



PRODUCT MANUAL FOR STEEL BUTT HINGES ACCORDING TO IS 1341: 2018

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 1341 : 2018
	Title	:	STEEL BUTT HINGES
	No. of Amendments	:	NIL
2.	Sampling Guidelines:		
a)	Raw material	:	As per Clause 4 and Table 1 of IS 1341
b)	Grouping guidelines	:	Please refer ANNEX – A
c)	Sample Size	:	10 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) All Test as per IS 1341		
6.	Scope of the Licence :		
	“Licence is granted to use Standard Mark as per IS 1341 : 2018 with the following scope:		
	Name of the product	Steel Butt Hinges	
	Type	a) Light weight ‘LW’ steel butt hinges b) Light weight ‘LWU’ unequal flap hinges c) Medium weight ‘MWU’ unequal flap hinges d) Medium weight ‘MW’ steel butt hinges e) Broad type ‘BR’ steel butt hinges f) Square type ‘SQ’ steel butt hinges g) Heavy weight (Type 1) ‘HW1’ steel butt hinges h) Heavy weight (Type 2) ‘HW2’ steel butt hinges	
	Size	As applicable as per Table 2 to Table 9 of IS 1341	

ANNEX A

Grouping Guidelines

1. Steel Butt Hinges are classified based on the following:

(A) Types :

- a) Light weight 'LW' steel butt hinges
- b) Light weight 'LWU' unequal flap hinges
- c) Medium weight 'MWU' unequal flap hinges
- d) Medium weight 'MW' steel butt hinges
- e) Broad type 'BR' steel butt hinges
- f) Square type 'SQ' steel butt hinges
- g) Heavy weight (Type 1) 'HW1' steel butt hinges
- h) Heavy weight (Type 2) 'HW2' steel butt hinges

(B) Sizes :

Size denoted by length (A) of the hinge as per Table 2 to Table 9 of IS 1341.

- 2. Considering the above, one sample from each type of Steel Butt Hinges having minimum and maximum size shall be drawn to cover all the sizes of Steel Butt Hinges in that type tested.
- 3. The Firm shall declare the varieties of Steel Butt Hinges 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

Sl. No.	Tests used in with Clause Reference	Test Equipment
1.	Dimensions and Tolerances (Clause 5)	a) Vernier Calliper b) Micrometre
2.	Manufacture (Clause 6)	a) Steel square b) Countersunk head of Wood Screws as per IS 6760

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 1341: 2018.

4. CONTROL UNIT – All Steel Butt Hinges of same type and size manufactured from similar material 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 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	Recommended Levels of Control		
Clause	Requirement	Test Methods Clause Reference			No. of Sample	Frequency	Remarks
4	Material	4	IS 1341	S	-	-	No further testing is required if accompanied with test certificate or ISI marked.
5	Dimensions and tolerance	5.1 & 5.2	IS 1341	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. 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.
6	Manufacture	6.1 to 6.4	IS 1341	R	5	Each control unit	
7	Finish	7	IS 1341	R	Each	-	-

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 B.O. Head.