



उत्पाद मैनुअल
मोल्डेड रबड़ यूनिट आउटसोल
भारतीय मानक 5676: 2026 के अनुसार

**PRODUCT MANUAL
FOR
MOULDED RUBBER UNIT OUTSOLES
ACCORDING to IS 5676: 2026**

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो) अनुरूपता मूल्यांकन (विनियम, 2018 की योजना -I के तहत प्रमाणन के संचालन में एकरूपता और पारदर्शिता के लिए इस उत्पाद मैनुअल का उपयोग सभी क्षेत्रीय / शाखा कार्यालयों और लाइसेंसधारियों द्वारा संदर्भ सामग्री के रूप में किया जाएगा। दस्तावेज़ का उपयोग बीआईएस प्रमाणन प्राप्त करने के इच्छुक संभावित आवेदकों द्वारा भी किया जा सकता है।

This Product Manual shall be used as reference material by all Regional/Branch Offices & licensees to ensure uniformity of practice and transparency in operation of certification under Scheme-I of Bureau of Indian Standards (Conformity Assessment) Regulations, 2018 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification.

1.	मानक संख्या IS No.	:	IS 5676: 2026
	शीर्षक Title	:	मोल्डेड रबड़ यूनिट आउटसोल Moulded Rubber Unit Outsoles.
	संशोधनों की संख्या No. of amendments	:	Nil
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	No specific requirement.
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Not applicable.
c)	नमूने का परिमाण Sample Quantity	:	02 Nos. <i>Note: This section indicates the quantity of the sample of the product and/or the raw material (if applicable), required to be sent to the laboratory for testing, for the purpose of Grant of Licence/Change in Scope of Licence/ Factory Surveillance (in case of market surveillance, effort may be made to procure the required quantity of product sample, as far as possible since raw material sample may not be available in</i>

		market)
d)	परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर Parameters to be Declared in Test Request	-- <i>Note: Apart from the above, any other requirements/parameters may also be declared as per the standard, as applicable.</i>
3.	परीक्षण उपकरणों की सूची List of Test Equipment	: Please refer to Annex-A.
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	: Please refer to Annex-B.
5.	एक दिन में संभावित परीक्षण Possible tests in a day	
	Size, Design, Thickness, Tensile strength, Elongation at break. <i>Note: This section is for the guidance of BIS Certification Officers/Technical Auditors of BIS Authorized Outside Surveillance Agencies(OSAs) during factory inspection to provide ready reference regarding the tests which can be witnessed during the inspection in the factory by the officer/auditor.</i>	
6.	लाइसेंस का दायरा/Scope of the Licence:	
	“Licence is granted to use Standard Mark as per IS 5676: 2026 with the following scope:	
	Name of the product	Moulded Rubber Unit Outsoles
	Grade / Type / Variety etc.	-

BUREAU OF INDIAN STANDARDS
MANAK BHAVAN,9, BAHADUR SHAH ZAFAR
MARG,NEW DELHI-110002

ANNEX - A
LIST OF TEST EQUIPMENT
(INDICATIVE LIST, FOR GUIDANCE ONLY)

Clause	Requirement	Test Facilities
4.4	Thickness	• Adequate instrument with 0.1 mm scale/graduation • Cutter
4.5, Table 1, Sl. No. i)	Density	• Laboratory Balance • Accessories • Balance Pan Straddle • Sinker • Weight • Suitable Device to Suspend the Test Specimen • Distilled or Deionised Water • Cutter • Wetting Agent • Arrangement for Environment of $(23 \pm 2) ^\circ\text{C}$ • Vernier or Digital Calliper • Standard Laboratory Dial Thickness Gauge for Rubber
4.5, Table 1, Sl. No. ii)	Hardness	• Durometer, Type A with Presser foot and Indenter • Arrangement for $27 \pm 2^\circ\text{C}$ and relative humidity of 65 ± 5 percent
4.5, Table 1, Sl. No. iii)	Flexing Resistance, Bennewart Method	• Flexing Machine • Mandrel • Clamps • Means of counting the total number of flexing cycles • Means of flexing the specimens at a rate of 125 to 150 cycles per minute through an angle of $90^\circ \pm 2^\circ$ about the axis of the mandrel • Vernier Callipers • Chisel • Device for measuring the temperature of environment surrounding the test specimen • Standard Thickness Gauge for Rubber
	Flexing Resistance, Ross Flex Method	• Ross Flexing Machine • Piercing Tool and Holder • Rule • Arrangement for Environment of $(23 \pm 2) ^\circ\text{C}$ • Timer
4.5, Table 1, Sl. No. iv)	Abrasion Resistance	• Abrasion Machine • Abrasive Sheet • Hollow Drill • Balance • Standard Reference Compounds
4.5, Table 1, Sl. No. v and vi)	Tensile Strength and Elongation at Break	• Dies and Cutters • Thickness Gauge • Cone Gauge • Tensile-Testing Machine • Test Rig for Ring Test Pieces

4.5, Table 1, Sl. No. vii)	Tear Strength	• Dies • Nick cutter • Testing machine • Grips • Razor Blade or a Sharp Knife • Thickness Gauge
----------------------------------	---------------	---

The above list is indicative only and may not be treated as exhaustive.

