



**PRODUCT MANUAL FOR
VIBRATION MACHINE FOR CASTING
STANDARD CEMENT MORTAR CUBES
ACCORDING TO IS 10080 : 1982**

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 10080: 1982
	Title	:	Vibration Machine for Casting Standard Cement Mortar Cubes
	No. of Amendments	:	5
2.	Sampling Guidelines:		
a)	Raw material	:	As per clause 2.1, Table 1 and clause 3.5 of IS 10080: 1982
b)	Grouping guidelines	:	Vibration Machine for Casting Standard Cement Mortar Cubes or Mould of size 70.6 mm or Poking rod, as applicable shall be tested separately for considering GoL/CSoL
c)	Sample Size	:	Vibration machine/ Mould/Pocking rod – 1 No
3.	List of Test Equipment	:	Please refer ANNEX – A
4.	Scheme of Inspection and Testing	:	Please refer ANNEX – B
5.	Possible tests in a day:		
	i)	Vibrator (Clause 3.1.1)	
	ii)	Mould (Clause 3.4)	
	iii)	Poking rod (Clause 3.5)	
6.	Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 10080: 1982 with the following scope:		
	Name of the product	Vibration Machine for Casting Standard Cement Mortar Cubes or Mould of size 70.6 mm or Poking rod (as applicable)	

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.	Construction (Clause 3.1)	<ul style="list-style-type: none"> - Weighing balance - Tachometer - Dynamic balancing machine or similar arrangement for checking out of balance moment of eccentric shaft
2.	Mould (Clause 3.4)	<ul style="list-style-type: none"> - Vernier caliper - Angle Protractor - Micrometer - Filler gauge - Straight edge - Weighing balance - Hardness tester - Dial Height Gauge - Dial Bore Gauge - Dial Indicator (Plunger Type) - Plain Plug Gauge (GO- NOGO) - Plunger Dial Gauge
3.	Poking rod (Clause 3.5)	<ul style="list-style-type: none"> - Durometer hardness tester - Vernier caliper/Steel scale - Radius gauge

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 – As per the requirement of IS 10080: 1982

4. 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.

4.1 All the production which conforms to the Indian Standards and covered by the licence should be marked with Standard Mark.

5. 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		
CI	Requirements	Test Method			No. of Samples	Frequency	Remarks
		Clause	Reference				
2	Material	2.1, Table 1	IS 10080	S	One	Each Consignment	##
3	Construction - Vibration Machine - Bed - Vibrator	3.1, 3.2, 3.3, Fig 1	IS 10080	R	Each Vibration machine	-	-
3.4	Mould – Dimension and construction	3.4, 3.4.1, Fig 2, Table 2	IS 10080 IS 10086	R	Each mould	-	-
3.5	Poking rod						
	Material	3.5	IS 10080	R	One	Each consignment	##
	Dimensions	3.5, Fig 3	IS 10080	R	Each poking rod	-	-

Further testing is not required each consignment received with manufacturers test certificate or ISI marked. Product under mandatory product certification of BIS shall be received with ISI marked. In case of casting, number of samples to be tested shall be as per IS 210.

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.