



**PRODUCT MANUAL FOR
CANVAS SHOES, RUBBER SOLE
ACCORDING TO IS 3735: 1996**

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 3735 : 1996
	Title	:	Canvas Shoes, Rubber Sole - Specification
	No. of Amendments	:	4
2.	Sampling Guidelines:		
a)	Raw material	:	Shall conform to Cl 4.1 (Material) of IS 3735:1996
b)	Grouping guidelines	:	One sample of any size shall be tested to cover boots of all sizes, subject to availability of testing and manufacturing facilities / capabilities.
c)	Sample Size	:	3 Pairs
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) Shape & Design(Cl 4.2)		
	(ii) Construction(Cl 4.3)		
	(iii) Mass(Cl 4.6)		
6.	Scope of the Licence :		
	“Licence is granted to use Standard Mark as per IS 3735 : 1996 with the following scope:		
	Name of the product	Canvas Shoes, Rubber Sole	
	Sizes	Upto 5 / 5½ to 8 / 8½ & above or Upto 38 / 39 to 42 / 43 & above	

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	Test on Upper (Cl 4.1.1 & Table 1)	Tensile testing machine Steel scale Conditioning chamber Scissors Porter gauge Equipment, in which test specimens can be immersed in water
3	Binding Material (Cl 4.1.2)	Vernier caliper Tensile testing machine Steel scale
4	Threads for upper closing (Cl 4.1.3)	Tensile testing machine Conditioning chamber Steel scale
5	Eyelets (Cl 4.1.4)	Vernier caliper
6	Laces (Cl 4.1.5)	Steel tape Tensile testing machine Alkaline hydrosulphite solution Stop watch Hot plate Test tube Stannous chloride solution Lead acetate Filter paper
7	Rubber Components (Cl 4.1.6)	Conditioning chamber Analytical balance Balance pan straddle Beaker, 250 ml Distilled water Filament Knife Hardness tester/ Durometer Ross flexing machine Dies and cutters Tensile testing machine

		Vernier calliper Thickness gauges Compression set apparatus
8	Ageing (CI 4.1.6.2)	Ageing oven
10	Construction (CI 4.3)	Porter gauge
11	Adhesion test (CI 4.4)	Vernier calliper Dies and cutters Conditioning chamber Steel scale Air conditioner Tensile testing machine/ Static load strip test apparatus
12	Consolidation test (CI 4.5)	Vernier calliper Dies and cutters Conditioning chamber Steel scale Air conditioner Tensile testing machine/ Static load strip test apparatus
13	Mass (CI 4.6)	Weighing Scale

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. PACKING AND MARKING – The Standard Mark as given in the Schedule of the license and shall be marked on the underside of each shoe, provided always that the product thus marked and packed conforms to all the requirement of the specification.

3.1 Marking and packing shall be done as per the provisions of the Indian Standard. In addition In addition, the following details shall be mentioned on the waist of the insole face cover:

a) BIS Licence No. CM/L _____.

b) BIS website details i.e.–“For details of BIS certification please visit www.bis.gov.in”

4. CONTROL UNIT – For the purpose of this scheme, all finished shoes of one size, vulcanized at a time and produced in a 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				
MATERIAL							
4.1.1 & Table 1	Upper: Overlayer Breaking load, warp & weft Ends & picks/dm Inner Layer (cotton drill) Breaking load, warp & weft Ends & Picks/dm		IS 1969:1985 IS 1963:1981 IS 1969:1985 IS 1963:1981	S	Two -do- -do- -do-	Each Consignment -do- -do- -do-	See Note 3
4.1.1.1	Colour fastness		IS 686:1985 IS 2454:1989 IS 764:1979	S	-do-	-do-	-do-
4.1.2	Binding Material	4.1.2	IS 3735:1996	S	Two	-do-	-do-
4.1.3	Threads for upper closing	4.1.3	-do-	S	One	-do-	-do-
4.1.4	Eyelets	4.1.4	-do-	S	Five	-do-	-do-
4.1.5	Laces	4.1.5	-do-	S	One	-do-	-do-
SHOES							
4.1.6	Rubber Components	4.1.6	-do-	R	One	Each Consignment	The rubber compounded in a mixing mill shall constitute a batch of rubber component
4.1.6.2	Ageing	4.1.6.2	IS 3735:1996	R	One Pair	Each Control Unit	
4.2	Shape & Design	4.2 & Fig.1	-do-	R	Each Pair		
4.3	Construction	4.3.1 to 4.3.8	-do-	R	Each Pair		After every operation each pair shall be inspected and only if found satisfactory, shall be taken for further processing.
4.4	Adhesion test	4.4	-do-	R	One pair	Each Control Unit	

4.5	Consolidation test	4.5	-do-	R	-do-	-do-	
4.6	Mass	4.6	-do-	R	-do-	-do-	

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empaneled 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 to BO head.

Note-3: Conformity of materials and components to the requirement of the specification may be established through either of the following or a combination of the same (No testing is required if the material is ISI marked):

- i. Test report from a laboratory recognized by the Bureau or Government laboratories empaneled by the Bureau
- ii. Material manufacturer's test certificate
- iii. In house factory test report