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उत्पाद मैनुअल

Moulded rubber unit outsoles — Specification
IS 5676: 1995 के अनुसार

PRODUCT MANUAL FOR
Moulded rubber unit outsoles — Specification
ACCORDING TO IS 5676: 1995

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.	:	5676:1995
	शीर्षक Title	:	Moulded rubber unit outsoles — Specification
	संशोधनों की संख्या No. of amendments	:	01
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	No specific requirement Note: This section indicates the requirements for raw material (if specified in the IS) for which compliance is to be established during Grant of Licence/Change in Scope of Licence/Factory Surveillance
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Not applicable
c)	नमूने का परिमाण Sample Quantity	:	2 Nos. Note: This section indicates the quantity of the sample of the product and/or the raw material (if applicable), required to be sent to the laboratory for testing, for the purpose of Grant of Licence/Change in Scope of Licence/ Factory Surveillance (in case of market surveillance, effort may be made to procure the required quantity of product sample, as far as possible since raw material sample may not be available in market)

3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer to Annex-A
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer to Annex-B Note : Please see Cl. 5 of the SIT for Applicability of SIT for Small and Micro Scale Enterprises
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	Size, Design, Thickness, Tensile strength, Elongation at break. Note: This section is for the guidance of BIS Certification Officers/Technical Auditors of BIS Authorized Outside Surveillance Agencies (OSAs) during factory inspection to provide ready reference regarding the tests which can be witnessed during the inspection in the factory by the officer/auditor.		
6.	लाइसेंस का दायरा /Scope of the Licence:		
	IS 5676:1995 के अनुसार मानक मुहर का उपयोग करने के लिए लाइसेंस निम्नलिखित कार्यक्षेत्र के लिए प्रदान किया जाता है “Licence is granted to use Standard Mark as per IS 5676:1995 with the following scope:		
	Name of the product		Moulded rubber unit outsoles

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

ANNEX – A

LIST OF TEST EQUIPMENTS

(INDICATIVE LIST, FOR GUIDANCE ONLY)

Sl. No.	Tests Used In With Clause Reference	Test Equipment/Chemical
1	Thickness, Cl. 5.5	Thickness dial gauge calibrated in 0.1 mm or equivalent apparatus
2	Relative Density, Cl. 5.7	Balance (LC-1 mg), Balance straddle, Beaker (250 ml), Copper wire, oven,
3	Hardness, degree, Shore A, Cl. 5.7	Thickness dial gauge calibrated in 0.1 mm / Graduated eyepiece with 0.1 mm scale spacing of travelling microscope
4	Flexing resistance, Cl. 5.7	<u>Bennewart method (Annex D of IS 15844 (Part 1))</u> Flexing machine, (D 3, Figure 1) of Annex D of IS 15488 (Part 1): 2023, vernier callipers, chisel thermometer with LC of 1 °C, thickness guage OR <u>Ross Flex method (IS 3400 (Part 16)</u> Ross flexing machine as per IS 3400 (Part 16), piercing tool and holder, rule, thickness guage, soap, conditioning chamber, cold chamber, arrangement to maintaining temp of 27 +/-2
5	Abrasion resistance at applied force of 10 N, Cl. 5.7	abrasion machine as per 5.1 of IS 3400 (Part 3), abrasive sheet, Hollow drill, balance, standard reference compounds. Conditioning chamber, arrangement for keeping ambient temperature, standard reference compounds
6	Tensile Strength and Elongation at Break, Cl. 5.7	Tensile testing Machine as per 7.4 of IS 3400 Part 1, die cutters as per 7.1 of IS 3400 Part 1, Steel Scale, vernier caliper, micrometer/dial thickness guage (as per 7.1 of IS 3400 Part 1), cone guage, Test rig for ring test pieces r, conditioning chamber, arrangement to maintain temp of 27 +/-2 and 65+/-2 %RH
7	Tear Strength, Cl. 5.7	Tensile testing machine as per Cl 5.3 of IS 3400 Part 12, Die for test specimens, Nick cutter, arrangement to maintaining temp of 27 +/-2

ANNEX B

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 : 50,000 pairs or Fortnight production (whichever is earlier), or any other quantity as defined by the manufacturer, of the same size, design and manufactured from the same type of rubber

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. PACKING AND MARKING - The Standard Mark as given in the Schedule of the licence shall be incorporated legibly and indelibly on each moulded rubber unit outsole provided always that the outsoles to which this mark is thus marked conforms to every requirement of the specification.

3.1 Packing and Marking shall be done as per the Indian Standard.

4. 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.

5. Applicability of SIT for Small and Micro Enterprises (SMEs):

5.1 Compliance to the Scheme of Inspection and Testing is OPTIONAL for Micro, and Small Scale Units with respect to the requirements for Clause 1 (Quality Assurance Plan), Clause 2 (Ensuring Compliance through Testing). However, ALL units shall ensure compliance of their products to the requirements of the Indian Standard.

5.2 The requirements of SIT with respect to Clause 3 (Packing and Marking) and Clause 4 (Rejection) shall be followed by all.

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				
5.1	General	5.1	IS 5676	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		
5.2	Design	5.2	IS 5676	R	Firm to have adequate in-process controls to check compliance of this parameter. However, appropriate records shall be maintained by the manufacturer for evidence of conformity		
5.4	Size			R			
5.5	Thickness		IS 15298 (Part 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		
5.7	Physical Requirements for Moulded Rubber Unit Outsole						
i.	Relative density	Annex C- 1	IS 10702	R	One	Each control unit	
ii.	Hardness, degree, Shore A		IS 12240 (Part 2)	R	One	Each control unit	
iii.	Flexing resistance (Bennewart method or Ross Flex method)		Annex D of IS 15844 (Part 1) Or IS 3400 (Part 16)	S	One	Once in a month	
iv.	Abrasion resistance at applied force of 10 N(Volume loss)		IS 3400 (Part 3)	S	One	Once in a month	
v.	Tensile strength		IS 3400 (Part 1)	R	One	Each control unit	
vi.	Elongation at break		IS 3400 (Part 1)	R	One	Each control unit	
vii.	Tear strength (average force)	Method A	IS 3400 (Part 12)	R	One	Each control unit	