



उत्पाद मैनुअल
आई एस 18507 : 2024 के अनुसार
ड्राईवॉल स्कू — विशिष्टि के लिए
दस्तावेज संख्या – पीएम/आई एस 18507/1/ जनवरी 2024
*विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना-
। के तहत प्रमाणन के संचालन में एकरूपता और पारदर्शिता के लिए इस उत्पाद मैनुअल का
उपयोग सभी क्षेत्रीय / शाखा कार्यालयों और लाइसेंसधारियों द्वारा संदर्भ सामग्री के रूप में किया
जाएगा। दस्तावेज का उपयोग बीआईएस प्रमाणन प्राप्त करने के इच्छुक संभावित आवेदकों द्वारा
भी किया जा सकता है।*

**PRODUCT MANUAL FOR
DRYWALL SCREWS — SPECIFICATION
ACCORDING TO IS 18507 : 2024**

Document No - PM/IS 18507/1/January 2025

*This Product Manual shall be used as reference material by all Regional/Branch
Offices & licensees to ensure uniformity 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.*

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ड्राईवॉल स्कू — विशिष्टि
आई एस 18507 : 2024 के अनुसार
PRODUCT MANUAL
DRYWALL SCREWS — SPECIFICATION
ACCORDING TO IS 18507 : 2024

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना- I के तहत प्रमाणन के संचालन में एकरूपता और पारदर्शिता 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 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 uniformity 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.

1.	मानक संख्या IS No.	:	IS 18507 : 2024
	शीर्षक Title	:	Drywall Screws — Specification
	संशोधनों की संख्या No. of amendments	:	NIL
2.	नमूना दिशानिर्देश Sampling Guidelines:		
a)	कच्चा माल Raw material	:	As per Sl. iii) of Table 3 of IS 18507
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Please refer ANNEX – A

c)	नमूने का परिमाण Sample Quantity	:	60 pieces
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer ANNEX – B
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	A generic SIT is placed at ANNEX – C .
5.	एक दिन में संभावित परीक्षण Possible tests in a day:	:	All possible test
6.	लाइसेंस का दायरा /Scope of the Licence	:	As per below table
Licence is granted to use Standard Mark as per IS 18507 : 2024 with the following scope:			
	Name of the Product	Drywall Screws	
	Type of Head	Cross Recessed Bugle Head/ Trumpet Head	
	Thread Type	Single Start/ Double Start	
	Outside Diameter (nominal)	___ mm	
	Material & Grade	Material: Steel/ Stainless Steel/ Brass Of Grade: ___	
	Pitch	___ mm	
	Screw Length	___ mm	
	Type of Coating	Without Coating/ Electroplating/ Phosphating/ Any other type of coating (as declared by manufacturer)	

ANNEX – A

समूहीकरण दिशानिर्देश **Grouping Guidelines**

- 1) Drywall Screw for thread diameter 3.5 mm to 5.5 mm are classified based on the following:
 - a) Type of Head
 - b) Thread Type
 - c) Outside Diameter (nominal)
 - d) Material & Grade
 - e) Pitch
 - f) Screw Length
 - g) Type of Coating
- 2) Considering the above, following grouping guidelines for grant of licence/ change in scope of licence shall be followed:
 - a) Drywall Screws of the largest and the smallest outside diameter shall be tested to cover all the Drywall Screws falling in the range;
 - b) Drywall Screws having the largest screw length shall be tested to cover the Drywall Screws upto and including the lengths tested;
 - c) Drywall Screws of each material (Steel/ Stainless Steel/ Brass) and each grade shall be tested separately;
 - d) Drywall Screws of each type of coating shall be tested separately. However, if Drywall Screws with coating is tested, then Drywall Screws without coating may be covered in scope of licence without further testing.
- 3) Manufacturer shall declare the varieties of the Drywall Screws they intend to cover in the scope of the licence. The scope of the 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 varieties of Drywall Screws covered in the scope of licence are tested in rotation, to the extent possible.

ANNEX – B

परीक्षण उपकरणों की सूची **List Of Test Equipment**

(INDICATIVE LIST, FOR GUIDANCE ONLY)

Major test equipment required to test as per the Indian Standard

Sl. No.	Tests Used in With Clause Reference	Test Equipment/Chemical
1.	Cl. 4 (Dimension)	Micrometer, Vernier caliper, profile projector, Go- No Go Gauges, angle gauge, thread gauge, pitch gauge
2.	Cl. 5 (Requirement – Surface Coating)	Coat meter, Salt spray chamber with temperature controller, Sulphur Dioxide
3.	Cl. 6 (Torque testing)	Torque wrench
4.	Cl. 7 (Hardness)	Vicker Hardness Tester

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

ANNEX – C

निरीक्षण और परीक्षण की स्कीम

Scheme Of Inspection And Testing

1. QUALITY ASSURANCE PLAN

1.1 It is expected that manufacturers (licensees/applicants) will implement a Quality Assurance Plan i.e. a plan of regular testing and in-process controls, designed to ensure that the product bearing the Standard Mark conforms to all requirements of the Indian Standard.

