

**BUREAU OF INDIAN STANDARDS**  
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**PGD 34 (18686) WC**  
**January 2022**

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*भारतीय मानक मसौदा*  
**हस्त औजार— सामान्य उपयोग के लिए कांटे (फोर्क) — विशिष्टि**  
*( IS 4506 का दूसरा पुनरीक्षण )*

*Draft Indian Standard*  
**HAND TOOLS — FORKS, GENERAL PURPOSE — SPECIFICATION**  
*( Second Revision of IS 4506 )*

ICS 25.140.30

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**Hand Tools Sectional Committee, PGD 34**

**FOREWORD**

This Indian Standard (Second Revision) will be adopted by the Bureau of Indian Standards after the draft is finalized by the Hand Tools Sectional Committee and had been approved by the Production and General Engineering Division Council (PGDC).

This standard was first published in 1968 and subsequently revised in 1989. In the first revision, assistance had been taken from BS 3388:1973 'Specification for Forks, shovels and spades' The second revision has been taken up to keep pace with the latest technological developments and international practices and align it with the latest version of BS 3388 published in 2004.

In this revision, the following changes have been made:

- a) Clause on references has been added;
- b) Material designations have been updated as per latest Indian Standard;

This standard lays down the requirements of forks used in road building, paving and coke loading, etc. Digging forks specified in this standard are not for use in plantations and estates and such forks have already been covered in IS 621: 1978 'Specification for forks for plantations and estates (*First Revision*)

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'.

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**HAND TOOLS — FORKS, GENERAL PURPOSE — SPECIFICATION**  
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## **1 SCOPE**

This draft standard covers the dimensions and other requirements of forks for general purposes.

## **2 REFERENCES**

The following standards contain provisions which through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards listed below

<i>IS No.</i>	<i>Title</i>
620 : 1985	Wooden tool handles, general requirements ( <i>Fourth Revision</i> )
621 : 1978	Forks for plantations and estates ( <i>First Revision</i> )
1501 (Part 1) : 2020	Metallic Materials — Vickers Hardness Test Part 1 Test Method ( <i>Fifth Revision</i> )
1570 (Part 2) : 1979	Schedules for wrought steels: Part 2 Carbon Steels (unalloyed steels) ( <i>First Revision</i> )
2500 (Part 1) : 2000	Sampling procedures for inspection by attributes: Part 1 sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection ( <i>Third Revision</i> )

## **3 NOMENCLATURE**

Nomenclature for forks shall be as shown in Fig. 1.

## **4 TYPES**

General purpose forks are classified into the following types:

- a) Digging Forks,
- b) Trenching Forks,
- c) Ballast Forks, and
- d) Coke Forks.

## **5 DIMENSIONS**

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- 5.1 The dimensions of digging forks shall be as given in Fig. 2.
- 5.2 The dimensions of trenching forks shall be as given in Fig. 3.
- 5.3 The dimensions of ballast forks shall be as given in Fig. 4.
- 5.4 The dimensions of coke forks shall be as given in Fig. 5.

