उत्पाद मैनुअल
चिपबोर्ड पेंच
आईएस 18508:2026 के अनुसर

PRODUCT MANUAL
CHIPBOARD SCREWS
According to IS 18508:2026

यह उत्पाद नियमावली सभी क्षेत्रीय/शाखा कार्यालयों और लाइसेंसधारियों द्वारा विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना-I 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 18508:2026
	शीर्षक / Title	:	Chipboard Screws
	संशोधनों की संख्या **No. of amendments**	:	0
2.	**नमूनाकरण दिशानिर्देश / Sampling Guidelines**		
a)	**कच्चा माल** **Raw material**	:	As per Cl. 5 & Table 4 of IS 18508:2026 *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**	:	50 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. *Note: Apart from the above, any other requirements/ parameters may also be declared as per the standard, as applicable.*
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 *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:**		
"License is granted to use Standard Mark as per **IS 18508:2026** with the following scope:			
Name of the product			Chipboard Screws
Designation*	**Thread Size**		3 mm / 3.5 mm / 4 mm / 4.5 mm / 5 mm / 6 mm
	Screw Length		____ mm upto and including ____ mm
	Type of Cross Recess		Type H / Type Z
	Material & Grade	**Steel**	Grade: 7M / 8M
		Stainless Steel	Grade: A2 / A3 / A4 / A5
Surface coating	**Steel**		As processed (no coating) / Electroplating / Phosphating / Other finishes or coatings as declared by the manufacturer
	Stainless Steel		Clean and bright and/or Passivated

* - For guidance refer example given in Cl. 8 of IS 18508

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ANNEX -A
Grouping Guidelines

1. "Chipboard Screws" covered in IS 18508:2026 are classified based on the following parameters:

Designation*	**Thread Size**		3 mm / 3.5 mm / 4 mm / 4.5 mm / 5 mm / 6 mm
	Screw Length		____ mm upto and including ____ mm
	Type of Cross Recess		Type H / Type Z
	Material & Grade	**Steel**	Grade: 7M / 8M
		Stainless Steel	Grade: A2 / A3 / A4 / A5
Surface coating	**Steel**		As processed (no coating) / Electroplating / Phosphating / Other finishes or coatings as declared by the manufacturer
	Stainless Steel		Clean and bright and/or Passivated

* - For guidance refer example given in Cl. 8 of IS 18508

2. Considering the above, the grouping guidelines given below shall be followed for GoL/CSoL:

- Sample of each designation of Chipboard Screws shall be tested separately.
- Sample(s) of Chipboard Screws having lowest thread size and highest thread size of any screw length shall be tested for all requirements to cover all the thread sizes in that particular designation for which the firm intends to take the licence.
- Sample of Chipboard Screws having each type of surface coating shall be tested separately. However, if samples of coated Chipboard Screws are tested, Chipboard Screws without coating may also be covered.

3. The Firm shall declare the varieties of Chipboard Screws intended to be covered in the Licence.

4. The Scope of Licence may be restricted based on the Manufacturing and testing capabilities of the manufacturer.

5. 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.	4 Table 1 to 3	Dimensions	Micrometer Vernier Caliper Angle Gauge Thread gauges Pitch Gauge Profile Projector
2.	5, Table 4	Chemical Composition	Spectrometer Sample Preparation Tools Reference Materials
3.	5, Table 4	Surface coating	Coat meter Salt spray tester with heater and temperature controller Stop watch / Timer Sulphur di oxide
4.	5, Table 4	Surface Condition	MPI Liquid penetrate or other NDT Methods
5.	6	Hardness	Hardness Tester Sample Preparation Tools
6.	7, Table 5	Torque Testing	Torque Wrench

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 Chipboard Screws of same thread size, same type of cross recess made from same material/grade, same screw length and having same surface coating and manufactured 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 on the packaging of the Chipboard Screws provided always that the Chipboard Screws so marked conforms to each requirement of the specification.

3.1 Marking of Chipboard Screws shall be done as per Cl. 9 of IS 18508:2026.

3.2 **Additional Marking requirements**: The Chipboard Screws 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)

<table>
<tr><th colspan="4">(1)</th><th colspan="3">(2)</th></tr>
<tr><th colspan="4">Test Details</th><th colspan="3">Levels of Control</th></tr>
<tr><th rowspan="2">Cl.</th><th rowspan="2" colspan="2">Requirement</th><th colspan="2">Test Methods</th><th rowspan="2">No. of Sample</th><th rowspan="2">Frequency</th><th rowspan="2">Remarks</th></tr>
<tr><th>Clause</th><th>Reference</th></tr>
<tr><td rowspan="2">6</td><td rowspan="2">Chemical Composition</td><td>Steel</td><td rowspan="2"></td><td>IS 7887</td><td colspan="2" rowspan="2">Each Consignment</td><td rowspan="2">No further testing is required if accompanied with the Test Certificate or ISI marked.</td></tr>
<tr><td>Stainless Steel</td><td>IS 1367 (Part 14 / Sec 4)</td></tr>
<tr><td>4</td><td colspan="2">Dimensions</td><td>4, Table 1, Table 2 & Table 3</td><td>IS 18508</td><td colspan="3" rowspan="4">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</td></tr>
<tr><td rowspan="4">5
Table 4</td><td colspan="2">Cross Recess</td><td></td><td>IS 7478</td></tr>
<tr><td colspan="2">Tolerances, shape and positional tolerances</td><td></td><td>IS 1367 (Part 2)</td></tr>
<tr><td colspan="2">Surface condition</td><td></td><td>IS 1367 (Part 9 / Sec 1)</td></tr>
<tr><td colspan="2">Acceptance test</td><td></td><td>IS 1367 (Part 17)</td></tr>
<tr><td rowspan="3">5
Table 4</td><td colspan="2">Surface Coating</td><td>5, Table 4</td><td>IS 18508</td><td></td><td></td><td></td></tr>
<tr><td colspan="2">Electroplating</td><td></td><td>IS 1367 (Part 11)</td><td>03</td><td rowspan="2">Each batch of Surface condition treatment</td><td></td></tr>
<tr><td colspan="2">Phosphating</td><td></td><td>IS 1367 (Part 12)</td><td>03</td><td></td></tr>
<tr><td>6</td><td colspan="2">Hardness</td><td>6.1, 6.2</td><td>IS 18508</td><td>01</td><td>Each Control Unit</td><td></td></tr>
<tr><td>7</td><td colspan="2">Torque Testing</td><td>7, Table 5</td><td>IS 18508</td><td>01</td><td>Each Control Unit</td><td></td></tr>
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