

केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-3/16: IS 2266 : 2019

18 जुलाई 2019

विषय: IS 2266 : 2019 के अनुरूप एस आई टी के अनुपालन हेतु

यह उपरोक्त विषय के संदर्भ में है। अनुमोदित एस आई टी संलग्न है।

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

(राकेश कुमार)
वैज्ञानिक 'सी' (के मु वि-III)

प्रमुख (के मु वि-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 2266: 2019**

18 July 2019

Subject: SIT for IS 2266: 2019

This has reference to the subject mentioned above. The approved SIT is attached.

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

(Rakesh Kumar)
Sc. C (CMD III)

Head (CMD - III)

Circulated to: All ROs/BOs

Copy to: ITS for hosting on Intranet

**SCHEME OF INSPECTION AND TESTING
FOR CERTIFICATION OF STEEL WIRE ROPES FOR GENERAL ENGINEERING
PURPOSES ACCORDING TO IS 2266: 2019 (*Fifth 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 equipment.

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

3. LABELLING AND MARKING – As per Clause 12 of IS 2266: 2019.

4. CONTROL UNIT – All the steel wire ropes of the same nominal diameter, type and grade manufactured using the same set of strands and same type of core under identical condition of production 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.

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					Levels of Control		
Clause	Requirement	Test Methods		Test equipment requirement Required (R) or Sub-contracting permitted (S)	No. of Sample	Frequency	Remarks
		Clause	Reference				
4	Size and Tolerance	4	IS 2266 : 2019, Annex A of IS 6594	R	Each Rope	--	-
5	Minimum Breaking Force	5, Table 1 to 13	IS 2266 : 2019 Annex B of IS 6594	R	One	Each Control Unit	
6	<u>General Requirements</u>						
-	Material	4.1	IS 6594	S	One	Each heat	No testing is required if the material is ISI Marked or accompanied with a test certificate.
-	Length	6.4	IS 6594	R	Each length	-	-
-	Approximate Mass	Table 1 to Table 13 6.5	IS 2266 : 2019 Annex B of IS 6594	R	Each length	-	-

-	Lay of rope	6.7	IS 6594	R	Each rope	-	-
-	Joints	9 6.8	IS 2266:2019 IS 6594	R	Each rope	-	-
-	Freedom from defects	7	IS 6594	R	Each rope	-	-
-	Performing	8	IS 6594	R	One	Every loading length subject to a max. of 5 Tonne	-
-	Lubrication	9	IS 6594	R	Each rope	-	-
-	Tests on wire prior to Rope Manufacture	10.1	IS 6594	-			
-	a) Diameter	10.1	IS 1835	R	One	Each coil from which a construction and size is made	For individual wires one sample from one end of each coil wound round the bobbins for each size shall be tested for all the tests laid down. If a sample fails in any of the requirements, the particular coil shall be rejected
-	b) Tensile strength	12.2	IS 1835	R	One		
-	c) Torsion test	12.3	IS 1835	R	One		
-	d) Reverse bend test	12.4	IS 1835	R	One		
-	e) Wrapping test*	12.5	IS 1835	R	One		
-	f) Galvanizing test	11, 12.6	IS 1835	R	One		

	Tests on individual Wires*	10.3	IS 6594				
-	a) Tensile strength	10.3.2	IS 6594	R	Nine	Each coil from which a construction and size is made	
-	b) Torsion test	10.3.3	IS 6594	R	Nine		
-	c) Reverse bend test	10.3.4	IS 6594	R	Nine		
-	d) Galvanizing test	10.3.5	IS 6594	R	One		
-	e) Diameter of wire	10.3.6	IS 6594	R	One		
8	Core	8	IS 2266: 2019				
8.1	Fibre Core	All requirements of IS 1804		S	Two	One batch of fibre core received	No testing is required if the material is ISI Marked or accompanied with a test certificate.
8.2	Steel Core	All requirements as per IS 6594 as outlined in this SIT					

* To be done only when specified by purchaser.

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.