



PRODUCT MANUAL FOR STAINLESS STEEL BUTT HINGES ACCORDING TO IS 12817: 2013

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.

1.	Product	:	IS 12817: 2013
	Title	:	STAINLESS STEEL BUTT HINGES
	No. of Amendments	:	Nil
2.	Sampling Guidelines:		
a)	Raw material	:	As per Clause 4.1 of IS 12817: 2013
b)	Grouping guidelines	:	Please refer ANNEX – A
c)	Sample Size	:	12 Hinges
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:		
	<ul style="list-style-type: none"> a) Dimensions and tolerances (Clause 6) b) Manufacture (Clause 7) c) Finish (Clause 8) d) Marking (Clause 10) 		
6.	Scope of the Licence	:	Please refer ANNEX – D
	“Licence is granted to use Standard Mark as per IS 12817: 2013 with the following scope:		
	Name of the product	Stainless Steel Butt Hinges	
	Type		
	Sizes		

ANNEX A

Grouping Guideline

1. Stainless Steel Butt Hinges covered in IS 12817: 2013 are classified based on the following:

(a) Type

- i. Light weight (narrow) hinges
- ii. Light weight unequal flap hinges
- iii. Medium weight hinges
- iv. Medium weight (narrow) hinges
- v. Heavy weight unequal flap hinges
- vi. Heavy weight hinges

(b) Size of Hinges

As per Table 1 to Table 6 of IS 12817: 2013.

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

- One sample from each type of Hinges with minimum and maximum size shall be drawn to cover all the sizes of Hinges for that particular type.
3. 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.
 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	Dimensions and tolerances (Clause 6)	<ul style="list-style-type: none"> - Vernier Callipers - Micrometer - Dial thickness Gauge
2	Manufacture (Clause 7)	<ul style="list-style-type: none"> - Screws of appropriate number - Vernier Callipers - Try Square

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 12817: 2013.

4. CONTROL UNIT – All hinges of same type and size manufactured from same lot of raw materials under identical conditions, in two hours 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				
4	Material	4.1, 4.1.1, 4.1.2	IS 12817 IS 6911 IS 6528	-	-	-	The consignment received shall be ISI marked and received along with manufacturers test certificate.
6	Dimensions and Tolerances	6.1,6.2, Table 1 to Table 6	IS 12817	R	5	Each control unit	At the starting of production, 10 samples shall be tested and normal frequency shall be followed if all the samples are conforming.
7	Manufacture	7.1 to 7.4, Table 1 to Table 6	IS 12817	R	5	Each control unit	In case of failure, machine shall be reset and 10 samples shall be tested again and normal frequency shall be followed if all the samples are confirming. Production during one hour before resetting of machine shall not be marked.
8	Finish	8	IS 12817	R	Each hinge	-	-

Note-1: 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.