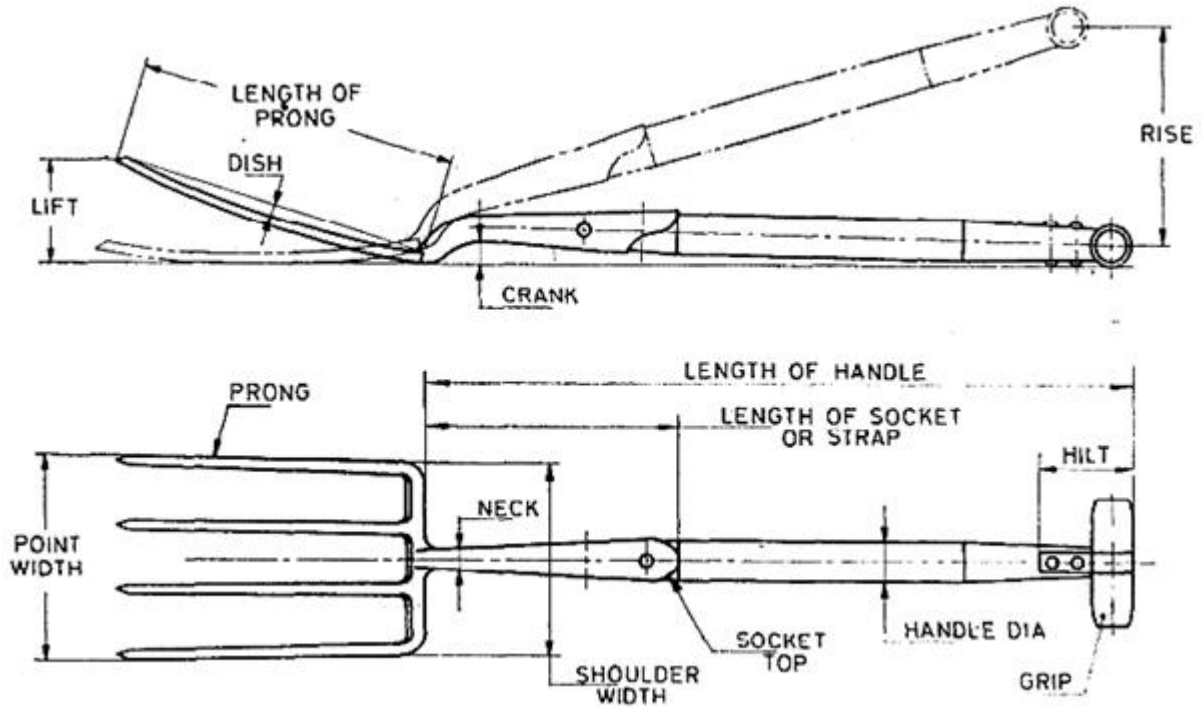
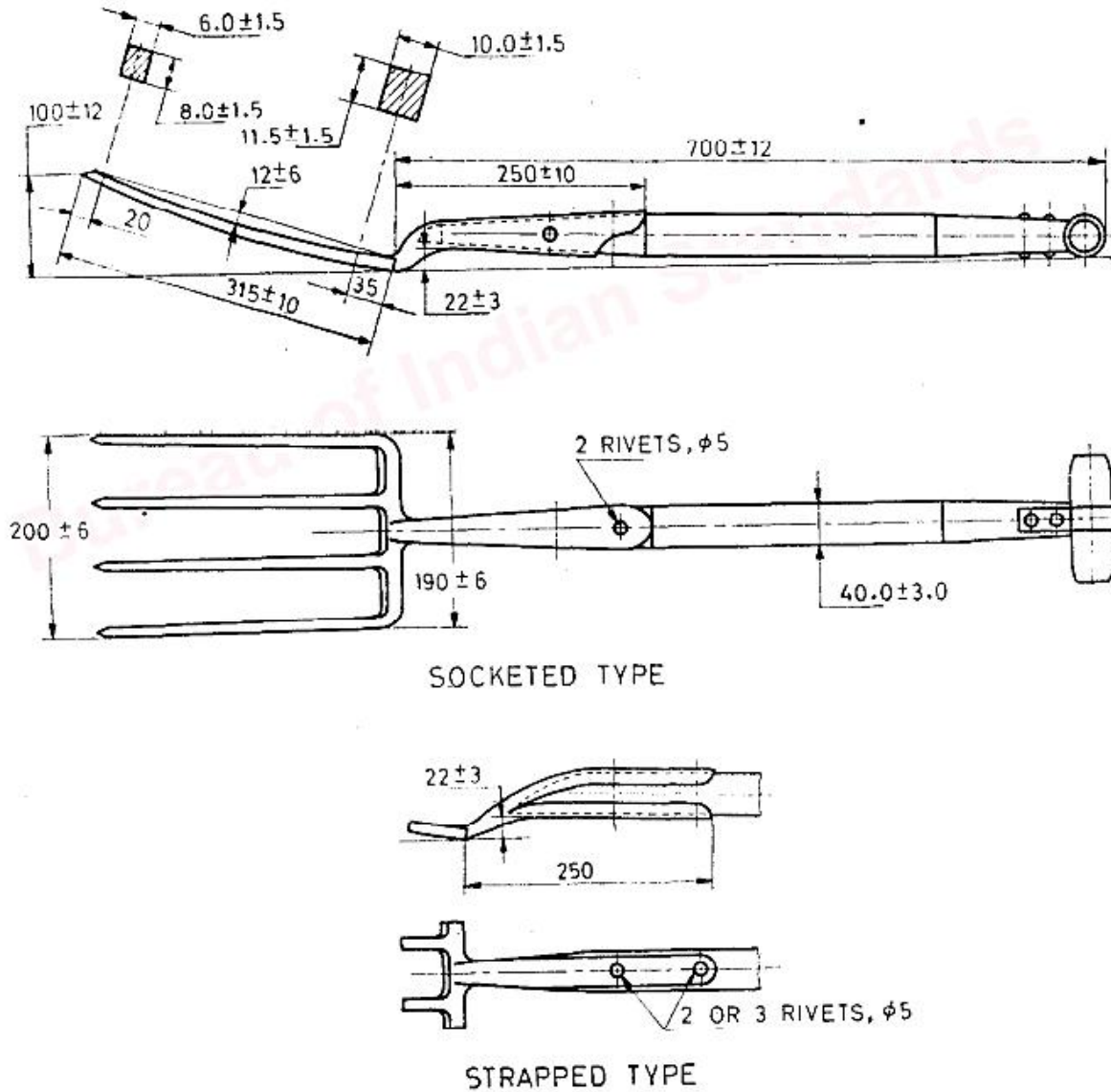


