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उत्पाद मैनुअल
सामान्य इंजीनियरिंग प्रयोजनों के लिए गढ़ा एल्युमिनियम और एल्युमिनियम मिश्र धातु
रिवेट स्टॉक के लिए विशिष्टता
IS 740: 1977 के अनुसार

Product Manual for
Specification for Wrought Aluminum and Aluminum Alloy Rivet Stock for General
Engineering Purposes
According to IS 740: 1977

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.	भारतीय मानक संख्या IS No.	:	IS 740:1977
	शीर्षक Title	:	Wrought Aluminum and Aluminum Alloy Rivet Stock for General Engineering Purposes
	संशोधनों की संख्या No. of amendments	:	0
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	No specific raw material 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	:	Please refer Annex-A

c)	नमूने का परिमाण Sample Quantity	:	For chemical test: 5 pcs of 5 cm length For mechanical test: 1 m length of round bar or wire 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	:	Designation, Condition (Temper), Size Note: Apart from the above, 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 All tests. 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 740: 1977 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 740: 1977 with the following scope:		
7.	उत्पाद का नाम Name of the product		Wrought Aluminum and Aluminum Alloy Rivet Stock for General Engineering Purposes
	Designation		19000, 24345, 53000.....
	Condition (Temper)		W, O, M ...
	Size		Round Bars /Wires of diameter fromxx....mm to up to and including ...xx... mm

ANNEX-A
TO PRODUCT MANUAL FOR
Wrought Aluminum and Aluminum Alloy Rivet Stock for General Engineering
Purposes
According to IS 740:1977

GROUPING GUIDELINES

1) Designations have been grouped based upon their aluminum purity/major alloying element content. For the purpose of GoL/CSoL, the following grouping guidelines may be considered:-

Designations	Purity of Al/Major Alloying Element Content (mean %)	Grouping
19000	Al 99.0%	One sample of the designation is required to be drawn and tested
46000	Si (11.5%)	One sample of the designation is required to be drawn and tested
53000	Mg (3.4%)	One sample of designation having the higher major alloying element content shall be drawn and tested to cover designations with lower major alloying element content within the group
55000	Mg (5%)	
64430	Magnesium Silicide (4%)	One sample of designation having the higher major alloying element content shall be drawn and tested to cover designations with lower major alloying element content within the group
65032	Magnesium Silicide (4.75%)	

2) The sample(s) drawn above shall be of the smallest diameter of bars/wires being manufactured. Further, sample of each Condition(Temper) (cl.6.1) is required to be drawn to cover the Conditions (Temper) intended to be covered in the licence.

3) However, it shall be ensured that the firm is having all the necessary manufacturing and testing facilities for manufacturing/testing of all the designations/conditions/sizes covered in the scope of the licence.

4) During the operation of the licence, BOs shall ensure that all designations/conditions/sizes covered in the scope of the licence are drawn for independent testing in rotation over a period of time.

ANNEX – B

LIST OF TEST EQUIPMENTS
(INDICATIVE LIST, FOR GUIDANCE ONLY)

Major test equipment required to test as per requirements of Indian Standard.

