



# American National Standard

**RIC001.1-2016**

**Specifications for the  
Process of Remanufacturing**

An American National Standard

for Remanufacturing





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### **Specifications for the Process of Remanufacturing**

#### **Disclaimer**

This standard was developed by the Remanufacturing Industries Council (RIC) and approved by ANSI on February 2, 2017. Compliance with this standard is voluntary and the specifications in this standard offer recommended practices for remanufacturing products and should be regarded as advisory only.

RIC does not set safety standards and does not certify or guarantee the safety of any products, parts or systems constructed in accordance with this standard. RIC strongly recommends that products be remanufactured and operated in accordance with appropriate nationally recognized safety standards.

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# Specifications for the Process of Remanufacturing

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## 1. Introduction

The Remanufacturing Industries Council (RIC) is a strategic alliance of businesses and academic institutions that works across industry sectors to support the entire remanufacturing industry through a combination of collaboration, education, advocacy and research. RIC is committed to promoting the growth of all sectors of the remanufacturing industry and working to increase awareness and grow the reputation of the benefits of remanufacturing in government organizations and the general public worldwide.

Remanufacturing is a comprehensive and rigorous industrial process by which a previously sold or leased product or part is returned through a controlled, reproducible and sustainable process to a “like-new” or “better-than-new” condition in performance level and quality for form, fit and function.

A number of terms are commonly used to describe different processes of product restoration,<sup>1</sup> and these processes may share characteristics that are similar to those described in Section 6. The purpose of this standard for the process of remanufacturing is to provide a standardized set of specifications to characterize remanufacturing and differentiate it from other processes.

While a consensus definition of remanufacturing is provided in Section 5 of this standard, some industries may be required to use alternative terms such as refurbishing, rebuilding or reconditioning in order to comply with government regulations. In such circumstances, conformance with this standard may be claimed provided that the organization complies with the requirements detailed in Section 7.

## 2. Purpose

Remanufacturing is a rapidly growing, global, high-technology industry that includes a wide variety of business sectors. The U.S. is the world’s largest producer, consumer, and exporter of remanufactured products. In a study<sup>2</sup> commissioned by the Office of the U.S. Trade Representative, the U.S. International Trade Commission identified two major impediments to growth for the remanufacturing industry: (i) the lack of a commonly accepted definition of remanufacturing, and (ii) the absence of standards for the remanufacturing process. RIC’s standards activities are designed to address these deficiencies and promote the understanding and credibility of the remanufacturing industry.

## 3. Scope

This standard defines and provides a benchmark for the process of remanufacturing, and establishes specifications that characterize the remanufacturing process and differentiate remanufacturing from other practices.

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<sup>1</sup> Other related restoration processes may include refurbishing, rebuilding, recycling, repairing and reconditioning.

<sup>2</sup> **U.S. International Trade Commission Investigation No. 332-525, Publication 4356.** *Remanufactured Goods: An Overview of the U.S. and Global Industries, Markets, and Trade.* 2012.

The specifications in this standard will promote continual improvement in the remanufacturing process and help ensure that the products provided to customers by the remanufacturing industry are dependable and of a consistent high quality.

This standard is intended to serve as a baseline for additional standards for specific remanufactured products and product groups to be developed in the future.

#### **4. Other relevant standards**

While this is a stand-alone standard, the following documents may be of value in developing processes that ensure the highest quality remanufactured products:

BS 8887 -2:2009 – Design for manufacture, disassembly and end-of-life processing (MADE)  
– Part 2: Terms and definitions

BS 8887 -220:2010 – Design for manufacture, disassembly and end-of-life processing (MADE) – Part 220: The process of remanufacture – Specification

IPC 7711/7721B:2007 – Rework, Modification and Repair of electronic Assemblies

ISO 9001:2008 – Quality management systems - Requirements

ISO 13485:2003 – Medical devices – Quality management systems – Requirements for regulatory purposes

ISO 14001:2004 – Environmental management systems – Requirements with guidance for use

#### **5. Definitions and terms**

For the purposes of this standard, the following definitions and terms apply:

(a) **As-new/Like-new**

A product returned to a condition where it meets its original manufacturer's specification from a quality, performance and service-life perspective.

(b) **Assembly**

The process by which qualified parts (whether remanufactured or new) are combined or connected together to create a subassembly, assembly, system or remanufactured product.