ANNEX - B
**SCHEME OF INSPECTION AND
TESTING**

1. QUALITY ASSURANCE PLAN

1.1 It is expected that during operation of BIS licence, manufacturers will implement a Quality Assurance Plan (QAP) i.e. a plan of regular testing and in-process controls, designed to ensure that the product bearing the Standard Mark conforms to all requirements of the Indian Standard.

1.2 The manufacturers shall define a Quality Assurance Plan (QAP) defining the control unit (i.e. lot/batch etc.), the levels of control (i.e. the frequency and number of samples for conducting the different tests as per the Indian Standard) and declare the arrangement for testing i.e. whether in-house or subcontracting/sharing for each applicable test and submit the same to BIS Branch Office for information. The manufacturer shall comply with the QAP and maintain test records in accordance with para 2.1.

1.3 RECOMMENDED LEVELS OF CONTROL/CONTROL UNIT:

1.3.1 For the guidance of manufacturers, the recommended definition of control unit is: *50,000 pairs or Fortnight production (whichever is earlier) of Moulded Rubber Unit Outsoles of the same size and design, manufactured from the same material.*

1.3.2 For the guidance of manufacturers in preparing the Quality Assurance Plan, recommended levels of control are given in [Table 1](#). Manufacturer has the discretion of declaring their own levels of control or accept the levels of control given in this document.

1.3.3 The manufacturer shall ensure inspection and testing as per the Quality Assurance Plan submitted by them on the whole production of the factory which is covered by this plan.

2. ENSURING COMPLIANCE THROUGH TESTING- manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard for which they may have in-house test facilities. However, there is no obligation to maintain in-house laboratory. Licensee may use alternative arrangements for tests of the production as per the declared QAP. Various alternatives are available for operation of BIS certification as given below and the relevant guidelines for availing such relaxations by the manufacturers, as amended from time to time, are to be referred:

- i) Shared testing resources like common facility,
- ii) Cluster based testing facility,
- iii) Sub-contracting to outside laboratories which may either be:
 - a) BIS recognised/empanelled laboratories, or

b) Any accredited laboratory as per ISO/IEC 17025

2.1 TEST RECORDS- The manufacturers shall maintain test records for the tests carried out (either in-house or at a sub-contracted or at shared test facility) to establish conformity of the product to the Standard for operation of licence. For the tests being subcontracted or conducted at a shared test facility, test results issued by the laboratories or test facilities, shall be made available for inspection by BIS.

3. PACKING AND MARKING - The Standard Mark, as given in the Schedule of the licence, shall be incorporated legibly and indelibly on each Moulded Rubber Unit Outsoles, provided always that the material so marked, conform to every requirement of the specification.

3.1 Packing and marking shall be done as per the provision of the Indian Standard.

3.2 **Additional Marking requirements:** Additionally, the following shall also be marked on each Moulded Rubber Unit Outsoles:

a) "For BIS certification details please visit www.bis.gov.in"

4. REJECTION - The production which conforms to the Indian Standard and covered under the scope of this licence shall be marked with the Standard Mark. Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act,2016.

5. Applicability of SIT for Small and Micro Enterprises (SMEs):

5.1 Compliance to the Scheme of Inspection and Testing is OPTIONAL for Micro, and Small Scale Units with respect to the requirements for Clause 1(Quality Assurance Plan), Clause 2 (Ensuring Compliance through Testing). However, ALL units shall ensure compliance of their products to the requirements of the Indian Standard.

5.2 The requirements of SIT with respect to Clause 3 (Packing and Marking) and Clause 4 (Rejection) shall be followed by all.

TABLE 1

(Recommended Levels of Control by BIS - For Guidance Only)

(1)				(2)	
Test Details				Levels of Control	
<i>Clause</i>	<i>Requirement</i>	<i>Test Methods</i>		<i>No. of Sample</i>	<i>Frequency</i>
		<i>Clause</i>	<i>Reference</i>		
4.1	General	4.1	IS 5676	Firm to have adequate in-process controls to check compliance of these parameters as per the Indian Standard. Appropriate records shall be maintained.	
4.2	Design	4.2	IS 5676		
4.3	Size	-	IS 1638		
4.4	Thickness	-	IS 15298 (Part 1)		
4.5, Table 1, Sl. No. i)	Density	-	IS 10702	One	Each Control Unit
4.5, Table 1, Sl. No. ii)	Hardness	-	IS 12240 (Part 2)	One	Each Control Unit
4.5, Table 1, Sl. No. iii)	Flexing Resistance, Bennewart method	-	IS 15844 (Part 1)	One	Once in a Month
	Flexing Resistance, Ross Flex Method	-	IS 3400 (Part 16)		
4.5, Table 1, Sl. No. iv)	Abrasion Resistance	-	IS 3400 (Part 3)	One	Once in a Month
4.5, Table 1, Sl. No. v and vi)	Tensile Strength and Elongation at Break	-	IS 3400 (Part 1)	One	Each Control Unit
4.5, Table 1, Sl. No. vii)	Tear Strength	Method A	IS 3400 (Part 12)	One	Each Control Unit