

## केन्द्रीय मुहर विभाग – III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-III/16: IS 204 (Part 1)

03 April 2019

विषय: अनुपालन हेतु एस आई टी

सभी शाखा कार्यालय से आग्रह है कि एस आई टी का अनुपालन 04 जून 2019 तक सुनिश्चित करें।

(एस डी राणे)  
वैज्ञानिक 'ई' (सी एम डी-III)

प्रमुख (सी एम डी-III)

सभी क्षेत्रीय/शाखा कार्यालय

आई टी एस विभाग — बीआईएस इंटरनेट पर अपलोड करने हेतु

## CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-III/16: IS 204 (Part 1)

03 April 2019

Subject: SIT for IS 204 (Part 1) : 1991 'Tower Bolts – Ferrous Metals'

This has reference to the subject mentioned above.

BOs may kindly ensure implementation of the SIT by 04 June 2019.

(S D Rane)  
Sc-E (CMD III)

Head (CMD - III)

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**SCHEME OF INSPECTION AND TESTING  
FOR TOWER BOLTS- FERROUS METALS  
ACCORDING TO IS 204 (PART 1) : 1991**

**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. LABELLING AND MARKING** – As per the requirements of IS 204 (Part 1) : 1991

**3.1 PACKING** – Packing of tower bolts shall be done as per clause 9 of IS 204 (Part 1) : 1991.

**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 Standards 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**

(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 Table 5	<b>Material</b>	<b>4.1</b>	<b>IS 204 (Part 1)</b>				
	Mild Steel Sheets	-	IS 1079, IS 10748 IS 513 (Part 1)	S	One	Further testing is not required , if material received with test certificate or ISI marked	
	Mild Steel bars	-	IS 2062	S	One		
	Cast Iron	-	IS 210	S	One		
5	Manufacture	5.1	IS 204 (Part 1)	-	Each tower bolt	-	
5.2	Particulars	5.2.1 to 5.2.4	IS 204 (Part 1)	-	Each tower bolt	-	
6	Dimensions	6.1 to 6.5	IS 204 (Part 1)	R	Five	Each type and size from every hour production	In case of failure of any sample, entire production during the hour shall be checked for dimensions and only those tower bolts, which are passing, shall be marked.
7	Finish (Visual)	7.1	IS 204 (Part 1)	-	Each tower bolt	-	-
	Finish (Plating/Coating)	7.1	IS 204 (Part 1) IS 1068, IS 1378 IS 1573	R	One	Daily	-

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 of BO Head.