



उत्पाद मैनुअल
Unlined moulded rubber boots – Specification
IS 13995 : 1995 के अनुसार

PRODUCT MANUAL
FOR Unlined moulded rubber boots – Specification
ACCORDING TO IS 13995 : 1995

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना- I के तहत प्रमाणन के संचालन में अभ्यास और पारदर्शिता के संचालन में पारदर्शिता सुनिश्चित करने 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 लाइसेंस/प्रमाणपत्र 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 coherence 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 licence/certificate.

1.	उत्पाद Product	:	IS 13995 : 1995
	शीर्षक Title	:	Unlined moulded rubber boots – Specification
	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	:	Please refer Annex-A
c)	नमूने का आकार Sample Size	:	4 pairs+ Raw material
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer Annex-B

4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer Annex-C
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	Thickness, Tensile requirements before ageing, tear resistance of upper, design, size		
6.	लाइसेंस का दायरा /Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 13995 : 1995 with the following scope:		
	Name of the product	Unlined moulded rubber boots	
	Design	Fig. 1,2,3 as per IS 5557	
	Sizes	Men's - 5 – 11 (As per IS 5557/IS 1638) Women's - 5 – 11 (As per IS 5557/IS 1638)	

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ANNEX-A

GROUPING GUIDELINES

The following grouping guidelines shall apply for Grant of Licence (GoL)/Change in Scope of Licence (CSoL):

- i) The manufacturer shall declare the sizes (as per IS 1638) and the design of boots being manufactured.
- ii) Samples of any of the sizes and each design of boots being manufactured shall be tested. (The designs, duly authenticated by the manufacturer shall be submitted to BIS). Separate samples of men's and women's boots shall be tested.
- iii) Scope of the licence shall be restricted based on the manufacturing and testing capability
- iv) During the operation of licence, samples of each variety covered in the scope of licence shall be tested in rotation.

ANNEX – B

LIST OF TEST EQUIPMENTS

Major test equipment required to test as per the Indian Standard

Sl. No.	Tests Used In With Clause Reference	Test Equipment/Chemical
1	Thickness, Cl. 4.1	Thickness tester
2	Tensile requirements before ageing – breaking strength and elongation at break, Cl. 5.1.1	Tensile Testing Machine
3	Tensile requirements after ageing, Cl.5.1.2	Tensile Testing Machine, Ageing oven capable of maintaining temperature of 70 deg. C for 168 h
4	Tear resistance of upper, Cl.5.1.3	Tear resistance testing machine, dies, cutter, grips
5	Resistance to dry heat ageing, Cl. 5.1.4	Air oven, apparatus for dry heat ageing test
6	Flexing resistance of upper, Cl. 5.1.5	Flexing resistance apparatus

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

ANNEX C

SCHEME OF INSPECTION AND TESTING

1. **LABORATORY-** A laboratory shall be maintained, which shall be suitably equipped (as given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the method given in the specification.

1.1 The manufacturer shall prepare **and implement a** calibration plan for the test equipment.

2. **TEST RECORD-** The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. **PACKING AND MARKING** - The Standard Mark as given in the Schedule of the licence shall be incorporated legibly and indelibly on each piece of footwear provided always that the material so marked conforms to each requirement of the specification.

3.2 Packing and Marking shall be done as per the Indian Standard. The footwear and/or the package shall also be marked with the following:

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

5. **CONTROL UNIT-** For the purpose of this scheme, entire quantity of footwear of the same design, produced from the same consignment of raw material under similar conditions of manufacture in a day shall be taken as one control unit.

6. **LEVELS OF CONTROL :-** The tests as indicate in Table 1 and at the levels of controls in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and records maintained in accordance with paragraph 2 above.

6.1 All the production which conforms to the Indian Standard and covered under the scope of this licence shall be marked with the Standard Mark.

7. **REJECTION** - 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.

TABLE1
LEVELS OF CONTROL

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or)S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods Clause Reference			No. of Sample	Frequency	Remarks
4.1	Thickness	4.1	IS 13995:1995	R	Manufacturer shall ensure adequate inspection and in process control to ensure product meets specified thickness requirement		
5.1.1	Tensile requirements before ageing		IS 3400 (Part 1)	R	3	Each control unit	
5.1.2	Tensile requirements after ageing	5.1.2	IS 13995:1995	R	3	Each month	
5.1.3	Tear resistance of upper		IS 3400 (Part 12)	R	3	Each control unit	
5.1.4	Resistance to dry heat ageing		IS 3400 (Part 4)	S	One	Each month	
5.1.5	Flexing resistance of upper	Annex A	IS 13995:1995	S	One	Each month	

5.1.6	Design	5.1.6	IS 13995:1995	R	Manufacturer shall ensure adequate inspection and in process control to ensure product meets specified design	
5.1.7	Size	5.1.7	IS 13995:1995	R	Manufacturer shall ensure adequate inspection and in process control to ensure product meets specified size	

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit/batch/lot and submit his own levels of control in column 3 with proper justification for approval by BO Head.

Note-3: It shall be ensured that all different sizes being manufactured are tested in rotation.