



उत्पाद मानुयल
इस्पात की चारखानेदार प्लेटें
आईएस 3502 : 2009 के अनुसार

**PRODUCT MANUAL
FOR STEEL CHEQUERED PLATES
ACCORDING TO IS 3502:2009**

भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम 2018 की स्कीम-I के तहत यह उत्पाद मानुयल प्रमाणीकरण के प्रचलन में रीति और पारदर्शिता के सुसंगतता सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों एवं लाइसेन्स धारियों द्वारा संदर्भ सामग्री के रूप में उपयोग किया जाएगा। बीआईएस लाइसेन्स/प्रमाण पत्र प्राप्त करने के इच्छुक भावी आवेदकों द्वारा भी इस दस्तावेज़ का उपयोग 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 3502:2009
शीर्षक Title	:	इस्पात की चारखानेदार प्लेटें Steel Chequered Plates
संशोधनों की संख्या No. of amendments	:	NIL
2. नमूना दिशानिर्देश Sampling Guidelines		
a) कच्चा माल Raw material	:	Base material shall be as per Grade E250A of IS 2062 unless otherwise specified
b) समूहीकरण दिशानिर्देश Grouping guidelines	:	Not Applicable
c) नमूने का आकार Sample Size	:	Mechanical : 500 mm X 300 mm sample (preferably prepared samples for mechanical tests to be drawn and sent to lab) Chemical : 100 gm drilling or 50 mm X 50 mm chips
3. परीक्षण उपकरणों की सूची List of Test Equipment	:	कृपया Annex-A देखें Please see Annex-A
4. निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	कृपया Annex-B देखें Please refer Annex –B
5. एक दिन में संभावित परीक्षण Possible tests in a day		

	All tests
6.	लाइसेंस का दायरा /Scope of the Licence:
	IS 3502:2009 के अनुसार मानक मुहर का उपयोग करने के लिए लाइसेन्स निम्नलिखित कार्यक्षेत्रके लिए प्रदान किया जाता है Licence is granted to use Standard Mark as per IS 3502:2009 with the following scope:
उत्पाद का नाम Name of the product	Steel Chequered Plates
Sizes	Thickness x Width x Length (Based on manufacturing capacity available)

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

Annexure A
To Product Manual
For Steel Chequered Plates
According to Is 3502:2009

LIST OF TESTING EQUIPMENT

Major test equipment essentially required to test as per requirements of Indian Standard.

Sl. No.	Test Equipment/Chemicals and Identification Numbers (Where applicable)	Tests Used in with Clause Reference
1.	Vernier Callipers	Cl.10& 15
2.	Micrometer	Cl. 10& 15
3.	Steel Scale ,Try-square, Radius gauges, Filler Gauges, Depth gauges, Straight edges, Magnetic V- block, Angle Protector (combination set), Protector outside and inside calliper, Carbon Paper	Cl. 10& 15
4.	UTM (0-1000KN)	Cl.10
5.	Steel Mandrels (for bend tests), Templates(for Bend test), UTM attachments/clamps/vice/Magnifying glass	Mandrels is required on the basis of thickness of the products as given in Table-2 as per Cl.11.1 to 11.3
6.	Analytical balance (0-200g,Lc:0.1mg)	Cl.8
7.	Weigh M/c	Cl.15
8.	Steel tape	Cl.15
9.	Instrumental methods Spectrometer: atomic-absorption spectrometry, inductively coupled plasma atomic emission, inductively coupled plasma mass spectrometry techniques, spark source optical emission spectrometry. Spectrophotometer	Cl 8.1,8.2 for C,S,P, Mn, Si, Al, Cu, Micro alloying and alloying elements content Mn, S, P, Si
10.	Strohlein or Leco apparatus with all attachments Barometer with chart, Hot plate, Muffle furnace, Complete range of glass wares, measuring cylinders, Desiccator, porcelain boats or ceramic crucibles, Thermometer, Electronic Balance, Distilled Water, Hot air oven, Oxygen - 99.5 percent minimum purity, ether or acetone Standard Reference Material (NML) with certificate Reagents for C: tin granules or pure iron fillings, acidulated water/brine water, methyl red, caustic potash	cl.8.1, 8.2 -C& S (chemical method, alternative to instrumental method)
11.	Reagents for S: Ceramic boats/crucibles –desiccators, Fluxes -Low sulphur copper, tin or iron, Dilute hydrochloric acid, Starch Iodide solution, Potassium iodate	Phosphorus content Cl8.1,8.2 (chemical method, alternative to instrumental method)

