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उत्पाद मैनुअल

पेडल संचालित धान थ्रेशर— विशिष्ट

IS 3327: 2025 के अनुसार

**PRODUCT MANUAL FOR
PEDAL – OPERATED PADDY THRESHERS — SPECIFICATION
ACCORDING TO IS 3327:2025**

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 3327: 2025
	शीर्षक Title	:	PEDAL – OPERATED PADDY THRESHERS
	संशोधनों की संख्या No. of amendments	:	NIL
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	Materials used for various parts of the paddy thresher shall be as given in Table 1 of IS 3327: 2025. 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	:	Thresher of each size and max. rotational speed to be tested to be covered in the scope of licence
c)	नमूने का परिमाण Sample Quantity	:	1 thresher 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)

d)	परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर Parameters to be Declared in Test Request		a) Size of thresher b) rotational speed Note: This section indicates declared values to be specified against a parameter (in Test Requests) to enable testing of sample against the requirement and determine its conformity. Any other requirements/parameters may also be declared as per the standard, as applicable.
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer to Annex-B
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer to Annex-C
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	Licence is operated on factory testing basis and all tests on thresher is possible in a day 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 3327: 2025 के अनुसार मानक मुहर का उपयोग करने के लिए लाइसेंस नम्रलिखित कार्यक्षेत्र के लिए प्रदान किया जाता है "Licence is granted to use Standard Mark as per IS 3327: 2025 with the following scope:		
	उत्पाद का नाम Name of the product		PEDAL – OPERATED PADDY THRESHERS
	Size		1. up to 600 mm (in case of one person operated thresher) 2. up to 800 mm (in case of two person operated thresher) (Actual Size is to be declared by the manufacturer)
	Rotational speed		To be declared by the manufacturer

ANNEX– A

LIST OF TEST EQUIPMENTS

(INDICATIVE LIST, FOR GUIDANCE ONLY)

Sl no	Test with CI reference	Test Equipment
1	Constructional Requirements (CI 6), Dimensions (CI 7), Requirements (CI 8),	Vernier caliper, scale, Micro meter, Measuring Tape
2	Test (Performance , CI 9)	Pulling machine, Level surface , tachometer

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:

For the guidance of manufacturers, the recommended definition of control unit is: All threshers of the same size and rotational speed assembled in a day

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

1.3.2 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".

2.2 Manufacturers shall also implement a calibration plan for the in-house test equipment.

2.2.1 In lieu of an in-house laboratory, 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).

2.3 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.

3. PACKING AND MARKING - The Standard Mark as given in the Schedule of the licence shall be incorporated legibly and indelibly on each thresher. provided always that the material so marked conforms to each requirement of the specification.

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

3.2 **Additional Marking requirements:** The thresher shall also be marked with the following.

a) "For BIS certification details please visit www.bis.gov.in"

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.

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.	Material	-	IS 3327	S	One	Each consignment	No testing required if accompanied if ISI marked of accompanied with Test certificate from the manufacturer/supplier
6.	Constructional Requirements						
6.1	Body Frame	-	IS 3327	R	Firm to have adequate in- process controls to check compliance of this parameter within the tolerance given in the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity		
6.1.1	Base	-					
6.1.2	Side Frames	-					
6.1.3	Front Grain Shield	-					
6.1.4	Rear Grain Shield	-					
6.2	Cylinder	-					
6.2.1	Slat	-					
6.2.2	Cylinder End Discs	-					
6.2.3	Threshing Teeth	-					
6.3	Drive	-					
6.3.1	Gear Housing	-					
6.3.2	Crank	-					
6.3.3	Pedal Frame Fulcrum	-					
6.3.4	Pedal Frame	-					
6.3.5	Pedal Board	-					
6.4	Axles	-					
6.5	Lifting Handle	-					

7.	Dimensions	-	IS 3327	R			
8.	Requirements						
8.1	Clearances	-	IS 3327	R			
8.2	Lubrication	-					
8.3	Safety Arrangement	-					
9	Test						
9.1	The Setting Strength of Threshing teeth	-	IS 3327	R	One	Each Control Unit	
9.2 (a)	Oscillation of the thresher	-	IS 3327	R	One	Each Control Unit	
9.2 (b)	Undue Vibration unbalancing of the cylinder; and	-	IS 3327	R	One	Each Control Unit	
9.2 (c)	Feet and knee of the operator shall not touch the rear grain shield.	-	IS 3327	R	One	Each Control Unit	
10.	Workmanship and Finish	-	IS 3327	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		