

केन्द्रीय मुहर विभाग-2

हमारा संदर्भ: के मू वी-2/16: 13382

25 02 2019

विषय: संशोधित IS 13382:2018 की एस आई टी (Scheme of Inspection and Testing)

1. यह उपरोक्त विषय व 07 01 2019 को जारी किए गए कार्यान्वयन दिशा निर्देशों के संदर्भ में है।
2. सक्षम अधिकारी द्वारा अनुमोदित संशोधित IS 13382:2018 की एस आई टी अनुपालन हेतु संलग्न है।

(आदित्य दास)
वैज्ञानिक सी

प्रमुख (के मू वी-2)

सभी क्षेत्रीय/शाखा कार्यालय

प्रतिलिपि :

आई टी एस विभाग – बी आई एस इंटरनेट पर डालने हेतु

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 13382

25 02 2019

Subject: Scheme of Inspection and Testing (SIT) for Revised IS 13382:2018

1. This has reference to the above and further to the implementation guidelines issued on 07 01 2019
2. Scheme of Inspection and Testing for Revised IS 13382:2018, duly approved by the CA, is enclosed for implementation.

(Aditya Das)
Scientist C

Head (CMD-2)

All ROs/BOs

**SCHEME OF INSPECTION AND TESTING
FOR CERTIFICATION OF CAST IRON SPECIALS FOR
MECHANICAL AND PUSH-ON FLEXIBLE JOINTS FOR PRESSURE
PIPES FOR WATER, GAS AND SEWAGE
ACCORDING TO IS 13382:2018
(Second Revision)**

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. **MARKING** -The Standard Mark as given in Schedule of the license shall be stamped or indelibly painted on each casting and the marking shall be done as per the provision of the Indian Standard, provided always the casting thus marked conforms to all the requirement of the specification.
 - 3.1 In addition, BIS Licence No i.e. CM/L-_____ and details of BIS website shall be marked (stamped or indelibly painted) as follows: "For details of BIS certification please visit www.bis.gov.in"
4. **CONTROL UNIT** – For the purpose of this scheme, all the castings of same size and type cast from the same metal in a day shall constitute one control unit.
5. **LEVELS OF CONTROL** - The tests, as indicated in Table 1 and the levels of control specified therein, shall be carried out on the whole production of the factory which is covered by this scheme and appropriate records and charts maintained in accordance with paragraph 2.0 above. All the production which conforms to the Indian Standards and covered by the licence shall be marked with certification mark of the Bureau.
6. **REJECTION** - 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. Any rejected material which is potentially resalable be sheared or cut or deformed in such a manner that it cannot be used for any other purpose except re-melting. A separate record shall be maintained giving information on quantity and cast number/coil number/control unit number, as applicable, relating to all such rejections/defective/substandard material of the production not conforming to the requirements of the Specification and the method of its disposal. Such material shall in no case be stored together with that conforming to the Specification. The Standard Mark (if already applied) on rejected material should be defaced

**IS 13382:2018
CAST IRON SPECIALS FOR
MECHANICAL AND PUSH-ON FLEXIBLE JOINTS FOR PRESSURE
PIPES FOR WATER, GAS AND SEWAGE
ACCORDING TO IS 13382:2018
(Second Revision)**

Table 1: Levels of Control
(Clause 5.0 of the Scheme of Inspection and Testing)

Test Details				Test equipment requirement R:required (or) S: Sub-contracting permitted	Levels of Control			
Clause	Requirement	Method of Test			No. of Samples	Lot Size	Frequency	Remarks
		Clause	Reference					
10.1	Tensile Test	10.1 & Annex A	IS 13382:2018	R	Two	One day's casting	Each days casting	If any of the sample fails, retesting shall be done as per clause 9.3 of IS 13382.
10.2	Hardness Test		IS 1500 (Part 1)	R	-do-	-do-	-do-	
11	Hydrostatic test	11 & Table 2	IS 13382:2018	R	Each fitting			
6, 12, 13, 19	Sizes and tolerances	6, 12, 13 and 19	-do-	R	Two	One Control Unit	Each Control Unit	
5	Manufacture and Repair	5.1 to 5.6	-do-	R	Each fittings manufactured			
7	Joints	7.1 to 7.6	-do-	R	-do-			

14	Coating	14.1 and 14.2	-do-	R	One	One Control Unit	Once a Week	
8	Rubber gasket (if supplied)		IS 5382	R	One	One consignment	Each Consignment	In case test certificate is received with the supply indicating conformity, no testing is required
15	Cement Mortar lining (optional)	15	IS 13382:2018	S	As agreed between purchaser and supplier			
17	Type tests	17 and 18	-do-	S	If the design has been tested and documented by the manufacturer and successfully used for a minimum of ten years, no type test is necessary for that design. The performance of a type test is only required whenever there are significant changes in design which could adversely affect the performance of the joint.			

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 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.