Sl. No.	Test Equipment/Chemicals and Identification Numbers (Where applicable)	Tests Used in with Clause Reference
1	Spectrometer, Analytical Balance(0-200gm, LC- 0.1mg) ,Hot Plate, Hot Air Oven, Photometer (Absorption cell), Porcelain/Silica Crucible, Platinum Crucible, Thermometer, Filter Paper including ashless filter paper pad, Stainless steel/nickel beaker, Plastic/polyethene/SS Beaker, Pyrex beakers and other glassware	Chemical Composition, cl.4.
2	Reagents-Mixed Acid (Conc.HCL, Conc. Sulphuric Acid, Conc. Nitric Acid), Dilute Sulphuric Acid, Hydrofluoric Acid, Hydrogen Sulphide(gas), Hydrogen Sulphide Wash Solution, Dilute Nitric Acid, Concentrated Ammonium Hydroxide, Dilute Ammonium Hydroxide Wash Solution, Citric Acid Solution, Sodium-Diethyl-Dithiocarbonate solution, Carbon Tetrachloride, Sodium Sulphate, Standard Copper Solution, silica basin	Copper (Below 0.1%)
3	Reagents – Concentrated Sulphuric Acid, Concentrated Nitric Acid, Concentrated Hydrochloric Acid, Mixed Acids(Conc.HCL, Conc. Sulphuric Acid, Conc. Nitric Acid), Hydrofluoric Acid, Dilute Sulphuric Acid, Ammonium Fluoride, Concentrated Ammonium Hydroxide, Acetic Acid, Urea Solution, Potassium Iodide Solution, Standard Sodium Thiosulphate Solution, Starch solution, ammonium thiocyanate, Sodium Hydroxide Solution, Sodium Sulphate Solution, Sodium Hydroxide-Sodium Sulphate Wash Solution, Dilute Nitric Acid, Sulphurous Acid, Hydrogen Copper (Above 0.1%) PM/ IS 733/1 Oct 2018 Sulphide(gas), Hydrogen Sulphide Wash Solution	Copper (Above 0.1%)
4	Reagents – Sodium Hydroxide, Hydrogen Peroxide, Sodium Carbonate, Methyl Red Indicator Solution, Conc. Ammonium Hydroxide, Ammonium Chloride Wash Solution, Ammonium Chloride, Conc. Hydrochloric Acid, Ammonium Sulphide Solution, Ammonium Persulphate, Ammonium Sulphide Wash Solution, Bromine Water, 8-Hydroxyquinoline Solution, Dilute Ammonium Hydroxide, Methyl Orange Indicator Solution, Potassium Bromate- Potassium Bromide Solution, Potassium Iodide Solution, Starch Solution, Standard Potassium Iodate Solution, Standard Sodium Thiosulphate Solution	Magnesium (0.01 to 12 %)
5	Reagents – Sodium Hydroxide Solution, Hydrogen Peroxide, Potassium Cyanide Solution, Dilute Hydrochloric Acid, Ammonium Chloride, Bromine Water, Conc. Ammonium Hydroxide, Sodium Acetate, Tartaric Acid, Chrome Blank T	Magnesium (0.5 to 11%)

