variations do not render the certificate invalid. Minor changes to the Quality Control Manual/Plan system, not affecting manufacturing process or the performance of the product, may be made without written approval if the changes are reviewed at routine Assessment.
 - (f) Discontinue any use of the Certificate of Registration and Full Member Symbol or any reference to Full Member, which, in the opinion of the Governing Body, might be misleading.
 - (g) Give representatives of the Governing Body full access to premises, records, and methods of test etc. for the purposes of establishing that the terms of the Certificate of Registration are being complied with.
 - (h) Upon termination of the Certificate of Registration discontinue use of the Certificate of Registration, Full Member Symbol and any reference to Full Member on all advertising matter and return any GRCA documentation that has been issued in respect of the Regulations and Certificate of Registration.

6. Fees

All GRC manufacturers accepted into the Full Member grade of GRCA membership shall pay fees, as follows:

 - (a) An annual membership subscription fee, which shall include a contribution towards both the cost of administering the Full Member Regulations, and the Assessment and

- Assessor costs, as determined and agreed by the Governing Body from time to time.
- (b) The annual fee, above, will be invoiced by the GRCA and is to be paid to the GRCA no later than 30 days from the invoice date, and by the start of the membership year (1st April) at the latest.
 - (c) Any additional costs required or incurred due to additional inspection or non-compliance with these Regulations.
 - (d) The fee for additional costs, above, will be invoiced by the GRCA and are to be paid to the GRCA prior to the work being undertaken. Where the additional costs are incurred by the GRCA prior to invoicing they are to be paid by the Full Members immediately upon receipt of the invoice.
7. The Governing Body and Scheme Manager shall:
- (a) Notify the Full Member at least once a year of the requirement for the annual Assessment.
 - (b) Notify the Full Member of any changes in processes and procedures that are considered necessary to meet the Full Member Regulations.
 - (c) Not disclose any information that is confidential to the Members and Full Members.
 - (d) Maintain a register of Full Members and their Production Facilities.
8. Designated Date
- (a) The Designated Date shall initially be determined as the date the Member was originally assessed and accepted into the Full Member grade of GRCA membership.
 - (b) Subsequent annual Assessments may be carried out up to a month before the Designated Date for the original Designated Date to be maintained.
 - (c) Should a compliant Assessment not be carried out by the Designated Date, then the Member shall be suspended from the Full Member grade until a compliant Assessment is carried out.
 - (d) In the case of 8.(c), the Designated Date shall revert back to the original Designated Date when a compliant Assessment is carried out, and it shall not move forward to the actual date of a compliant Assessment.
9. If a Full Member fails to comply with any of the Regulations, the Governing Body may revoke the Certificate of Registration or reduce its scope, if the deficiencies are not rectified within a period of time considered reasonable by the Governing Body.
10. In the event of a Scheme Member wishing to appeal against a decision by an Assessor, the Governing Body or the Scheme Manager, notice must be given in writing to the GRCA within 14 clear days of the decision. This notice shall fully detail any and all objections to the decision, with full supporting evidence and documentation. A meeting of the Governing Body and the Member should take place within 30 days. If this is not practicable, then both parties should present written submissions to the GRCA Council via the GRCA Administration address. The decision of the GRCA Governing Body as declared by the Council Chair shall be final.
11. A Full Member shall indemnify the GRCA and any nominated Assessors, and their Officers, members, employees and associates against any claims for liability arising from the Full Member's failure to perform in accordance with the Full Member Regulations.
12. The GRCA, the Governing Body, the Scheme Manager and any nominated Assessor disclaim any liability for any claims made by Members, Full Members, and all others, that may be made against the GRCA, its Members and Full Members, in respect of faulty goods or performance however caused.

PART 2: ASSESSMENT AND CERTIFICATION

Each Assessment is individually planned to allow evaluation of the Members' GRC manufacturing system as it relates to a specific product or products.

