



उत्पाद मैनुअल
मोल्डेड पीवीसी यूनिट आउटसोल
भारतीय मानक 6719: 2026 के अनुसार
PRODUCT MANUAL
FOR
MOULDED PVC UNIT OUTSOLES
ACCORDING to IS 6719: 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 6719: 2026
	शीर्षक Title	: मोल्डेड पीवीसी यूनिट आउटसोल Moulded PVC Unit Outsoles.
	संशोधनों की संख्या No. of amendments	: Nil
2.	नमूना दिशानिर्देश Sampling Guidelines	
a)	कच्चा माल Raw material	: PVC resin or blends with its copolymers as per Cl. 4.1. <i>Note: This section indicates the requirements for raw material (if specified in the IS) for which compliance is to be established during Grant of Licence/Change in Scope of Licence/Factory Surveillance.</i>
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	: Moulded PVC Unit Outsoles of any size may be tested to cover all the sizes, subject to availability of necessary manufacturing and applicable testing facilities.

c)	नमूने का परिमाण Sample Quantity	04 pairs along with test slabs made of the same composition as per CI C-3.2. *The manufacturer shall issue certificate to the effect that these slabs are made with the same composition and cured under technical identical condition wherever required. : <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 market)</i>
d)	परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर Parameters to be Declared in Test Request	Size. : <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	
	All tests possible in a day (on Pre conditioned samples, as applicable). <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 6719: 2026 with the following scope:	
	Name of the product	Moulded PVC Unit Outsoles
	Sizes	As applicable.

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)

Cl. No.	Test	Method of Test	Test Facilities
Table 1, i)	Relative Density	IS 10702	1. Weighing Balance 2. Cradle suspended from a top hook with Balance pan straddle – arrangement. 3. Beaker (250 ml) 4. Copper wire (0.1 mm diameter) 5. Distilled water 6. Knife 7. Arrangement to condition and carry out the test at $27^{\circ}\text{C} \pm 2^{\circ}\text{C}$ 8. Wetting agent such as methanol. 9. Vernier or digital calliper 10. Dial thickness gauge
Table 1, ii)	Hardness	IS 12240 (Part 2)	1. Type A Shore durometer 2. Arrangement to condition and carry out the test at $27^{\circ}\text{C} \pm 2^{\circ}\text{C}$ and relative humidity of 65 ± 5 percent 3. Pan Balance 4. Timer
Table 1, iii)	Volatility	Annex B	1. Oven 2. Desiccator 3. Disc cutter 4. Arrangement to condition at $27^{\circ}\text{C} \pm 2^{\circ}\text{C}$ and relative humidity of 65 ± 5 percent 5. Balance
Table 1, iv)	Lead content	IS 12240 (Part 5)	1. Glassware 2. Reagents including standard lead solution 3. Balance 4. Whatman filter paper No. 41 or equivalent
Table 1, v)	Flexing resistance, Bennewart method	IS 15844 (Part 1)	5. Flexing machine [see Fig. 4 (a) and Fig. 4 (b) of IS 15844 (Part 1)] 6. Vernier Callipers 7. Chisel 8. A device for measuring the temperature of environment surrounding the test specimen to an accuracy of $\pm 1^{\circ}\text{C}$ 9. A standard thickness gauge for rubber
Table 1, vi)	Abrasion resistance	IS 3400 (Part 3)	1. Abrasion machine as per cl 5.1 of IS 3400 (Part3) 2. Abrasive sheet as per cl 5.2 3. Hollow drill 4. Balance 5. Standard reference compounds 6. Arrangement to condition and carry out test at Standard laboratory

			temperature 7. Timer
Table 1, vii)	Thickness	IS 12240 (Part 1)	1. Thickness dial gauge calibrated in 0.1 mm or equivalent apparatus 2. Graduated eye piece with 0.1 mm scale spacing of travelling microscope or Screw gauge
Table 1, viii)	Tear strength	IS 3400 (Part 2)	1. Tensile testing machine as per Cl 5.3 of IS 3400 Part 12 2. Die for test specimens 3. Nick cutter 4. Grips 5. Arrangement to condition and carry out test at Standard laboratory condition.

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 PVC 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 PVC 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. In addition, the material shall also be marked (through tags/stickers or otherwise) with the following additional requirement on the package/Product (in case only bulk packaging is done):

a) BIS Licence No. CM/L _____.

b) BIS website details: "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 to 4.4	Material	4	IS 6719	-	Each consignment of raw material
4.5, Table 1, i)	Relative Density	-	IS 10702	One	Each Control unit
4.5, Table 1, ii)	Hardness	-	IS 12240 (Part 2)	One	-do-
4.5, Table 1, iii)	Volatility	Annex B	IS 6719	One	-do-
4.5, Table 1, iv)	Lead Content	-	IS 12240 (Part 5)	-	Each consignment of raw material
4.5, Table 1, v)	Flexing Resistance	-	IS 15844 (Part 1)	One	Each Control unit
4.5, Table 1, vi)	Abrasion Resistance	-	IS 3400 (Part 3)	One	-do-
4.5, Table 1, vii)	Thickness	-	IS 12240 (Part 1)	One	-do-
4.5, Table 1, viii)	Tear Strength	-	IS 3400 (Part 12)	One	-do-