(c) **Core**

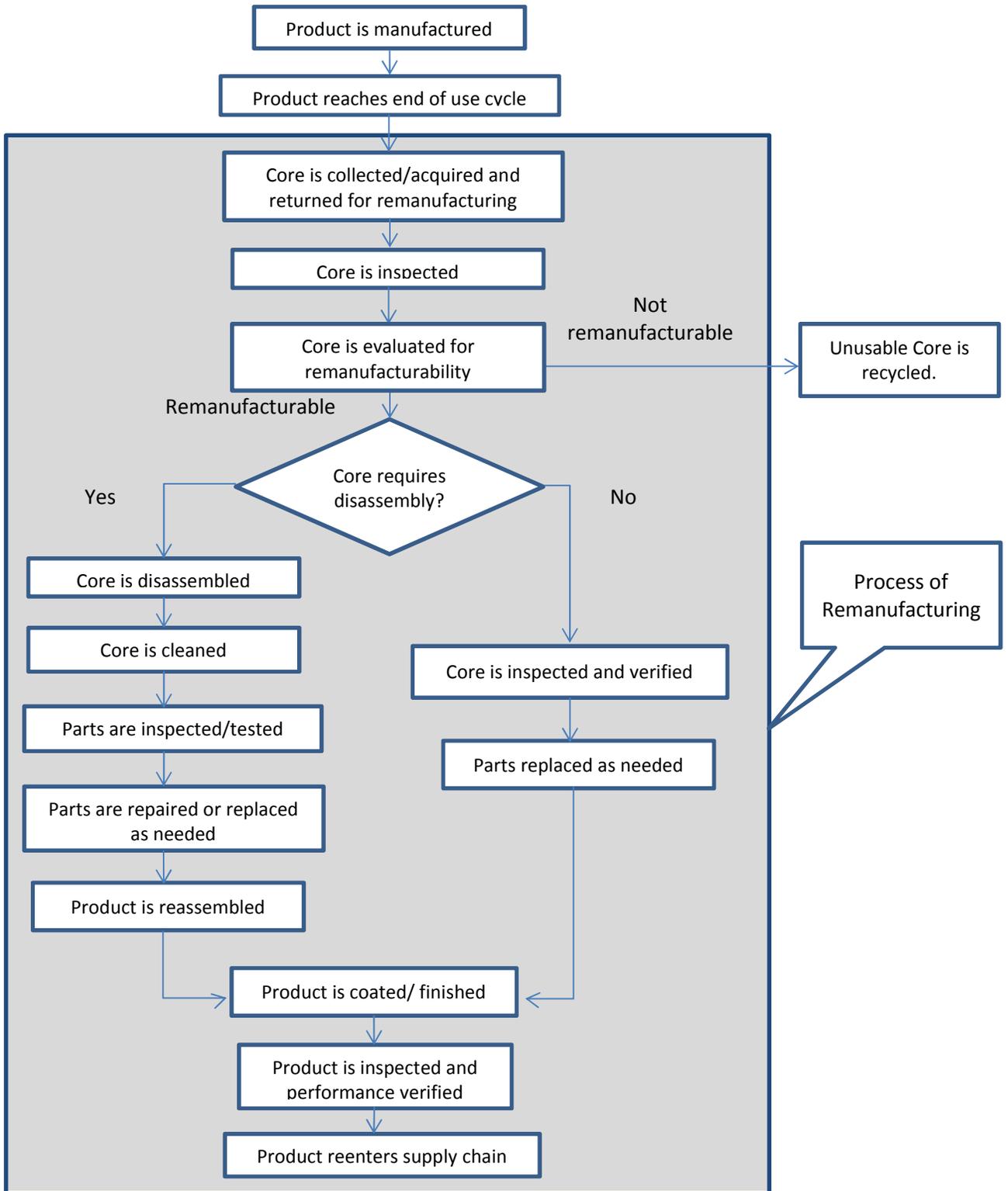
A worn, failed, or end-of-use part, assembly, or product of a branded or Original Equipment Manufacturer product that is retained with the objective of restoring or improving its original functionality through remanufacturing, or for use as a source of parts for a remanufactured product. A core may have already been placed on the market and used, been damaged after production but before sale, or been subject to an extended shelf life. During reverse logistics, a core is protected, handled and

identified for remanufacturing to avoid damage and to preserve its value. A core is not waste or scrap and is not intended to be reused before being remanufactured.

- (d) **Disassembly**  
Complete sequential removal of parts of an assembled product into its constituent materials or parts.
- (e) **Lifecycle of the remanufactured product**  
The complete process from recovery at the end of a product's first useful life, through the remanufacturing of the core, sales, remarketing and use of the remanufactured product, to the disposition of the product when returned at the end of the use cycle of the remanufactured product.
- (f) **Part**  
The smallest, indivisible unit of a remanufactured product; individual parts may be combined or connected together to create a subassembly, assembly, system, or remanufactured product.
- (g) **Product verification**  
Process of using established, documented test and/or inspection procedures to confirm that the specific requirements are fulfilled for the intended use of a product.
- (h) **Remanufactured product**  
The as-new/like-new remanufactured finished article resulting from the recovery and transformation of core using the remanufacturing process described in this standard.
- (i) **Remanufacturing**  
Remanufacturing is a comprehensive and rigorous industrial process by which a previously sold, leased, used, worn, or non-functional product or part is returned to a "like-new" or "better-than-new" condition, from both a quality and performance perspective, through a controlled, reproducible and sustainable process in conformance with the specifications listed in Section 6 of this standard.
- (j) **Technical specifications**  
A collection of product documents that provide a detailed description of technical requirements, with specific acceptance criteria, and form the basis for the design, development and production processes of a product and ensure that a remanufactured product delivers a performance and service life functionally equivalent to that of a new product.