FIG. 1 NOMENCLATURE FOR FORKS

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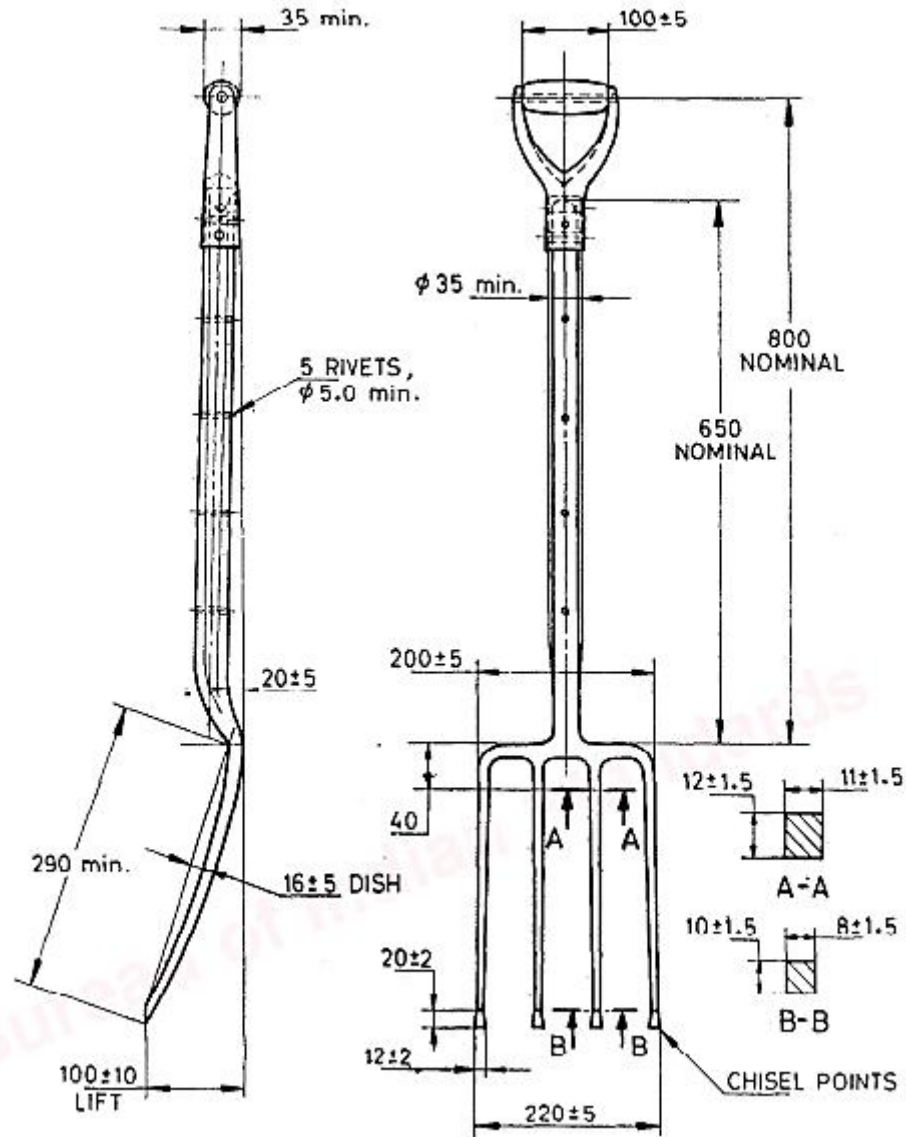
All dimensions in millimeters

