



**उत्पाद मैनुअल
आई एस 208:2020 के अनुसार
दरवाजों के हत्ये**

**PRODUCT MANUAL FOR
DOOR HANDLES
ACCORDING TO IS 208:2020**

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 208: 2020
	शीर्षक Title	:	Door Handles
	संशोधनों की संख्या No. of amendments	:	2
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	Please refer to Annex-A 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	:	Please refer to Annex-B
c)	नमूने का परिमाण Sample Quantity	:	6 nos of door handles 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	-	Same as the scope of licence
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer to Annex-C
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer to Annex-D
5.	एक दिन में संभावित परीक्षण Possible tests in a day All tests except Corrosion test (Cl 8.2) 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 readyreference 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: Licence is granted to use Standard Mark as per IS 208: 2020 with the following scope:		
	Name of the product	Door Handles	
	Type	Type 1/ Type 2/ Type 3/ Type 4	
	Size		
	Material		

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ANNEX- A

Details of Raw Materials

Raw Material	Indian Standard
Mild steel	Mild steel shall conform to Grade HR 1 of IS 1079
Mild steel bar	Mild steel bar shall conform to Grade E 165 of IS 15911
Malleable cast iron	Malleable cast iron shall conform to Grade BM 350 of IS 14329
Cast brass	Cast brass shall conform to LCB 2 of IS 292
Aluminium alloy pressure die casting	Aluminium alloy pressure die casting shall conform to Designation 5230 or 4600 of IS 617
Aluminium alloy sheet/ strip	Aluminium alloy sheet/ strip shall conform to Designation 19000 Hx4 of IS 737
Extruded Aluminium alloy rod and flat	Extruded Aluminium alloy rod and flat shall conform to Grade 63400 WP or 63400W or 65032 WP of IS 733
Cast iron	Cast iron shall conform to FG 200 of IS 210
Zinc base alloy die casting	Zinc base alloy die casting shall conform to IS 742
Stainless steel sheet (Grade 202, 304 or 316)	Stainless steel sheet Shall conform to Grade 202, 304 or 316 of IS 6911
Stainless steel wire (Grade X07Cr18Ni9 or X04Cr18Ni10 or X02Cr17Ni12Mo2)	Stainless steel wire Shall conform to Grade X07Cr18Ni9 or X04Cr18Ni10 or X02Cr17Ni12Mo2 of IS 6603

ANNEX-B

Grouping Guidelines

1. Door handles as per IS 208:2020 are classified based on the following:

Type	Material	Size
Type 1 - Cast	Cast Iron, Malleable Cast Iron, Cast Brass, Cast Aluminium Alloy or Zinc Alloy Die Casting.	75 mm, 100 mm, 125 mm and 150 mm
Type 2 - Pressed oval	Mild Steel or Stainless Steel	75 mm, 100 mm, 115 mm and 135 mm
Type 3 - Pressed half oval	Mild Steel or Stainless Steel	75 mm, 90 mm, and 100 mm
Type 4 - Fabricated	Mild Steel, Stainless Steel, Brass or Aluminium Alloy	75 mm, 100 mm, 125 mm and 150 mm

2. Considering the above, one sample each of the smallest and highest size from each type of door handle shall be tested to cover all sizes in that size-range for that particular type of door handle.
3. Separate samples of door handles of each material from each Type shall be tested to cover that material for that particular Type in the scope of licence.
4. The Firm shall declare the varieties of various Door Handles they intend to cover in the Licence. The Scope of Licence may be restricted based on the manufacturing and testing capabilities of the manufacturer.
5. During operation of the licence, BO shall ensure that all the varieties covered in the licence are tested in rotation to the extent possible.

ANNEX-C

List of Test Equipment

(INDICATIVE LIST, FOR GUIDANCE ONLY)

Sl. No.	Tests used in with Clause Reference	Test Equipment
1.	Dimensions and Tolerances (Cl 6.1, 6.2, Tables 2A, 2B and 2C- Fig. 1 to 5)	- Vernier Calliper - Micrometre
2.	Finish (Cl 7)	- Test equipment, chemicals as per IS 1068, as applicable Or - Test equipment, chemicals as per IS 1378, as applicable Or - Anodizing coating thickness gauge, as applicable Or - Test equipment, chemicals as per IS 1868, as applicable
3	Performance Requirements of Finish (Cl 8)	
	Corrosion Test (Cl 8.2)	- Test facilities as per IS 9844
	Anodizing Test (Cl 8.3)	- Test facilities as per IS 1868

ANNEX D

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: All door handles of the same type, size and material manufactured under similar conditions in a day shall be considered as a control unit.

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.

2.3 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.

2.4 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.

2.4.1 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.

2.5 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.

2.5.1 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.

2.6 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 legibly and indelibly marked on each door handle, provided always that the product so marked conforms to all requirements of the Standard.

3.1 Packing and Marking shall be done as per Clause 11 and Clause 10 of IS 208:2020 respectively.

3.2 Additional Marking requirements: Each door handle or its packaging shall also be marked with the following detail:

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 Method			No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Material	Cl. 4	IS 208	S	One	Each consignment	No further testing is required if accompanied with test certificate or ISI marked.
5	Manufacture	Cl. 5.1	IS 208	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	Dimensions & tolerances	Cl.6, Table 2A, Table 2B	IS 208				
7	Finish (Visual)	Cl.7.1	IS 208				
	Finish (Other requirements)	Cl.7.1	IS 208	R	One	From each batch of material finished together	
8	PERFORMANCE REQUIREMENTS OF FINISH						
	Corrosion test	Cl 8.1	IS 208	S	One	Once in a month	Each type of door handles produced during the month shall be tested for this requirement
	Anodizing Test	Cl 8.2	IS 208	S	One	Once in a month	Each type of door handles produced during the month shall be tested for this requirement