	Indicator, Standard Magnesium Sulphate, Standard EDTA Solution.	
6	Reagents- Sodium Hydroxide Solution, Dilute Nitric Acid, Ammonium Molybdate Solution, Standard Silicon Solution.	Silicon (0.02 to 0.3%)
7	Reagents – Sodium Hydroxide Solution, Hydrogen Peroxide, Conc. Sulphuric Acid, Sulphuric Acid-Perchloric Acid Mixture, Perchloric Acid Solution, Conc. Nitric Acid, Sulphurous Acid, Dilute Sulphuric Acid, Conc. Hydrochloric Acid, Ammonium Acetate Solution, Dilute Hydrochloric Acid, Hydrofluoric Acid	Silicon (Above 0.3%)
8	Reagents-Sodium Hydroxide Solution, Finely granulated lead containing under 0.001% iron, Acetate Buffer Solution, Hydroxylamine Hydrochloride Solution, Ophenanthrolinesolution, Standard Iron Solution. Equipment – Magnet, Nickel Beaker.	Iron (0.03 to 0.10%)
9	Reagents -Concentrated Sulphuric Acid, Concentrated Nitric Acid, Concentrated Hydrochloric Acid, Mixed Acids(Conc.HCL, Conc. Sulphuric Acid, Conc. Nitric Acid), Dilute Sulphuric Acid, Hydrofluoric Acid, Potassium Bisulphate, Hydrogen Sulphide, Hydrogen Sulphide Wash Solution, Potassium Permanganate Solution, Potassium Thiocyanate Solution, Standard Titanous Chloride Solution. Equipment – Apparatus for Storing Titanous Chloride Solution, Solid Glass Beads.	Iron (0.01 to 2.0%)
10	Reagents – Sodium Hydroxide Solution, Sodium Nitrite Solution, Acid Mixture(Conc. Nitric Acid and Phosphoric Acid), Hydrofluoric Acid, Potassium Periodate Solution, Standard Manganese Solution	Manganese (Mn content between 0.01 to 0.1%)
11	Reagents - Sodium Hydroxide Solution, Acid Mixture(Conc. Sulphuric Acid, Phosphoric Acid and Nitric Acid), Silver Nitrate Solution, Ammonium Persulphate Solution, Ammonium Chloride Solution, Standard Arsenite-Nitrite Mixture, Sodium Arsenite, Standard Manganese Solution.	Manganese (Chromium Content up to 0.5%)
12	Reagents – Conc. Nitric Acid, Sodium Bismuthate, Sulphurous Acid, Dilute Nitric Acid, Phosphoric Acid, Standard Ferrous Ammonium Sulphate Solution, Standard Sodium Oxalate Solution, Standard Potassium Permanganate Solution. Equipment-Asbestos Gooch Crucible	Manganese (Mn content between 0.1 to 1.5%)
13	Reagents – Dilute Hydrochloric Acid, Potassium Chlorate, Carbon Tetrachloride, Complex Forming Solution (Conc. Ammonium Hydroxide, Ammonium Oxalate, HCl acid, sodium acetate, sodium thiosulphate solution and sodium sulphide solution), Dithizone Solution, Sodium Sulphide Wash Solution, Standard Zinc Solution.	Zinc (Photometric Method for Zn content below 0.1%)
14	Reagents – Mixed Acid(Conc. Sulphuric Acid, Conc. HCl and Conc. Nitric Acid), Dilute Sulphuric Acid, Hydrogen Sulphide(gas), Hydrogen Sulphide Wash Solution, Tartaric Acid Solution, Conc. Ammonium Hydroxide, Methyl Red Indicator Solution, Formic Acid Mixture, Formic Acid Wash Solution, Dilute Hydrochloric Acid, Ammonium Nitrate, Methylated Spirit, Mercuric Potassium Thiocyanate Solution,	Zinc (By Mercuric Thiocyanate Method)

	Chloroform, Standard Zinc Solution, Standard Potassium Iodate Solution.	
15	Reagents – Sodium Hydroxide Solution, Nitric Acid-Sulphuric Acid Mixture, Dilute Sulphuric Acid, Hydrogen Peroxide, Standard Titanium Solution.	Titanium
16	Reagents – Conc. Sulphuric Acid, Conc. Nitric Acid, Silver Nitrate, Hydrofluoric Acid, Ammonium persulphate, Dilute HCl, Standard Ferrous Ammonium Sulphate Solution, Standard Potassium Permanganate Solution.	Chromium
17	Universal Tensile Testing Machine	Tensile Strength, cl.4.1, cl.9.1
18	Punch die arrangement with press for heading load, Flattening Machine	Head Forming Test, cl.9.2
19	Micrometer, Vernier Caliper	Dimensions and Tolerances, cl.7.1

Note: The above is an indicative list for the purpose of guidance only

ANNEX- C SCHEME OF INSPECTION AND TESTING

1. QUALITY ASSURANCE PLAN

1.1 It is expected that during operation of BIS licence, manufacturers will implement a Quality Assurance Plan (QAP) 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 (QAP) defining the control unit (i.e. lot/batch etc.), the levels of control (i.e. the frequency and number of samples for conducting the different tests as per the Indian Standard) and declare the arrangement for testing i.e. whether in-house or subcontracting/sharing for each applicable test and submit the same to BIS Branch Office for information. The manufacturer shall comply with the QAP and maintain test records in accordance with para 2.1.

1.3 RECOMMENDED LEVELS OF CONTROL/CONTROL UNIT:

1.3.1 For the guidance of manufacturers, the recommended definition of control unit is: For the purpose of this scheme, all rivet stocks of the same grade, diameter and manufactured under similar conditions of production i.e. of the same cast/heat shall constitute 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. Manufacturer has the discretion of declaring their own levels of control or accept the levels of control given in this document.

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.