FIG. 2 DIMENSIONS FOR DIGGING FORKS

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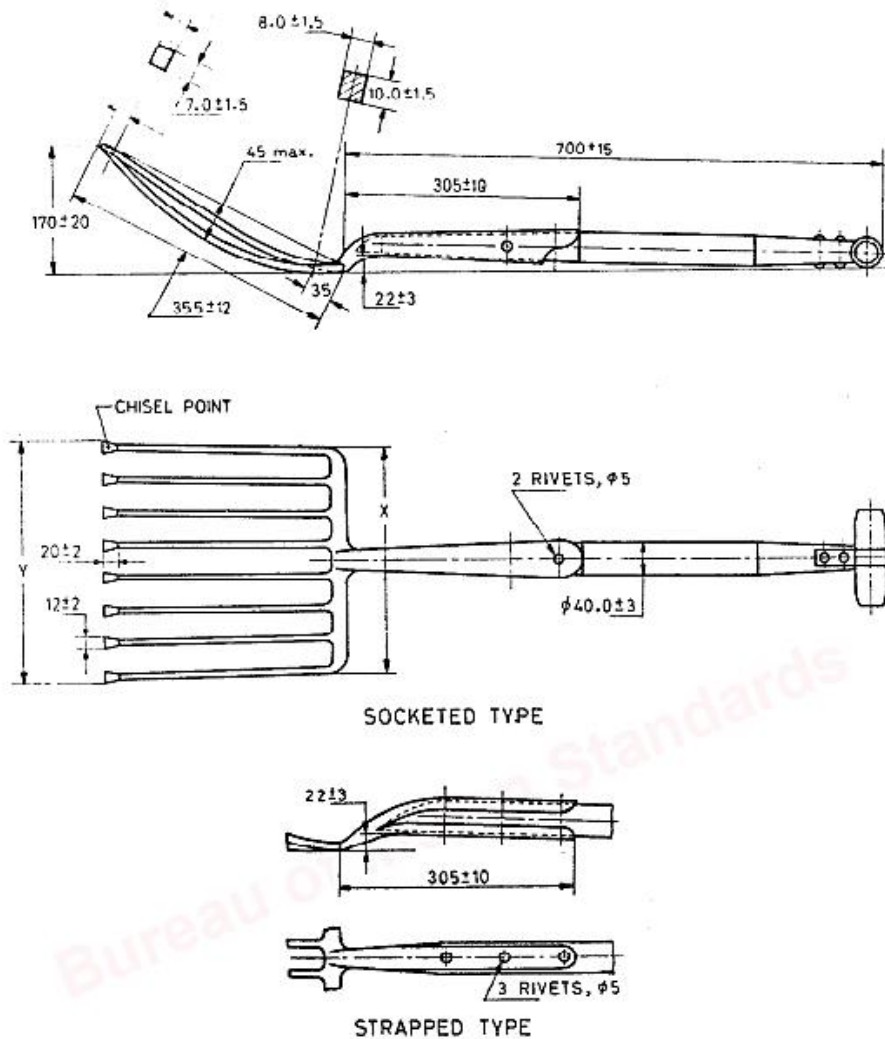
All dimensions in millimeters