## 6. Specifications for the process of remanufacturing

The order of various steps may differ depending upon the product being remanufactured. An example of a typical flow map for the process of remanufacturing incorporating the specifications in this section is illustrated in Figure 1.



**Figure 1: Example of Flow map for the Process of Remanufacturing**

**6.1. Quality management system**

Product remanufacturing shall be conducted in a manner consistent with a recognized quality management system, such as ISO 9001:2008 or ISO 13485:2003.

**6.2. Control of nonconforming product**

The organization shall ensure that product which does not conform to minimum product technical specifications is identified and addressed to prevent reintroduction into the market, as detailed in the quality management system referenced above. A documented procedure shall be established to define the process for dealing with such a nonconforming product.

When nonconforming product is corrected such a product shall be subject to re-verification to demonstrate conformity to these specifications.

**6.3. Obtain technical specifications**

The organization shall obtain or create technical specifications for the remanufactured product to validate the “equivalent, or better, condition and performance” compared to the new original product.

**6.4. Core collection/acquisition**

The organization shall collect or acquire the core using appropriate documented quality control processes.

**6.5. Inspection of core**

The core shall be inspected against documented acceptance criteria to determine whether the core is suitable for remanufacturing<sup>3</sup>. Documentation shall include the appropriate criteria, such as quality, condition, economic, cosmetic, etc., as well as the techniques to be used to conduct the evaluation, and the disposition of cores that fail to meet the acceptance criteria.

**6.6. Disassembling the core**

The core shall be disassembled to the appropriate level into its constituent parts and/or materials. The organization shall obtain or create documentation to ensure and record the appropriate level of disassembly for each product and process.

**6.7. Cleaning**

The core may be cleaned (and disinfected, if appropriate) before disassembly, as necessary. After disassembly, parts shall be cleaned using documented procedures to remove all foreign materials (e.g., soil, grease, paint, surface oxidation, etc.) to facilitate appropriate inspection of the core parts before their use in reassembly of the product.

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<sup>3</sup> In some situations, a core must be disassembled (Section 6.6) before inspection

### **6.8. Inspection of parts**

Product parts shall be inspected and functionally evaluated using documented procedures to determine their eligibility for reuse. Parts that do not meet the documented acceptance criteria shall be remanufactured or replaced with new parts to ensure conformance with original specifications from both a quality and performance perspective.

### **6.9. Reassembly**

The product shall be reassembled, applying engineering updates and replacing worn or damaged parts with new or like-new parts, as appropriate according to documented technical specifications.

### **6.10. Finishing**

The product shall be coated/finished to meet the necessary cosmetic finish in accordance with documented technical specifications. This may include coating/finishing with appropriate surface coating materials or casing, as appropriate.

### **6.11. Performance verification**

The product shall undergo performance testing using established, documented test procedures to confirm that its performance meets the technical specifications described in Section 6.3.

### **6.12. Packaging**

The product shall be packaged in accordance with any applicable legal requirements and conform to any prevailing business practices for packaging.

## **7. Conformance with this standard**

In order to conform to this standard, the organization shall document consistent implementation of the specifications described in Section 6 of this standard. If the organization determines that any specification is not applicable to the remanufacturing of its product, the organization shall detail fully any deviation, variance or omission of any particular specification and the rationale for such determination in its process documentation<sup>4</sup>.

## **8. Verification of conformance with this standard**

The organization may apply to an accredited third-party in order to qualify for self-declaration of conformity to this standard. Such an application shall include detailed, written documentation to establish systematic implementation of the process described in Section 6 of this standard.

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<sup>4</sup> Some industries may be required to use other terms, such as refurbishing or reconditioning, in order to comply with regulatory requirements even though their processes conform to the remanufacturing specifications described in this standard.

Absent any accredited third-party verification, the validity of any claim of conformity with this standard made by, or on behalf of, the remanufacturing organization shall be understood to be the responsibility of the claimant.

## **9. Marking and labeling of product**

The organization may label products that meet or exceed this standard with a label or mark certifying conformance with this standard. The label should be clearly visible on the product, associated packaging, or documentation, as appropriate, and should include a reference to this standard, i.e., RIC001.1-2016. In addition, the label may include one or more of the following:

- Information to identify the product
- “Remanufactured by [REMANUFACTURING COMPANY NAME]”
- “Remanufactured on behalf of [NAME OF ORIGINAL EQUIPMENT MANUFACTURER]”
- “Remanufactured by [REMANUFACTURING COMPANY NAME] on behalf of [NAME OF ORIGINAL EQUIPMENT MANUFACTURER]”