



**PRODUCT MANUAL FOR
Steel Countersunk Head Wire Nails
ACCORDING TO IS723:1972**

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.

1.	Product	:	IS 723:1972
	Title	:	Steel Countersunk Head Wire Nails
	No. of Amendments	:	3
2.	Sampling Guidelines:		
a)	Raw material	:	As per Clause 2 of IS 723
b)	Grouping guidelines	:	Steel Countersunk Head Wire Nail of any designation to be tested to cover Nails of all designations.
c)	Sample Size	:	40 Nails
3.	List of Test Equipment	:	Please refer ANNEX – <u>A</u>
4.	Scheme of Inspection and Testing	:	Please refer ANNEX – <u>B</u>
5.	Possible tests in a day	:	All Tests
6.	Scope of the Licence :		
	“Licence is granted to use Standard Mark as per IS 723:1972 with the following scope:		
	Name of the product	Steel Countersunk Head Wire Nails	
	Designation	Nail Shank Dia x Length IS 723	

ANNEX A**List of Test Equipment***Major test equipment required to test as per the Indian Standard*

Sl. No.	Tests used in with Clause Reference	Test Equipment
1.	Dimension and Tolerance (Clause 3)	a) Vernier Calliper b) External Micrometer c) Filler gauge
2	Bend Test (Clause 7.1)	a) Mandrel b) Hammer
3	Packing (Clause 8)	a) weighing Balance

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

ANNEX B

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 manufacturer shall prepare a calibration plan for the test equipments.

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

3. LABELLING AND MARKING – Designation as per clause 4 and weight of nails as per clause 8 of IS 723:1972 shall be marked on each box and gunny bag as the case may be.

4. CONTROL UNIT – All nails produced in one day shall constitute a 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 Standards and covered by the licence 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		
Cl.	Requirement	Test Method			No. of Sample	Frequency	Remarks
		Clause	Reference				
2	Material	2	IS 723 IS 278	S	One	Each Consignment	No further testing is required, if accompanied with test certificate or ISI marked
3	Dimensions and Tolerances	3	IS 723	R	Ten	Every two hour of production	In case of failure, 10 more nails from the same batch (two hour production) unit to be tested and the batch (two hour production) will be considered as pass only, if all the ten nails pass.
3.1	Band of shank	3.1	IS 723	R			
3.2	Eccentricity and ovality	3.2	IS 723	R			
6	Finish	6	IS 723	R	All		Visual Inspection only
7.1	Bend Test	7.1	IS 723	R	Five	Every four hour of production	In case of failure, five more nails from the same batch (four hour production) to be tested and the batch (four hour production) will be considered as pass only, if all the five nails pass.
8	Packing	8	IS 723	R	All Packings		

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/batch/lot and submit his own levels of control in column 3 with proper justification for approval by BO Head.