FIG. 3 DIMENSIONS FOR TRENCHING FORK

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No. of Prongs	Dimension at Shoulder $X \pm 10$
8	290
10	380

**NOTES**

- 1 The point width Y shall not be less than the shoulder width X.
- 2 If not specifically required by the purchaser the prongs may be of rectangular or diamond cross-section.

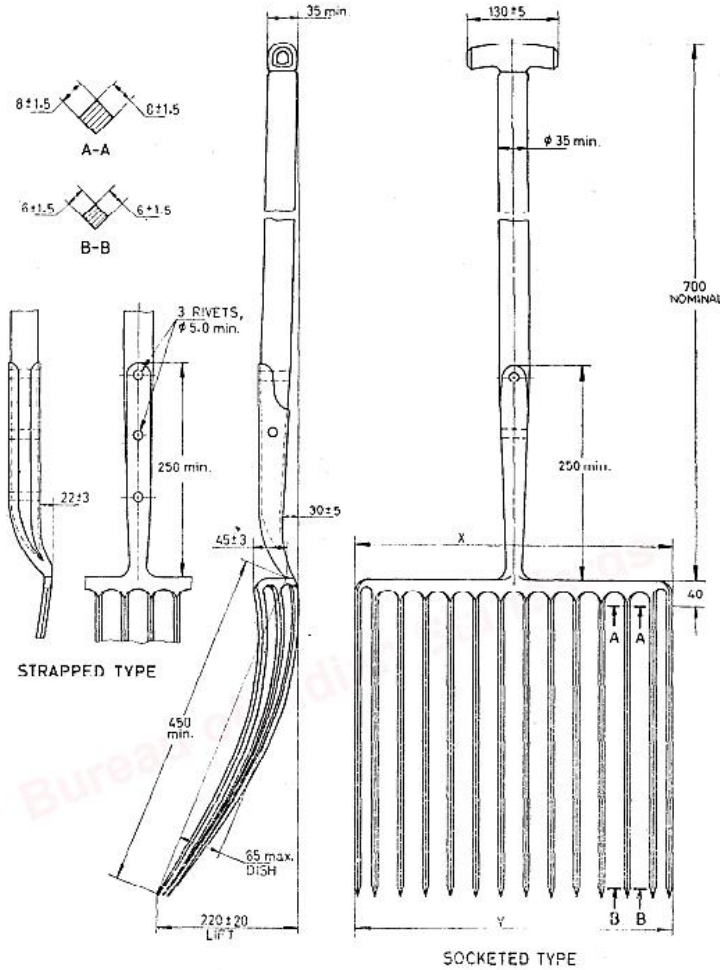
All dimensions in millimeters.

**FIG. 4 DIMENSIONS FOR BALLAST FORK**

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No. of Prongs	Dimension at Shoulder $X \pm 10$
8	290
10	380
12	425
14	480

**NOTES**

- 1 The point width Y shall not be less than the shoulder width X.
- 2 If not specifically required by the purchaser, the prong section may be rectangular or of diamond cross-section.

All dimensions in millimeters

**FIG. 5 DIMENSIONS FOR COKE FORK**

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## **6 MATERIAL**

Forks shall be manufactured from suitable steels to meet the requirements laid down in **8** and **12**.

### *Example*

Steel designation 40C8 or 55C8 conforming to IS 1570 (Part 2): 1979 with a maximum Sulphur and phosphorus content of 0.06 percent each may be used.

## **7 HANDLES**

**7.1** The handles, if made of wood shall conform to class 4 of IS 620: 1975 or as agreed to between the manufacturer and the purchaser.