2. ENSURING COMPLIANCE THROUGH TESTING- manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard for which they may have in-house test facilities. However, there is no obligation to maintain in-house laboratory. Licensee may use alternative arrangements for tests of the production as per the declared QAP. Various alternatives are available for operation of BIS certification as given below and the relevant guidelines for availing such relaxations by the manufacturers, as amended from time to time, are to be referred:

- i) Shared testing resources like common facility,
- ii) Cluster based testing facility,
- iii) Sub-contracting to outside laboratories which may either be:
 - a) BIS recognised/empanelled laboratories, or
 - b) Any accredited laboratory as per ISO/IEC 17025

2.1 TEST RECORDS- The manufacturers shall maintain test records for the tests carried out (either in-house or at a sub-contracted or at shared test facility) to establish conformity of the product to the Standard for operation of licence. For the tests being subcontracted or conducted at a shared test facility, test results issued by the laboratories or test facilities, shall be made available for inspection by BIS.

3. PACKING AND MARKING - The Standard Mark as given in the Schedule of the license and Licence Number (i.e. CM/L...) shall be suitably incorporated on the product and on the test certificate accompanied along with each consignment, provided always that the product thus marked conform to all the requirements of the specification.

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

3.2 Additional Marking requirements: Additionally, the following shall also be marked on each package:

- a) “For BIS certification details please visit www.bis.gov.in”
- b) Any other requirement not specified in the Indian Standard

4. TEST CERTIFICATE – For each consignment of BIS Certified material conforming to IS 740:1977 there shall be a test certificate which shall contain the Standard Mark, the cast/Control Unit number and the corresponding test results (as given in Annexure-I enclosed).

5. REJECTION - 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
(Recommended Levels of Control by BIS- For Guidance Only)

(1)				(3)		(4)
TEST DETAILS				LEVELS OF CONTROL		REMARKS
Clause	Requirements	Test Method		No. of Samples	Frequency	
		Clause	Reference			
4.1	Chemical Composition	4.1, Table 1	IS 740 IS 504 (all parts)	One	Each Cast	In case of raw material procured from outside, the manufacturer shall ensure that the material is received with test certificate indicating the designation and its chemical composition. No further testing is required if the raw material wire rods procured are ISI marked
4.1	Tensile Test	9.1, Table 2	IS 740 IS 1608 (Part 1)	One	Each Control Unit	—
6.1	Freedom from Defects	—	IS 740	Manufacturer shall maintain adequate inspection/in process controls to ensure freedom from defects		
7.1	Dimensions and Tolerances	—	IS 3577	Adequate inspection to ensure that the wires conform to the requirements of the specification		
9.2	Head-Forming Test	—	IS 740	One	Each Control Unit	Applicable only to Rivet Stock of 1.6 mm Diameter and above

Annexure-I
(Para 4 of the Scheme of Inspection and Testing)
XYZ ALUMINIUM COMPANY
(Registered office Address and works address)

ISI Mark
With IS No.
and CM/L
no.

**Test Certificate for Wrought Aluminum and Aluminum Alloy Rivet Stock for General Engineering Purposes
According to IS 740:1977**

TEST CERTIFICATE NO. _____

To M/s _____

Dated _____

We certified that the material described below fully conforms to IS 740:1977. Chemical composition and Mechanical properties of the product as tested in accordance with the Scheme of Inspection and Testing contained in the BIS Certification Marks Licence No. CM/L _____ are as indicated below against each order No.

(PLEASE REFER TO IS 740:1977 FOR DETAILS OF SPECIFICATION REQUIREMENTS)

TEST RESULTS

Order No. & Date	Size/ Shape	Control Unit No.	Designation	Qty. (in tonnes)	Chemical Composition (%)								Tensile Strength	Dimensions and Tolerances	Head Forming Test	Remarks
					Al	Si	Mn	Fe	Mg	Zn	Cu	Ti				

Remarks
Wagon No.
Truck No.

FOR XYZ ALUMINIUM COMPANY

(It is suggested that size A4 paper be used for this test Certificate)