



**PRODUCT MANUAL FOR  
ASBESTOS CEMENT BUILDING PIPES AND PIPE FITTINGS,  
GUTTERS AND GUTTER FITTINGS AND ROOFING  
FITTINGS – GUTTER AND GUTTER FITTINGS  
ACCORDING TO IS 1626 (PART 2) : 1994**

*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.	<b>Product</b>	:	IS 1626 (Part 2) : 1994
	<b>Title</b>	:	Asbestos Cement Building Pipes and Pipe Fittings, Gutters and Gutter fittings and Roofing fittings - Gutter and Gutter Fittings
	<b>No. of Amendments</b>	:	NIL
2.	<b>Sampling Guidelines:</b>		
a)	<b>Raw material</b>	:	Cement – Clause 3 of IS 1626 (Part 2): 1994 Other ingredient – Clause 3 of IS 1626 (Part 2): 1994
b)	<b>Grouping guidelines</b>	:	Please refer ANNEX – A
c)	<b>Sample Size</b>	:	Gutters/Gutter fittings - 3 Nos
3.	<b>List of Test Equipment</b>	:	Please refer ANNEX – B
4.	<b>Scheme of Inspection and Testing</b>	:	Please refer ANNEX – C
5.	<b>Possible tests in a day:</b>		
	i) General quality and workmanship (Clause 4) ii) Dimensional requirements (Clause 5.1) iii) Shape (Clause 5.2)		
6.	<b>Scope of the Licence:</b>		
	“Licence is granted to use Standard Mark per IS 1626 (Part2):1994 with the following scope”		
	Name of the product	Asbestos Cement Gutter and Gutter Fittings	
	Type	Valley gutter (V) /Boundary wall gutter (BW)/ Half round gutter (H) Gutter fittings (Fig 4 to 7)	
	Nominal size		

**ANNEX A****Grouping Guidelines**

1. Asbestos Cement Gutter and Gutter Fittings covered in IS 1626 (Part 2): 1994 are classified as given below:

a) **Types of Gutters:**

Type of Gutter	Nominal Sizes (mm)	Code No
Valley gutter	915 × 205 × 230 610 × 150 × 230 455 × 125 × 150 405 × 125 × 255	V
Boundary wall gutter	510 × 150 × 255 455 × 150 × 305 305 × 150 × 230 280 × 125 × 180	BW
Half round gutter	305, 230, 150	H

b) **Type of Gutter Fittings:**

- i) Drop end and nozzle for boundary wall and valley gutters (Fig 4)
- ii) Drop end and nozzle for half round gutters (Fig 5)
- iii) Stop end and union clip for gutters (Fig 6)
- iv) Angle for gutter (Fig 7)

2. Considering the above, the following grouping guidelines is developed for GoL/CSoL:

- One sample of each type of gutter [as per 1(a)] and gutter fittings [as per 1(b)] of any nominal size shall be tested for all requirements to cover all nominal sizes of that particular type of gutter and gutter fittings tested.

4. The Firm shall declare the varieties they intend to cover in the Licence. The Scope of Licence may be restricted based on the Manufacturing and Testing capabilities of the Manufacturer.

5. During the operation of the Licence, BO shall ensure that all the types and sizes 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*

<b>Sl. No.</b>	<b>Tests used in with Clause Reference</b>	<b>Test Equipment</b>
1	Dimension (Clause 5.1)	<ul style="list-style-type: none"> <li>- Steel scale</li> <li>- Vernier calliper</li> <li>- Micrometer</li> <li>- Templets</li> </ul>
2	Shape (Clause 5.2)	<ul style="list-style-type: none"> <li>- Steel scale</li> <li>- Vernier calliper</li> <li>- Micrometer</li> <li>- Plug gauges/templets</li> </ul>
3	Permeability (Clause 5.3)	<ul style="list-style-type: none"> <li>- Transparent or metallic tube</li> <li>- Steel scale</li> <li>- Suitable arrangement for supporting the test pics which provides the bottom surface to be inspected</li> <li>- Sealing wax</li> <li>- Air Conditioner and humidity control arrangement</li> <li>- Hygrometer</li> </ul>

*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 1626 (Part 2): 1994.

**4. CONTROL UNIT** – All gutters and gutter fittings of same type and size produced from same raw material composition under similar condition of manufacturing in a week 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				
3	<b>Composition</b>						
	Cement	3	IS 1626 (Part 2)	-	-	-	Cement shall be ISI marked
4	General quality and workmanship	4	IS 1626 (Part 2)	-	All	-	Adequate visual inspection to be done
5	<b>Dimensional and Physical requirements</b>						
5.1	Dimensional requirements	5.1, Table 1 to Table 3	IS 1626 (Part 2)	R	1 % subject to minimum of 5 nos	Each control unit	In case of failure, complete control unit shall be checked, and conforming product only shall be marked.
5.2	Shape	5.2, Fig 4 to 7	IS 1626 (Part 2)	R	1 % subject to minimum of 5 nos	Each control unit	In case of failure, complete control unit shall be checked, and conforming product only shall be marked. Dimensions of gutter fittings shall be declared by the manufacturer.
5.3	Impermeability test	5.3	IS 1626 (Part 2) IS 5913	R	Three	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/batch/lot and submit his own levels of control in column 3 with proper justification for approval by BO Head.