



**PRODUCT MANUAL FOR
STEEL DOORS, WINDOWS AND VENTILATORS
ACCORDING TO IS 1038: 1983**

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 1038 : 1983
	Title	:	STEEL DOORS, WINDOWS AND VENTILATORS
	No. of Amendments	:	3
2.	Sampling Guidelines:		
a)	Raw material	:	a) Rolled Steel Section - Clause 5.1 of IS 1038 b) Coupling Sections for non-modular openings - Clause 5.2 of IS 1038 c) Glass Panes - Clause 5.3 of IS 1038 d) Screws - Clause 5.4 of IS 1038
b)	Grouping guidelines	:	Please refer ANNEX – A
c)	Sample Size	:	2 Nos for all tests
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 :		
	(i) Sizes (Clause 4.1) (ii) Fabrication (Clause 6) (iii) Finish (Clause 8) (iv) Glazing (Clause 9)		
6.	Scope of the Licence :		
	“Licence is granted to use Standard Mark as per IS 1038 : 1983 with the following scope:		
	Name of the product	Steel Doors, Windows , Ventilators and Fixed light	
	Designation	- Designation of Door/Windows/Ventilator/Fixed light - Modular/Non modular	

ANNEX A**Grouping Guidelines**

1. Steel Doors, Windows, Ventilators and Fixed-lights are classified as given below:

Doors	Side Hung type	i) Horizontal glazing bars (HS) ii) No horizontal glazing bars (NS)
Windows	Side Hung type	i) Horizontal glazing bars (HS) ii) No horizontal glazing bars (NS)
Ventilators	Top Hung type	i) Horizontal glazing bars (HT) ii) No horizontal glazing bars (NT)
	Centre Hung type	i) Horizontal glazing bars (HC) ii) No horizontal glazing bars (NC)
Fixed light	Door height	i) Horizontal glazing bars (HF) ii) No horizontal glazing bars (NF)
	Window height	i) Horizontal glazing bars (HF) ii) No horizontal glazing bars (NF)
	Ventilator height	i) Horizontal glazing bars (HF) ii) No horizontal glazing bars (NF)

2. For considering GoL and CSoL, the following guidelines shall be followed:

One sample of any size, each from modular and non-modular size, for each variety (i.e. Doors/Windows/Ventilators/Fixed-lights) and Type shall be drawn to cover that variety, type and all sizes of modular/non modular tested.

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 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*

S. No.	Tests used in with Clause Reference	Test Equipment
1.	Standard Sizes and Fabrication (Clause 4, 6)	i) Vernier Caliper ii) Steel Scale iii) Steel tape iv) Micrometer v) Radius gauge vi) Snap gauge
2.	Macro Examination (Clause 6.1.1.2)	i) Grinder for polishing weld ii) Etching agent
3.	Micro Examination (Clause 6.1.1.3)	i) Grinder for polishing weld ii) Etching agent iii) Microscope
4	Fillet Weld Test (Clause 6.1.1.4)	Hammer

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 equipment.

2. TEST RECORDS – The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. LABELLING AND MARKING – As per the requirements of IS 1038: 1983.

4. CONTROL UNIT – Steel doors/Windows/Ventilators/Fixed-lights of same designation manufactured in one 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 Standard 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 Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
4.1	Sizes	4.1.1, 4.2 and Fig 2	IS 1038	R	All	-	-
5	Materials	5	IS 1038	S	One	Each consignment received	#
6	Fabrication (Frames)	6.1 to 6.1. 6	IS 1038	R	One	Frames fabricated in one hour	
	Fabrication (Other than Frames)	6.2 to 6.7	IS 1038	R	One		
6.1.1	Requirement of welded joints						
6.1.1.1	Visual Inspection	6.1.1.1	IS 1038	R	One	Each control unit	
6.1.1.2	Macro Examination	6.1.1.2	IS 1038	R	One		
6.1.1.3	Micro Examination	6.1.1.3	IS 1038	S	One	Once in three months for each welder or machine and whenever there is a change in the welder/machine	
6.1.1.4	Fillet Weld Test	6.1.1.4	IS 1038	S	One		
7	Position of holes, fixing screws and lugs	7.1, 7.2	IS 1038	R	One	Frames fabricated in one hour	
8	Finish- Phosphating and Painting	8.1.1	IS 1038	R	All	-	-
	Finish - Hot dipped galvanizing	8.1.2	IS 1038	R	One	From each lot galvanized in a day	
9	Glazing	9	IS 1038	R	One	Frames fabricated in one hour	

No further testing is required if accompanied with Test Certificate or ISI marked.

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.