



उत्पाद मैनुअल
भा. मा. 1019: 1974 के अनुसार
रिम लैचेस के लिए
दस्तावेज संख्या-पी एम/आई एस 1019/1/जनवरी 2023

भारतीय मानक ब्यूरो की स्कीम-I (अनुरूपता मूल्यांकन) विनियम, 2018 के तहत यह उत्पाद मैनुअल प्रमाणीकरण के प्रचालन में रीति और पारिश्रिता की सुसंगतता सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों और लाइसेंसों द्वारा संदर्भ सामग्री के रूप में उपयोग किया जाएगा। बीआईएस प्रमाणीकरण लाइसेंस/प्रमाणपत्र प्राप्त करने के इच्छुक भावी आवेदकों द्वारा भी इस दस्तावेज का उपयोग किया जा सकता है।

**PRODUCT MANUAL FOR
RIM LATCHES
ACCORDING to IS 1019:1974**

Document No.-PM/IS 1019/1/ January 2023

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.

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1.	Product	:	IS 1019: 1974
	Title	:	Rim Latches
	No. of Amendments	:	One
2.	Sampling Guidelines:		
a)	Raw material	:	As per Table 1 of IS 1019: 1974 <i>Materials as per IS 1079, IS 280 and IS 4454 (Part 2) are under mandatory BIS Certification and manufacturer shall ensure that only ISI Marked material is used and is received with test certificate</i>
b)	Grouping guidelines	:	Please refer ANNEX – <u>A</u>
c)	Sample Size	:	2 Nos.
3.	List of Test Equipment	:	Please refer ANNEX – <u>C</u>
4.	Scheme of Inspection and Testing	:	Please refer ANNEX – <u>D</u>
5.	Possible tests in a day	:	All tests except finish tests as per IS 1868 (coating thickness and quality of coating can be tested)
6.	Scope of the Licence:		
	Licence is granted to use Standard Mark as per IS 1019:1974 with the following scope:		
	Name of Product	:	Rim Latches
	Material of body	:	Mild steel/Aluminium alloy/ Brass/ Zinc alloy
	Type	:	• Type 1 – Left Hand/Right Hand • Type 2
	Size	:	From...mm up to and including....mm

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ANNEX A

Grouping Guidelines

1. Rim Latches as per IS 1019: 1974 can be classified into different varieties based on the following:

(a) Types:

- Type 1: Left Hand/Right Hand
- Type 2

(b) Sizes: 75, 100, 125 and 150 mm

Further, Rim Latches can be manufactured in other sizes also as per mutual agreement between purchaser and supplier

2. Considering the above, one sample from each type (Type 1 and type 2 , and separate sample for left and right hand for Type 1) of Rim latches having minimum and maximum size shall be drawn to cover all the sizes of Rim Latches in that type tested.
3. The Firm shall declare the varieties of Rim Latches they intend to cover in the Licence. The Scope of Licence may be restricted based on the Manufacturing and Testing capabilities of the Manufacturer.
4. During the operation of the Licence, BO shall ensure that all the types and sizes covered in the Licence are tested in rotation, to the extent possible.

ANNEX B**List of Test Equipment***Major test equipment required to test as per the Indian Standard*

S.no.	Tests used in with Clause Reference		Test Equipment
	Cl. No.	Test	
1)	7.1, Fig.1, Fig.2, table 1, table 2	Dimensions	Vernier caliper
2)	9.2	Test of anodic coatings on Aluminium Rim Latches	Chemicals with reagents or Eddy current tester or other test equipment as per IS 1868 for coating thickness, Salt spray chamber for corrosion resistance test, other apparatus for abrasion resistance, resistance to crazing, fastness to light, Light reflection as per IS 5523, Apparatus for Electric potential breakdown (as per IS 6910) and continuity tests (as per IS 8375)
3)	10.1	Performance test	Test fixture

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

ANNEX D

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.

1.1 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. LABELLING AND MARKING – As per the requirements of IS 1019:1974. Additionally, size of Rim Latches shall also be marked on each piece or package.

4. CONTROL UNIT- Quantity of Rim Latches of same material, type and size, manufactured by the same method and under similar conditions in a day 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.

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

6. 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.

TABLE 1

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub- contracting permitted	Levels of Control		
Cl.	Requirement	Test Method			No. of Sample	Frequency	Remarks
		Clause	Reference				
5.1, 8.2, 8.3, Table 1	Material	5.1, 8.2, 8.3, Table 1	IS 1019 IS 1079 IS 280 IS 4454-2 IS 292 IS 318 IS 737	S	One	Each Consignment	No further testing is required if material is received with test certificate or is ISI Marked. Material as per IS 1079, IS 280 and IS 4454-2 are under mandatory BIS Certification and manufacturer shall ensure that material used is ISI Marked and received with test certificate
7.1	Dimensions	7.1, Fig.1, Table 1, Fig.2, Table 2	IS 1019	R	One piece from each hour of production		
8	Manufacture	8.2, 8.3	IS 1019	Manufacturer shall exercise adequate levels of control to ensure that entire production should conform to the Standard. Appropriate records of testing indicating conformity shall be maintained			
9	Workmanship and Finish	9.1, 9.1	IS 1019				
9.2	Tests for Anodic Coating on Aluminum Rim Latches						
	Thickness	9.2 9	IS 1019 IS 1868	R	One	Once in 3 months	
	Quality of sealing	9.2 9	IS 1019 IS 1868	R	One	Once in 3 months	

	Colour and appearance	9.2 11	IS 1019 IS 1868	S	One	Once in 3 months	
	Corrosion resistance	9.2 12	IS 1019 IS 1868	S	One	Once in 3 months	
	Abrasion resistance, If required by purchaser	9.2 13	IS 1019 IS 1868	S	One	Once in 3 months	
	Resistance to crazing by deformation	9.2 14	IS 1019 IS 1868	S	One	Once in 3 months	
	Fastness to light	9.2 15	IS 1019 IS 1868	S	One	Once in 3 months	
	Light reflection properties	9.2 16	IS 1019 IS 1868	S	One	Once in 3 months	
	Electrical Breakdown potential, if required by purchaser	9.2 17	IS 1019 IS 1868	S	One	Once in 3 months	
10.1	Performance test	10.1	IS 1019	R	One	Each Control Unit	

Note-1: 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.