There are two types of Assessment:

- (a) Specific product(s) (appropriate to Members manufacturing standard GRC products)
- (b) Specific processes (appropriate to Members manufacturing custom made GRC products)

In the case of (a), the Member must demonstrate that they manufacture, cure and test GRC in accordance with the requirements of the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products' and the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material'. They must demonstrate that the Grade of GRC adopted is suitable for their products, in accordance with the GRCA 'Practical Design Guide for Glass Reinforced Concrete'. If necessary, an independent review of the latter may be requested by the Governing Body prior to considering the Member and their products for approval.

In the case of (b), the Member must demonstrate that they manufacture, cure, test and design their GRC material in accordance with the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material' and the GRCA 'Practical Design Guide for Glass Reinforced Concrete'.

In both instances the Member must demonstrate that they can meet the requirements for the simultaneous spray and/or premix methods of GRC manufacture.

The Assessment shall involve a thorough appraisal of the GRC manufacturing Member's procedures. It is necessary to demonstrate practical compliance, in normal production, with the Member's Quality Control Manual / Plan, which shall include reference to the GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', the GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material' and the GRCA 'Practical Design Guide for Glass Reinforced Concrete', or other national standard recognised by the Governing Body and the GRCA.

At the end of the Assessment, the Assessor shall submit an Assessment Report to the Scheme Manager, which includes details of any discrepancies found, agreed actions to resolve these, and a recommendation regarding the acceptance or continued acceptance as a Full Member grade of the GRCA. The Assessment Report shall be confidential between the Assessor and the Scheme Manager, except where the disclosure of specific elements of the Assessment Report to the GRC manufacturing Member being assessed is required solely for the purposes of identifying and addressing any discrepancies found.

The Assessor shall only make 3 possible outcomes of any Assessment:

1. Full Member grade of GRCA membership IS NOT recommended at this time.
2. Full Member grade of GRCA membership IS recommended at this time, indicating whether simultaneous spray GRC manufacturing method, premix GRC manufacturing method or both have been assessed.
3. Recommendation is deferred at this time, and subject to another Assessment being undertaken within a stated period.

On acceptance as a Full Member, and subject to payment of all outstanding fees, the GRCA Member will be sent a Certificate of Registration indicating the Production Facility Assessed and which manufacturing method(s) they have been accepted for.

PART 3: ASSESSMENT REQUIREMENTS

The following requirements shall form part of any Assessment, to demonstrate that the GRC is being manufactured fully in accordance and compliance with the requirements of the:

- GRCA 'Specification for the Manufacture, Curing & Testing of Glassfibre Reinforced Concrete (GRC) Products', hereafter referred to as "SPEC", and
- GRCA 'Methods of Testing Glassfibre Reinforced Concrete (GRC) Material', hereafter referred to as "MOT", and
- GRCA 'Practical Design Guide for Glass Reinforced Concrete', hereafter referred to as "GUIDE", and
- The Member's Quality Control Manual / Plan which as a minimum must include all the requirements of the GRCA "SPEC", "MOT" and "GUIDE".

The use of other National Standards may be acceptable if recognised by, and with prior approval of, the Governing Body and the GRCA.

The Assessment shall cover the following areas:

1) PRODUCTION FACILITY

Does the GRC manufacturing Member have a suitably set out and organized Production Facility, with the necessary equipment for the production processes used, including suitable curing and storage provision?

2) QUALITY CONTROL

Does the GRC manufacturing Member have a written Quality Control Manual / Plan?

Does the Quality Control Manual / Plan detail a QA system covering the design, manufacture and testing of GRC products in compliance with the GRCA "SPEC", "MOT" and "GUIDE"?

Does the Quality Control Manual include a written procedure of actions in the event of test results or inspections not meeting a required specification and grade of GRC (non-conforming procedure)?

3) ORGANISATION CHART

Does the GRC manufacturing Member have a written organisation chart detailing individual responsibilities from input of customer requirements, design, manufacture, inspection and test, packaging, approval, dispatch and installation (as applicable)?

