

केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-3/16: IS 2365

दिनांक :04 02 2019

विषय: अनुपालन हेतु एस आई टी

सभी शाखा कार्यालय से आग्रह है कि एस आई टी का अनुपालन तत्काल प्रभाव से सुनिश्चित करें।

(अमित कुमार)
वैज्ञानिक 'सी' (सी एम डी-III)

प्रमुख (सी एम डी-III)

सभी क्षेत्रीय/शाखा कार्यालय
आई टी एस विभाग – बीआईएस इंटरनेट पर अपलोड करने हेतू

CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-3/16: IS 2365

Date: 04 02 2019

Subject: SIT for IS 2365 :2018 – Steel Wire Suspension Ropes for Lifts, Elevators and Hoists (Second Revision).

This has reference to the subject mentioned above.

BOs may kindly ensure implementation of the SIT with immediate effect.

Amit Kumar
Sc. C (CMD III)

Head (CMD - III)

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**SCHEME OF INSPECTION AND TESTING
FOR CERTIFICATION OF
STEEL WIRE SUSPENSION ROPES FOR LIFTS, ELEVATORS AND HOISTS
ACCORDING TO IS 2365 : 2018**

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 2365 : 2018.

4. 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.

4.1 All the production which conforms to the Indian Standard and covered by the licence should be marked with Standard Mark.

5. 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

Table 1

(1)				(2)	(3)		
TEST DETAILS				Test equipment requirement	LEVELS OF CONTROL		
Cl.	Requirement	Test Methods		R: required (or) S: Sub-contracting permitted	No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Rope Size and Tolerance	4	IS 2365	R	Each rope	---	---
5	Minimum Breaking Load	5, Annex A	IS 2365	R	Two	Each continuous length	For finished rope
6.1	Core Fibre Core Steel Core	6.1	IS 2365 IS 1804 IS 6594	S	One	Each Consignment	No further testing is required if accompanied with test certificate
6.2	Joints	6.2	IS 2365	R	Each rope	---	---
6.3	Mass	6.3	IS 2365	R	Each rope	---	---
6.4	Galvanizing	6.4 11.2,11.3	IS 2365 IS 1835	R	One	Every fifth coil	
6.5	Tensile Grade	6.5	IS 2365	R	Each rope	---	---
6	Other General Requirements as per IS 6594						
	Chemical composition of steel wire	4.1	IS 6594	S	One	Each heat	No further testing is required if accompanied with test certificate
	Mass of rope	6.5	IS 6594	R	Each rope	---	---
	Lay	6.7	IS 6594	R	Each rope	---	---

	Joints	6.8	IS 6594	R	Each rope	---	---
	Freedom from defects	7	IS 6594	R	Each rope		Adequate inspection to be carried out
	Individual wires before stranding	10.1	IS 6594				
	Diameter	10.1	IS 1835	R	Two	Every fifth coil	
	Tensile strength	12.2					
	Torsion test	12.3					
	Reverse bend test	12.4					
	Adhesion test	12.6					
	Wrapping test	12.5	IS 1835	R	Two	Every fifth coil	If required by purchaser
	Test on wire from completed wire	10.3	IS 6594				
	Tensile test	10.3.2	IS 6594	R	As per Cl. 10.3.1 of IS 6594	Each 25 ton or part thereof from finished rope	If required by purchaser
	Torsion test	10.3.3					
	Reverse bend test	10.3.4					
	Diameter of wire	10.3.6					

	Galvanizing	10.3.5					
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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.