



उत्पाद मैनुअल
भा. मा. 6343: 1982 के अनुसार
हलके वजन के दरवाजों (40 किलोग्राम भार तक) के लिए वायवीय रूप से विनियमित डोर
क्लोजेर्स के लिए
दस्तावेज संख्या-पी एम/आई एस 6343/1/जनवरी 2023

भारतीय मानक ब्यूरो की स्कीम-I (अनुरूपता मूल्यांकन) विनियम, 2018 के तहत यह उत्पाद मैनुअल प्रमाणीकरण के प्रचालन में रीति और पारिशिष्ट की सुसंगतता सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों और लाइसेंसी 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
DOOR CLOSERS (PNEUMATICALLY REGULATED) FOR LIGHT
DOORS WEIGHING UPTO 40 Kg
ACCORDING to IS 6343:1982

Document No.-PM/IS 6343/1/ 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.

भारतीय मानक ब्यूरो
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PRODUCT MANUAL FOR DOOR CLOSERS (PNEUMATICALLY REGULATED) FOR LIGHT DOORS WEIGHING UPTO 40 Kg ACCORDING TO IS 6343: 1982

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1.	Product	:	IS 6343: 1982
	Title	:	Door Closers (Pneumatically Regulated) For Light Doors Weighing Upto 40 Kg
	No. of Amendments	:	Nil
2.	Sampling Guidelines:		
a)	Raw material	:	As per Table 1, Cl. 3.1 of IS 6343: 1982 Note: Manufacturers should check for the latest applicable cross referred Indian Standards on raw material and test methods with BIS
b)	Grouping guidelines	:	Please refer ANNEX –A
c)	Sample Size	:	2 Nos.
3.	List of Test Equipment	:	Please refer ANNEX –B
4.	Scheme of Inspection and Testing	:	Please refer ANNEX –C
5.	Possible tests in a day	:	Dimensions (Cl. 5.1), General Requirements (Cl. 6), Performance requirements (Cl. 7.1), Finish (Cl. 8- except tests as per Cl. 8.2.2 and 8.2.4)
6.	Scope of the Licence:	:	Licence is granted to use Standard Mark as per IS 6343:1982 with the following scope:
	Name of product	:	Door Closers (Pneumatically Regulated) For Light Doors Weighing Up to 40 Kg
	Type based on Suitability on direction of opening of door:	:	Right Closer/Left Closer/Universal Closer

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ANNEX A

Grouping Guidelines

1. “Door Closers (Pneumatically Regulated) For Light Doors Weighing Up to 40 Kg” as per IS 6343: 1982 are classified in to different varieties based on following:

Suitability based on direction of opening of door: Right Closer/Left Closer/Universal Closer

2. Considering the above, Door Closers of each Type based on direction of opening of door shall be tested for all the requirements to cover that variety tested.

3. The Firm shall declare the varieties of “Door Closers (Pneumatically Regulated) For Light Doors Weighing Up to 40 Kg” 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 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.	5.1	Dimensions	Vernier caliper, Micrometer
2.	7.1	Performance requirements	Angle protector,
3.	7.2	Endurance test	Endurance test set up with cycle counter
4.	8.1	Tests for anodizing on Aluminum Closers	Chemicals with reagents or Eddy current tester or other test equipment as per IS 1868 for coating thickness
5.	8.2	Tests for phosphating on MS	Mineral spirit or trichloroethylene, Conc. Hydrochloric acid, antimony trioxide, Weighing balance, Salt spray chamber as per IS 3618

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

ANNEX C

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 6343: 1982. Additionally, Type based on direction of opening of door shall also be marked on each closer.

4. CONTROL UNIT- All “Door Closers (Pneumatically Regulated) For Light Doors Weighing Up to 40 Kg” of same material of components and Type (based on direction of opening of door) 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.

5.2 Manufacturers should check for the latest applicable cross referred Indian Standards on raw material and test methods with BIS.

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				
3.1	Raw Material	3.1	IS 6343 IS 3601 IS 407 IS 738 IS 7283 IS 210 IS 617 IS 742 IS 2062 IS 1264 IS 2507 IS 4454-1 IS 292 IS 28 IS 2932	S	One	Each Consignment	No further testing is required if material is received with test certificate or is ISI Marked. <i>Materials as per IS 7283, 2062 and IS 4454-1 are under mandatory BIS Certification and manufacturers shall ensure that only ISI Marked material are used and received with test certificate.</i>
5.1	Dimensions	5.1	IS 6343	R	One	Each Control Unit	--
6	General requirements	6.1	IS 6343	R	Firm should exercise adequate control so that whole production should meet the requirements. Appropriate records shall be maintained as evidence of conformity.		
7.1	Performance test	7.1	IS 6343	R	One	Each Control Unit	--
7.2	Endurance test	7.2	IS 6343	S	One	Once in 6 months for each type	--

8	Finish						
8.1	Exposed surface finish	8.1	IS 6343	R	Each closer		
8.1	Thickness of coating for Aluminum body	8.1	IS 6343 IS 1868	S	One	From each lot anodized together	No further testing is required if received with test certificate or is ISI Marked
8.2.2	Phosphate treatment of MS Parts	8.2.2	IS 6343 IS 3618	S	One	From each lot phosphated together	
8.2.4	Painting of MS Parts	8.2.4	IS 6343 IS 2932	S	One	From each lot painted together	

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.