4) ALKALI RESISTANT GLASS FIBRES

Does the GRC manufacturing Member have a material Datasheet or Certification of compliance and a matching delivery note for the alkali resistant (AR) glass fibres?

Does the GRC manufacturing Member purchase sufficient AR glass fibres for the indicated GRC production volumes.

Does the material Datasheet or Certification confirm that the fibres have a high alkali resistance with a minimum zirconium dioxide (ZrO₂) content of 16 %?

Does the material Datasheet or Certification confirm that the glass fibres comply with EN 15422 (or equivalent National Standard)?

5) **STORAGE OF GLASS FIBRES**

Is the storage of glass fibres in compliance with the material Datasheet / Certification, which as a minimum includes no direct sun light and no direct water / large amount of moisture?

6) **CEMENTS**

Does the GRC manufacturing Member have a material Datasheet or Certification of compliance and a matching delivery note for the cements?

Do the said documents confirm that the cement is supplied by a manufacturer of assessed capability, made to recognized standards such as BS EN 197 (or equivalent National Standard)?

7) **STORAGE OF CEMENTS**

Is the storage of cements in accordance with the instructions in the material Datasheet / Certification, which as a minimum includes being kept dry to avoid deterioration?

8) **POLYMERS**

(only applicable if the Member manufactures polymer GRC)

Does the polymer GRC manufacturing Member have a Datasheet or Certification of compliance and a matching delivery note for the polymers?

Do the said documents confirm that the polymer:

Either: meets the requirements of the "SPEC" Table 2?

Or: in the case where the GRC manufacturing Member uses polymers with properties outside the specifications in the table does the Member have a written agreement of the purchaser and adequate test results?

9) **STORAGE OF POLYMERS**

Is the storage of polymers in accordance with the instructions in the material Datasheet / Certification, which as a minimum includes no direct sunlight and a method that takes into account the maximum the stability period of the polymers (see Datasheet / Certification, but typically 6 - 12 months)?

10) **AGGREGATES**

Does the GRC manufacturing Member have a Datasheet or Certification of compliance and a matching delivery note for the aggregates?

11) **STORAGE OF AGGREGATES**

Is the storage of aggregates in accordance with the instructions in the material Datasheet / Certification?

Does the GRC manufacturing Member use any fully dried aggregates, and if so, does the storage ensure that the aggregates do not receive further moisture?

Does the GRC manufacturing Member use any aggregates with moisture in them, and if so, does the storage ensure that the aggregates do not receive excessive additional water?

Does the GRC manufacturing Member use any aggregates with moisture in them, and if so, does the GRC manufacturing Member adjust the water content of the mix accordingly?

12) CONTROL OF MOULD MANUFACTURE

Does the GRC manufacturing Member have documented procedures for the control of mould manufacture, including the verification of moulds prior to use?

13) FLOW OF INFORMATION

Does the GRC manufacturing Member have documented systems to ensure that the necessary information to enable products to be manufactured to agreed specifications are available to the relevant personnel?

14) CONTROL OF MIX DESIGNS

Does the GRC manufacturing Member have documented procedures to ensure, that the mix designs are controlled?

Are the recipes for mix designs readily available in the production area?

15) CASTING

For Spray Process:

Does the GRC manufacturing Member have:

- a method of weighing / batching raw materials to comply with the specified mix design?
- a procedure for the calibration of the addition of fibres to given levels, with relevant calibration (Bag and Bucket-test)?
- a procedure for the control of the addition of fibres to given level, with relevant calibration (Wash-out-test)?
- a suitable method of spraying and compaction (layers, spray directions, compacting)?
- a method to control the sprayed thickness of the GRC?

For Premix Process:

Does the GRC manufacturing Member have:

- a method of weighing / batching raw materials to comply with the specified mix design?
- a suitable and consistent method of weighing and incorporating the fibres into the mix?
- a suitable method of delivery and compaction of the GRC into the mould (normally pumping, and vibration compaction or self-compacting mix)?

