



उत्पाद मैनुअल
खुले जबड़े वाले रिंच (पाने)
आईएस 2028:2026 के अनुसार

PRODUCT MANUAL
OPEN JAW WRENCHES (SPANNERS)
According to IS 2028:2026

यह उत्पाद नियमावली सभी क्षेत्रीय/शाखा कार्यालयों और लाइसेंसधारियों द्वारा विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना-1 के अंतर्गत प्रमाणन के संचालन में एकरूपता और पारदर्शिता सुनिश्चित करने के लिए संदर्भ सामग्री के रूप में उपयोग की जाएगी। बीआईएस प्रमाणन प्राप्त करने के इच्छुक भावी आवेदक भी इस दस्तावेज़ का उपयोग कर सकते हैं।

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 2028:2026
	शीर्षक / Title	:	Open Jaw Wrenches (Spanners)
	संशोधनों की संख्या No. of amendments	:	0
2.	नमूनाकरण दिशानिर्देश / Sampling Guidelines		
a)	कच्चा माल Raw material	:	As per Clause 4 of IS 2028:2026 <i>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.</i>
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Please refer ANNEX – A
c)	नमूने का परिमाण Sample Quantity	:	06 pieces
d)	परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर Parameters to be Declared in Test Request	:	Same as the parameters given in scope of the licence under S. No. 6. <i>Note: Apart from the above, any other requirements/ parameters may also be declared as per the standard, as applicable.</i>
3.	परीक्षण उपकरण की सूची List of Test Equipment	:	Please refer ANNEX – B
4.	निरीक्षण एवं परीक्षण योजना Scheme of Inspection and Testing	:	Please refer ANNEX – C
5.	एक दिन में संभावित परीक्षण Possible tests in a day	:	All tests <i>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.</i>

6.	लाइसेंस का दायरा / Scope of the Licence:	
“License is granted to use Standard Mark as per IS 2028:2026 with the following scope:		
Name of the product	Open Jaw Wrenches (Spanners)	
Type	Single-ended (SE) / Double-ended (DE) / Double-headed (DH)	
Intended use	General purpose (GP) / Automobile use(A) / Engineers’(E)	
Torque Series	C / D	
Nominal Width Across Flats		

BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9, BAHADUR SHAH ZAFAR MARG, NEW DELHI-110002
www.bis.gov.in

ANNEX -A
Grouping Guidelines

1. “Open Jaw Wrenches (Spanners)” covered in IS 2028:2026 are classified based on the following parameters:
 - a) Type: Single-ended (SE) / Double-ended (DE) / Double-headed (DH)
 - b) Intended use: General purpose (GP) / Automobile use(A) / Engineers’(E)
 - c) Torque Series: C / D
 - d) Nominal width across flats (mm)
2. The following varieties of Wrenches (Spanners) with different Size (Nominal Width across Flats) are covered in IS 2028:2026:
 - a) Single-ended Open Jaw Wrenches (Spanners) for General Purposes (Torque Series C or Series D)
 - b) Double-ended Open Jaw Wrenches (Spanners) for General Purposes (Torque Series C or Series D)
 - c) Double-ended Open Jaw Wrenches (Spanners) for Automobile use (Torque Series C or Series D)
 - d) Double-headed Open-ended Engineers’ Wrenches (Spanners) ISO Series (Torque Series C or Series D)
3. Considering the above, the grouping guidelines given below shall be followed for GoL/CSoL:
 - Sample of lowest and highest size (Nominal width across flats) from each variety stated in S. No. 2 above shall be tested for all requirements to cover all sizes (Nominal width across flats) in that size range for the particular variety tested.
 - If sample of Torque Series C is tested, samples of Torque Series D can also be covered.
4. The Firm shall declare the varieties of Wrenches (Spanners) intended to be covered in the Licence.
5. The Scope of Licence may be restricted based on the Manufacturing and testing capabilities of the manufacturer.
6. During the operation of Licence, it shall be ensured that all the varieties covered in the Licence are tested in rotation, to the extent possible.

ANNEX- B
List of Test Equipments
(Indicative List, For Guidance Only)

Major test equipment required to test as per the Indian Standard

Sl. No.	Cl. Ref.	Tests used in with Clause Reference	Test Equipment
1.	3 Table 1 to 5	Dimensions	Micro Meter Vernier Calliper Radius Gauge
2.	5	Hardness	Hardness Testing Machine Suitable Polisher
3.	6	Workmanship and Finish	Elcometer
4.	8	Torque Testing	Torque Tester

The above list is indicative only and may not be treated as exhaustive.

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 sub-contracting/ 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: *entire quantity of Open jaw wrenches (spanners) of same size and same variety having same torque class and made from same grade of material and heat treated under identical conditions in a day* 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.
- 1.4 However, all manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard.

2. ENSURING COMPLIANCE THROUGH TESTING

The 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 licence shall be incorporated legibly and indelibly on the packaging of the Open Jaw Wrenches (Spanners) provided always that the Open Jaw Wrenches (Spanners) so marked conforms to each requirement of the specification.

3.1 Packing and Marking of Open Jaw Wrenches (Spanners) shall be done as per Cl. 10 and Cl. 11 of IS 2028:2026.

3.2 **Additional Marking requirements:** The Open Jaw Wrenches (Spanners) shall also be marked with the following additional requirement on its packaging:

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

4. 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)				(2)		
Test Details				Levels of Control		
Cl.	Requirement	Test Methods		No. of Sample	Frequency	Remarks
		Clause	Reference			
4	Material	4	IS 2028	Each Consignment		No further testing is required if accompanied with the Test Certificate or ISI marked.
3	Dimensions	3.1 to 3.7 Table 1 to 5	IS 2028	One sample from each size	Hourly production	
5	Hardness	2	IS 6131	Ten of each size	Every Heat Treatment batch	Please see Note 1
6	a) Workmanship and Finish	3.1	IS 6131	Every piece		
	b) Plating Thickness	3.2	IS 6131	01	Each batch	All the Spanners plated together shall form one batch
8	Torque Testing	6	IS 6131	05	Each Control Unit	
10	Preservation and Packing	5, 5.1, 5.2	IS 6131	Every piece		

Note-1: In case of continuous heat treatment process five samples of each size shall be tested every hour. In case of failure, the whole lot may be taken up for re-heat treatment and number of samples of each size shall be doubled and tested. If any sample fails, the lot shall be rejected.