	Weighing balance, Heater/ Heating element along with energy regulator, Ice water bath, Vol Flask Cap – 1 litre, (Whatman) filter paper No. 040, Suction Filtration Facility, Filter paper pulp pad, Standard Reference Material (NML) with certificate Potassium Permanganate (KMnO_4), Sodium Nitrite (Na_2NO_3), Ammonium Molybdate [$(\text{NH}_4)_2 \text{Mo}_2\text{O}_7$], Ammonium Phosphate [$(\text{NH}_4)_3 \text{PO}_4$], Potassium Nitrate ($\text{K}_2\text{NO}_3$), Phenolphthalein Solution, Rectified spirit or methyl alcohol, Sodium Hydroxide (NaOH), Hydrofluoric Acid (HF), Perchloric Acid (HClO_4), Sulphurous Acid, Hydrobromic Acid (HBr), other chemicals and reagent as applicable	
12.	Hot plate, Conical flask Reagents: silver nitrate, ammonium per sulphate sodium arsenite solution, Dilute Nitric Acid, Phosphoric Acid, Dilute Sulphuric Acid, Concentrated Nitric Acid, NaCl Solution, Permanganic acid	Manganese content CI8.1,8.2 (chemical method, alternative to instrumental method)
13.	Medium textured filter paper, Porcelain casserole, platinum crucible, filter paper pulp, hot plate, hot air oven, muffle furnace Reagents: Silver nitrate solution, concentrated nitric acid, concentrated sulphuric acid, Dilute Hydrochloric Acid, Dilute Sulphuric Acid, Perchloric Acid, Tartaric acid and hydrofluoric acid	Silicon content CI8.1,8.2 (chemical method, alternative to instrumental method)
14.	Plate, Muffle Furnace, porcelain or silica crucible, Reagents: Hot Wash Solution (dilute sulphuric acid solution 1 : 99 v/v with hydrogen sulphide), dilute sulphuric acid, hydrogen sulphide, Dilute Nitric Acid, Sodium Fluoride, solid, Dilute Ammonium Hydroxide, Acetic Acid, Potassium Iodide, Starch Solution, Sodium Thiosulphate Solution, Ammonium Bifluoride Solution	Cu content CI8.1,8.2 (chemical method, alternative to instrumental method)
15.	ashless paper pulp, paper pulp pad, hot plate, dessicator, Reagents: ammonium nitrate, methyl red, dilute ammonium hydroxide, Concentrated hydrochloric acid, Concentrated nitric acid, Perchloric acid, Hydrofluoric Acid	Ni content CI8.1,8.2 (chemical method, alternative to instrumental method)
16.	Hot plate, stop watch Reagents: dilute sulphuric acid and phosphoric acid mixture, concentrated nitric acid, ammonium per sulphate, silver nitrate, dilute hydrochloric acid, ferrous ammonium sulphate, standard potassium permanganate solution.	Cr content CI8.1,8.2 (chemical method, alternative to instrumental method)

Nitrogen content shall be occasionally tested.

Least Count and Range should match the values/parameters/tolerances mentioned in the Indian Standard.

The above list is meant only for guidance and may not be treated as exhaustive.

ANNEXURE B
To Product Manual
For Steel Chequered Plates
According to Is 3502:2009

SCHEME OF INSPECTION AND TESTING

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

The manufacturer shall prepare a calibration plan for the test equipments.

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

3. MARKING -The Standard Mark, as given in the Schedule of the license shall be marked on the top of each steel chequered plate provided that the material thus marked conforms to the requirement of the specification.

