



PRODUCT MANUAL FOR STAINLESS STEEL TOWER BOLTS ACCORDING TO IS 15833: 2009

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 15833: 2009
	Title	:	Stainless Steel Tower Bolts
	No. of Amendments	:	Nil
2.	Sampling Guidelines:		
a)	Raw material	:	Sheet – Clause 4.1 of IS 15833: 2009 Bolt – Clause 4.2 of IS 15833: 2009
b)	Grouping guidelines	:	Please refer ANNEX – A
c)	Sample Size	:	Stainless steel tower bolts – 5 Nos
3.	List of Test Equipment	:	Please refer ANNEX – B .
4.	Scheme of Inspection and Testing	:	Please refer ANNEX – C .
5.	Possible tests in a day:		
	i)	Manufacture (Clause 5)	
	ii)	Dimensions (Clause 6)	
	iii)	Finish (Clause 7)	
6.	Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 15833: 2009 with the following scope:		
	Name of the Product	Stainless Steel Tower Bolts	
	Type	Barrel type	
	Size	100 mm, 150 mm, 200 mm, 250 mm and 300 mm	
	Bolt diameter	10 mm/ 12 mm	

ANNEX A

Grouping Guidelines

1. Stainless Steel Tower Bolts covered under IS 15833: 2009 are classified as given below:
 - a) **Type:** Barrel type
 - b) **Size (Length of barrel):** 100, 150, 200, 250 and 300 mm
 - c) **Diameter of bolt:** 10 and 12 mm.
2. Considering the above, following grouping guidelines is developed for GoL/CSoL:
 - Sample of Tower Bolt of each diameter, with minimum and maximum barrel length from the range of lengths intended to be covered in the licence shall be tested for all requirements to cover Tower Bolts of all lengths in the tested length range for that particular type of diameter tested.
3. The firm shall declare the variety they intend to cover in the licence. The scope of the Licence may be restricted based on the Manufacturing and Testing capabilities of the Manufacturer.
4. During the operation of the licence, BO shall ensure that all the varieties covered in the Licence are tested in rotation to the extent possible.

ANNEX B**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.	Manufacture (Clause 5)	- Micrometer - Countersunk head of wood screws as per IS 6760
2.	Dimensions (Clause 6 and Table 1)	- Vernier Calliper - Micrometer - Countersunk head of Wood Screws as per IS 6760

The above list is indicative only and may not be treated 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 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 – As per the requirement of IS 15833: 2009.

4. CONTROL UNIT – All the stainless-steel tower bolts of same size and diameter of bolt manufactured from the same lot of raw material under similar conditions of manufacturing in a shift 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: Subcontracting permitted	Levels of Control		
Cl.	Requirement	Test Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Material						
	Sheet	4.1	IS 15833 IS 6911	-	-	-	Material received shall be ISI marked.
	Bolt	4.2	IS 15833 IS 6527	-	-	-	
5	Manufacture	5.1, 5.2	IS 15833	R	All	-	-
6	Dimension	6, Table 1, 10.3.1	IS 15833	R	Five	Each control Unit	-
7	Finish	7, 10.3.1	IS 15833	R	All	-	-
10.3.2	Corrosion resistance	10.3.2	IS 15833	S	If required by purchaser, the material shall be tested for corrosion resistance. Method of test, requirement and number of samples shall be as agreed between purchaser and the manufacturer		

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.