



**उत्पाद मानुयल
आई एस 3950:1979 के अनुसार
स्लुइस वाल्व के लिए सरफेस बक्से के लिए**

दस्तावेज़ संख्या- पी एम/आई एस 3950/1/Dec 2023

भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम की स्कीम-1 के तहत यह उत्पाद मानुयल प्रमाणीकरण के प्रचलन में रीति और पारदर्शिता के सुसंगत सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों एवं लाइसेंस धारियों द्वारा संदर्भ सामग्री के रूप में उपयोग किया जाएगा। बीआईएस लाइसेंस/प्रमाण पत्र प्राप्त करने के इच्छुक भावी आवेदकों द्वारा भी इस दस्तावेज़ का उपयोग किया जा सकता है।

**PRODUCT MANUAL FOR
SURFACE BOXES FOR SLUICE VALVES
ACCORDING TO IS 3950:1979**

Document No.- PM/IS 3950/1/Dec 2023

This Product Manual shall be used as reference material by all Regional/Branch Offices & licensees to ensure coherence 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 licence/certificate

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1.	Product	:	IS 3950:1979
	Title	:	Surface Boxes for Sluice Valves
	No. of Amendments	:	01
2.	Sampling Guidelines:		
a)	Raw material	:	1) Frame – quality not less than FG 150 of IS 210. 2) Hinge Pin – IS 280.
b)	Grouping guidelines	:	Not Applicable
c)	Sample Size	:	02 surface boxes with cover for all tests. Prepared pieces for tensile and hardness test as per IS 210
3.	List of Test Equipment	:	Please see ANNEX – A
4.	Scheme of Inspection and Testing	:	Please see ANNEX – B
6.	Possible tests in a day	:	All tests
7.	Scope of the Licence :		
	“Licence is granted to use Standard Mark as per IS 3590:1979 with the following scope:		
	Name of the product		Surface Boxes for Sluice Valves

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ANNEX-A**LIST OF TEST EQUIPMENT**

Major test equipment required to test as per the Indian Standard

S.N.	Tests used in with clause Reference	Test Equipment
1	Material, Cl 2.1	• Universal Testing Machine(UTM), • Brinell Hardness testing machine
2	Dimensions and Tolerances, Cl 5	• Vernier Calliper • Steel Scale • Inside caliper • Outside calliper
3	Mass, Cl 6.1	• Weighing Balance
4	Protective Coating, Cl 8.1	• Hot air oven with temp controller (for 63°C) • Freezer with temp controller (for 15 °C)

The above list is indicative in nature and may not be taken as exhaustive

ANNEX-C

Scheme of Inspection and Testing

1. LABORATORY- A laboratory shall be maintained which shall be suitably equipped (as per the requirement given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.

1.1 The manufacturers shall prepare a calibration plan for the test equipment.

2.TEST RECORDS – The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. LABELLING AND MARKING – As per the requirement of Clause No. 9 of IS 3950:1979. The Standard Mark, as given in the Schedule of the licence, shall be marked on each surface box provided always that the surface box thus marked conforms to all the requirement of the specification. In addition, details of BIS website shall be marked on the surface box or its packaging, as follows: “For details of BIS certification please visit www.bis.gov.in”.

4. CONTROL UNIT – Surface boxes manufactured in a day shall constitute one control unit.

5. LEVELS OF CONTROL - The tests as indicated in column 1 of Table 1 and the levels of control in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with paragraph 2 above.

5.1 All the production which conforms to the Indian Standard and covered by the license should be marked with Standard Mark.

6. REJECTIONS - 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

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub-contracting permitted	Levels of Control		
C1.	Requirement	Test Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
2.1	Materials - Frame	15, 16.1	IS 210 IS 3590	R	One	Each Cast	(if firm manufactures the grey iron casting in-house)
				S	Each Consignment		No further testing is required, if received with test certificate or ISI marked. (if firm procures grey iron casting from outside)
2.2	Materials – Hinge Pin		IS 280 IS 3590	S	Each Consignment		No further testing is required, if received with test certificate or ISI marked
3	Manufacture and Workmanship	3.1	IS 3950	R	Firm to have adequate in-process controls to check compliance of this parameter as per the requirements given in the Indian Standard. Appropriate records shall be maintained by the manufacturer for evidence of conformity.		
4	Construction	4.1, 4.2	IS 3950				
5	Dimensions and Tolerances	5.1, fig.1, 5.2	IS 3950				
6	Mass	6.1	IS 3950	R	One	Each control unit	-
8	Protective Coating	8.1	IS 3950	R	One	Each control unit	-

Note-1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit submit his own levels of control in column 3 with proper justification for approval by BO Head.