Marking shall be done as per the provisions of the standard. In addition, details of BIS Certification i.e. BIS Licence Number CM/L—and BIS website shall be marked on the top plate of each pile of chequered plates or shown on a tag attached to each pile as follows

For details of BIS certification please visit www.bis.gov.in

4. CONTROL UNIT – For the purpose of this scheme the material or part thereof manufactured from steel of the same grade and from the same cast subject to a maximum of 40 tonnes shall constitute a control unit.

5. LEVELS OF CONTROL - The tests as indicated in column 1 of Table 1 and the levels of control in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with paragraph 2 above.

All the production which conforms to the Indian Standards and covered by the licence should be marked with Standard Mark.

6. TEST CERTIFICATE-1) For each consignment of BIS Certified material conforming to this specification there shall be a test certificate which shall contain the Standard Mark, the lot/cast number and the corresponding test results (as given in Annexure I enclosed).

7. REJECTIONS – 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. Any rejected material which is potentially resalable be sheared or cut or deformed in such a manner that it cannot be used for any other purpose. A separate record shall be maintained giving information on quantity and batch number/control unit number, as applicable, relating to all such rejections/defective/substandard material of the production not conforming to the requirements of the Specification and the method of its disposal. Such material shall in no case be stored together with that conforming to the Specification. The Standard Mark (if already applied) on rejected material should be defaced.

TABLE 1
LEVELS OF CONTROL
(Clause 5 of SIT)

(1)				(2)	(3)		(4)
TEST DETAILS					LEVELS OF CONTROL		REMARKS
Clause	Requirements	Test Method		Test equipment requirement R: required (or) S: Sub-contracting permitted	No. of Samples	Frequency	
		Clause	Reference				
5	Freedom from defects	5	IS 3502	R	Adequate inspection to ensure each item to be free from surface defects.		
4	Material	4	IS 228 (Various Parts) Or any established Chemical/ Instr. method	S	One sample from each 100 MT of material or part thereof rolled from the same cast No further testing is required if the material received is ISI marked and is received with Test Certificate		
8	Tensile Test	8.1	IS 1608 (Part 1)	R	One	Every Control Unit	
9	Bend Test	9.1	IS 1599 IS 3502 IS 2062	R	One	Every Control Unit	
10.1 to 10.2	Dimensions and Rolling Tolerances		IS/ISO 7452	R	Adequate inspection to ensure each item conforms nominal dimensions and tolerances stipulated in relevant standard.		
6 & 10.3	Pattern & Chequered Height	6 & 10.3	IS 3502:2009	R	Adequate inspection to ensure each item conforms nominal dimensions and tolerances stipulated in relevant standard.		

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 empaneled by the Bureau.

Note-2: The control unit and levels of control as decided by the Bureau are obligatory to which the licensee shall comply with.

ANNEXURE I

(Para 6 of the Scheme of Inspection and Testing)

XYZ IRON AND STEEL COMPANY (Registered office Address and works address)

**TEST CERTIFICATE FOR
Steel Chequered Plates According to IS
3502:2009**BIS
STANDARD
MARKTEST CERTIFICATE No. _____ DATE _____
To M/s _____

We certified that the material described below fully conforms to IS 3502:2009. Chemical composition and Physical properties of the product, as tested in accordance with the Scheme of Inspection and Testing contained in the BIS Certification Marks Licence No. CM/L____ are as indicated below against each order No.

(PLEASE REFER TO IS 3502:2009 FOR DETAILS OF SPECIFICATION REQUIREMENTS)

TEST RESULTS

Order No. and date	Nominal Size in mm (TxWxL)	Cast/Lo No.	Steel grade	Quantity (tonnes)	Chemical Composition				Mechanical Properties				Remarks
					C%	Mn%	S%	P%	YS (Mpa)	TS (Mpa)	Elongation%	Bend Test	

REMARKS

WAGON NO.

TRUCK NO.

(It is suggested that size A4 paper be used for this test certificate)

FOR XYZ IRON AND STEEL COMPANY