1.2 The manufacturers shall define a Quality Assurance Plan defining the control unit (i.e. lot/batch etc.) and the levels of control (i.e. the frequency and number of samples for conducting the different tests as per the Indian Standard) and submit the same to BIS Branch Office for information. The manufacturer shall comply with the same and maintain test records in accordance with para 2.4.

1.3 RECOMMENDED LEVELS OF CONTROL/CONTROL UNIT:

1.3.1 For the guidance of manufacturers, the recommended definition of control unit is: **All Drywall Screws of same Type, same Thread Type, same Outside Diameter (nominal), same Pitch, same Screw Length, having same Type of Coating and made from same material manufactured in a day, shall constitute a control unit.** The manufacturer has the choice to define their own control unit/batch/lot and submit the same to the BIS.

1.3.2 For the guidance of manufacturers in preparing the Quality Assurance Plan, recommended levels of control are given in **Table 1**.

1.3.3 The manufacturer shall ensure inspection and testing as per the Quality Assurance Plan submitted by them on the whole production of the factory which is covered by this plan. Alternatively, the manufacturer has the option of adherence to the quality plan as per levels of control recommended in column 3 of Table 1.

1.4 However, all manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard.

2. ENSURING COMPLIANCE THROUGH TESTING- It is expected that manufacturers (licensees/applicants) will establish a suitably equipped and staffed in house laboratory (In house testing facility) for testing at least those parameters of the Indian Standard which require routine testing for ensuring quality of the product. This includes in-process controls as may be defined and put in place by the manufacturer and testing parameters/requirements which can only be performed in the factory.

2.1 For the guidance of manufacturers, Table 1 giving the recommended levels of control is given below. Column 2 of Table 1 indicates routine tests where test equipment is required in house as “R” or other tests which can be subcontracted as “S”. Subcontracting is permitted to BIS recognized/empanelled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025.

2.2 For MSME manufacturers, the requirement of maintaining a laboratory/in-house testing facility for routine tests (indicated as “R” in Column 2 of Table 1) is also optional.

2.2.1 MSME manufacturers may utilize common cluster-based facilities as per guidelines for the utilization of cluster-based test facilities by MSMEs or the provisions of Sharing of testing facilities or get testing done from BIS recognized/empaneled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025.

2.3 Large Scale manufacturers shall maintain an in-house laboratory equipped at least with test facilities for routine tests (indicated as “R” in Column 2 of Table 1), where different tests given in the specification shall be carried out in accordance with the method given in the specification. They shall also implement a calibration plan for the in-house test equipment.

2.3.1 Alternatively, in lieu of an in-house laboratory, large scale manufacturers can also utilize the provisions of Sharing of testing facilities as per the Guidelines for Grant of Licence available on BIS website www.bis.gov.in. (Under Conformity Assessment>Product Certification Process). Even for subcontracted tests, provisions for sharing of testing facilities can be utilized.

2.4 TEST RECORDS- The manufacturers maintaining an in-house laboratory or utilizing common cluster-based facilities or shared test facilities shall maintain test records for the tests carried out to establish conformity. For the tests being subcontracted to BIS recognized/empanelled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025, test reports issued by the laboratories shall be available for inspection by BIS.

3. MARKING and PACKAGING- The Standard Mark as given in the Schedule of the licence shall be incorporated legibly and indelibly on **each package of Drywall Screws** provided always that the **Drywall Screw** so marked conforms to each requirement of the specification. In addition, marking on package shall be done as per the Cl. 9.1 of **IS 18507 : 2024**.

4. Additional Marking requirements:

a) The material shall also be marked with the following additional requirement on packaging:
“For BIS certification details please visit www.bis.gov.in”.

5. REJECTION - All the production which conforms to the Indian Standard and covered under the scope of this licence shall be marked with the Standard Mark. 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
(ONLY FOR GUIDANCE PURPOSE)

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
4, Table 3, Sl. iv)	Dimensions & Tolerances	4	IS 18507	R	Firm to have adequate in-process controls to check compliance of this parameter as per the tolerances given in the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity.		
Table 3, Sl. ii)	Cross recess		IS 7478	R			
Table 3, Sl. iii)	Material		IS 7887 for Steel/ IS 1367 (Part 14/ Sec 4) for Stainless steel/ as per agreement for Brass	S	One	Each Consignment	No further testing is required, if accompanied with test certificate or ISI marked.
Table 3, Sl. iv)	Surface Coating		IS 1367 (Part 11)/ IS 1367 (Part 12	R	One	Each Control Unit	
Table 3, Sl. vi)	Surface condition		IS 1367 (Part 9/ Sec 1)	R	Firm to have adequate in-process controls to check compliance of this parameter as per the tolerances given in the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity.		
6	Torque Testing	6	IS 18507	R	One	Each Control Unit	
7	Hardness	7.1, 7.2	IS 18507	R	One	Each Control Unit	