



उत्पाद मैनुअल
भा. मा. 4385: 2022 के अनुसार
थ्रोइंग हैमेर्स के लिए
दस्तावेज संख्या-पी एम/आई एस 4385/1/दिसंबर 2022

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
THROWING HAMMERS
ACCORDING to IS 4385:2022**

Document No.-PM/IS 4385/1/ December 2022

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.

भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS
मानक भवन, ९, बहादुर शाह ज़फ़र मार्ग
Manak Bhawan, 9, Bahadur Shah Zafar Marg
नई दिल्ली- ११०००२
New Delhi – 110002



PRODUCT MANUAL FOR THROWING HAMMERS ACCORDING TO IS 4385: 2022

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.	Product	:	IS 4385: 2022
	Title	:	Throwing Hammers
	No. of Amendments	:	Nil
2.	Sampling Guidelines:		
a)	Raw material	:	--
b)	Grouping guidelines	:	Throwing Hammers as per IS 4385 are classified into following types based on requirements of different age group: WU18, WU20/SW, BU18, BU20, SM Separate sample of Throwing Hammers of each type shall be tested to cover all types of Throwing Hammers in the scope for Grant of Licence (GoL) and change in Scope of Licence (CSoL)
c)	Sample Size	:	2 Nos.
3.	List of Test Equipment	:	Please refer ANNEX –A
4.	Scheme of Inspection and Testing	:	Please refer ANNEX –B
5.	Possible tests in a day	:	All tests
6.	Scope of the Licence:	:	Licence is granted to use Standard Mark as per IS 4385:2022 with the following scope:
	Name of product	:	Throwing Hammers
	Type	:	WU18, WU20/SW, BU18, BU20, SM

BUREAU OF INDIAN STANDARDS
Manak Bhawan, 9, Bahadur Shah Zafar Marg,
New Delhi – 110002

ANNEX A**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.	4.1, Table 1, Fig.1	Dimension	Scale or caliper
2.	4.3, Table 1	Weight	Weighing balance
3.	5.1, Fig.3	Test for center of gravity of Head	Apparatus as per Fig. 3 of IS 4385
4.	5.2,	Handle Deformation test	Load gauge, vernier caliper or similar arrangement to measure deflection
5.	5.3	Breaking strength of Handle	Tensile testing machine or other suitable arrangement

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

ANNEX B

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 4385: 2022.

4. CONTROL UNIT- All Throwing Hammers of same type, manufactured under similar conditions from same consignment of raw material 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				
3	Manufacture, Workmanship and Finish	3	IS 4385	R	One	Each Control Unit	--
4.1	Shape and Dimensions	4.1, Table 1, Fig.1	IS 4385	R	One	Each Control Unit	--
4.2	Dimension of Wire	4.2.2	IS 4385	S	One	Each Consignment	No testing is required in case material is received with test certificate or is ISI Marked
4.3	Weight	4.3	IS 4385	R	One	Each Control Unit	--
5.1	Test for center of gravity of Head	5.1, Fig. 3	IS 4385	R	One	Each Control Unit	--
5.2	Handle Deformation test	5.2	IS 4385	R	One	Every 30 th Control Unit	--
5.3	Breaking strength of Handle	5.3	IS 4385	R	One	Every 30 th Control Unit	--

Note-1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled 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.