16) TRAINING OF STAFF

Does the GRC manufacturing Member have a documented system to ensure, that all staff, including management, operators and technicians, are trained and competent, with training records held on file?

17) LABORATORY OR EXTERNAL TESTING

Does the GRC manufacturing Member have either a suitably organized testing laboratory or area, or access to certified third party testing facilities?

Are test methods and the preparation of test boards in accordance with the GRCA "MOT"?

18) TEST METHODS & FREQUENCY

Does the GRC manufacturing Member test with the correct frequency?

Which requires:

- Slump test (“MOT” Part 5, BS EN 1170-1, or equivalent National Standard):
May be used as an in process test to check the consistency of the cementitious slurry on each mixer for spray process. No minimum frequency is specified.
- Bag and bucket test (“MOT” Part 4, BS EN 1170-3, or equivalent National Standard):
Used when calibrating the spray equipment by measuring the deposition rates of the AR glassfibre and cementitious slurry. The calibration shall be carried out for each spray machine at the beginning of each shift, after any alteration of the equipment controls, and after any unsatisfactory 'Wash out' test results.
- Wash out test (“MOT” Part 1, BS EN 1170-2, or equivalent National Standard):
May be used as an alternative test to the “Bag and bucket” test (“MOT” Part 4) to measure the deposition rate of spray equipment, at the frequency specified above for the “Bag and bucket” test.
- Flexural strength test (Spray Process) (“MOT” Part 3, BS EN 1170-5, or equivalent National Standard):
Minimum of twice per week per spray station or every 10 tonnes of GRC produced, whichever is the greater.
- Flexural strength test (Premix Process) (“MOT” Part 3, BS EN 1170-5, or equivalent National Standard):
Minimum of once per week per mixer, or every 10 tonnes of GRC produced, whichever is the greater.
- Bulk density, water absorption and apparent porosity (“MOT” Part 2, BS EN 1170-6, or equivalent National Standard):
Minimum of once per month.
- Extreme dimensional variation test (BS EN 1170-7, or equivalent National Standard):
When setting up a new mix design.

Does the GRC manufacturing Member perform the tests in accordance with the GRCA “MOT” or equivalent National Standards?

Is there evidence that test boards are produced at the rate of not less than 1 board per day per mixer/pump, for both spray and premix processes?

Are untested spray process test boards retained, and available for any future testing requirements, for a minimum period of one year?

19) TEST RESULTS

Do the test results confirm compliance with the required specification and grade of GRC?

Do the characteristic flexural strength results confirm compliance with the required grade of GRC?

20) LABELLING & TRACEABILITY

Does the GRC manufacturing Member record, pack and mark the product in a way that allows identification and good traceability to the relevant test results?

PART 4: APPOINTED ASSESSORS

1. It is the intention of the GRCA and the Governing Body that any Assessor or Assessor company nominated by the GRCA to carry out an Assessment shall be a fully qualified and registered ISO 9001 auditor.
2. The GRCA Governing Body shall maintain a list of approved Assessors.
3. All approved Assessors when appointed by the Scheme Governing Body or Scheme Manager, shall:
 - (a) Undertake initial Assessments of GRC manufacturers as required under instruction from the Scheme Governing Body or Scheme Manager, as detailed in Parts 1, 2 and 3.
 - (b) Undertake annual Full Member Assessments under instruction from the Scheme Governing Body or Scheme Manager, as detailed in Parts 1, 2 and 3.
 - (c) Only report to the Scheme Governing Body and Scheme Manager in all matters appertaining to the GRCA Full Member scheme.
 - (d) Not directly employ external consultants or sub-contracted resources to act as Assessors without the authority of the GRCA Governing Body or Scheme Manager.
 - (e) Not offer any direct consultation to the GRCA Members and Full Members without the prior approval of the GRCA Governing Body or Scheme Manager.
 - (f) Not directly contract with the GRCA Members and Full Members without the authority of the GRCA Governing Body or Scheme Manager.



The International Glassfibre Reinforced Concrete Association

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