



**PRODUCT MANUAL FOR
SCREWED CLOSURES FOR DRUMS
ACCORDING TO IS 1784: 2020**

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 1784: 2020
	Title	:	Screwed Closures for Drums
	No. of Amendments	:	Nil
2.	Sampling Guidelines:		
a)	Raw material	:	As per Cl.4 of IS 1784: 2020
b)	Grouping guidelines	:	Please refer ANNEX – A
c)	Sample Size	:	6 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	:	a) Dimensions and tolerance (Cl. 6) b) Interchangeability (Cl. 8.1) c) Air pressure test (Cl. 8.2) d) Torque test for steel bungs (Cl. 8.3) e) Curling test (Cl. 8.4)
6.	Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 1784: 2020 with the following scope:		
	Name of the product	Screwed Closures for Drums	
	Bung Material	Steel/Zinc alloy	
	Size	20 mm/ 50 mm	

ANNEX A

Grouping Guidelines

1. Screwed Closures for Drums as per IS 1784 are classified based on the material of Bung:
 - a) Steel
 - b) Zinc Alloy
2. Further, two nominal sizes of closures 50 mm and 20 mm are covered in the Standard.
3. For considering GoL/CSoL, separate samples of closure of each material shall be tested to cover closure of that particular material in the Scope of Licence. However, if closure of higher size is tested, then closure of lower size of the same material may also be covered without further testing.
4. The Firm shall declare the varieties of Closures 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 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, Cl. 6, 6.1, Fig. 2 to 6)	Vernier Caliper, Gauges conforming to IS 10216
2.	Air pressure test, Cl. 8.2	Fixture, Pressure gauge, Air compressor.
3.	Torque test for steel bung, Cl. 8.3	Torque wrench
4.	Curling test for flanges, Cl. 8.4	Fixture similar to the flange insertion die, Angle protector, Magnifying glass

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 1784.

4. CONTROL UNIT- All Closures manufactured 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: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Method			No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Material	Cl. 4.1 to 4.4	IS 1784	S	One	Each consignment	No further testing is required if accompanied with test certificate or ISI marked.
5	Manufacture	Cl. 5.1 to 5.4	IS 1784	-	Each Closure		-
6	Dimensions & tolerances	Cl.6, Fig. 2 to Fig.6	IS 1784	R	Each Closure		-
7	Finish	Cl.7	IS 1784	-	As agreed between purchaser and manufacturer		-
8.1	Interchangeability	Cl. 8.1	IS 1784	R	Adequate inspection to be carried out to ensure interchangeability		-
8.2	Air pressure test	Cl. 8.2	IS 1784	R	Five	Each Control unit	-
8.3	Torque test for steel bungs	Cl. 8.3	IS 1784	R	One	Every 1000 bungs	In case of failure further two samples shall be drawn and tested. The lot shall be considered passing if both the samples pass otherwise lot shall not be marked.
8.4	Curling test for flanges	Cl. 8.4	IS 1784	R	One	Every 1000 flanges	

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.