**7.2** Handles of other materials if agreed upon between the manufacturer and purchaser may also be supplied provided the finished tool complies with the requirements laid down in **12**.

## **8 HARDNESS**

The prongs of the forks shall be suitably hardened and tempered, up to the length 50 mm less from the shoulder. The hardness shall be 380 HV minimum when determined in accordance with IS 1501 (Part 1).

## **9 MANUFACTURE**

**9.1** The prongs of forks shall be either forged integrally or welded to the strap. The straps or sockets may be either forged integrally or welded with the prongs.

**9.2** The sockets and straps shall be smooth and shall be positively and permanently secured to the handles.

**9.3** The sockets and straps shall be close fitted and finished flush with the handle. Rivets shall also be finished flush.

**9.4** Where handles of other material suitably joined to the socket are used in place of wooden handles, the socket may be shorter than specified provided the finished tool complies with the requirements laid down in **12**.



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## **10 FINISH**

The sockets or straps shall be polished bright or painted. The remaining areas of metal may be bright, self-colored or painted. Any exposed unpainted metal shall be given a suitable anticorrosive treatment.

## **11 SAMPLING**

**11.1** Unless otherwise agreed to between the purchaser and the supplier, the procedures given in IS 2500 (Part 1) : 2000 shall be followed for sampling inspection. The sampling plan, inspection level and acceptable quality level shall be as given in **11.2**, **11.3** and **11.4** respectively.

**11.2** For dimensions and workmanship, single sampling plan with inspection level IV and AQL of 2.5 percent as given in Tables 1 and 2 of IS 2500 (Part 1) : 2000 shall be followed.

**11.3** For bend and prong test, the single sampling plan with inspection level I and AQL 1.5 percent as given in Tables 1 and 2 of IS 2500 (Part 1) : 2000 shall be followed.

**11.4** For hardness test one sample shall be tested from each lot of 100 pieces or parts thereof. No sample should fail.

## **12 TESTS**

### **12.1 Bend Test**

The forks shall be clamped and a load of 40 kgf shall be gradually applied by suspension from the grip. The load shall be maintained in the position for one minute and then removed. A load of 55 kgf in case of digging forks and 65 kgf in case of other types of forks shall then be applied gradually and maintained for two minutes. On removal of this load the forks shall show no sign of damage or loosening of any component part, nor shall there be any evidence of permanent set in excess of 25 mm when measured at the extreme tip of the hilt, at the centre line of the handle (see Fig. 6).

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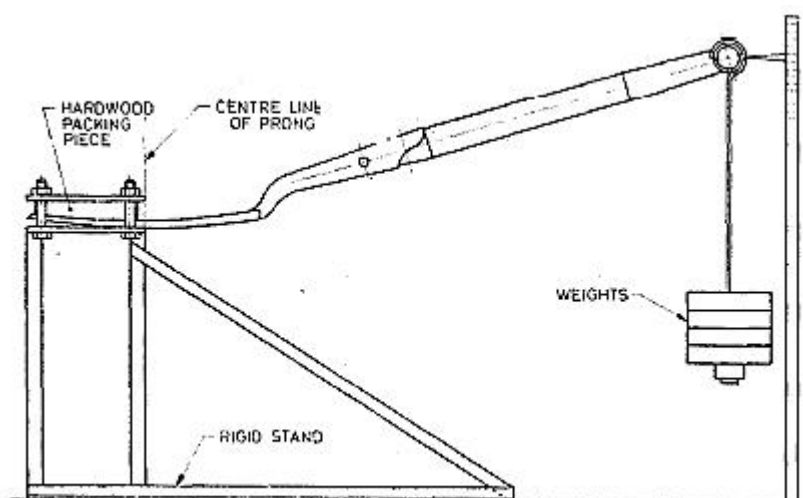


FIG. 6 BEND TEST OF FORKS

## 12.2 Prong Test

The prongs of the forks shall be tested by bringing tips of any two adjacent prongs together in case of digging forks and trenching forks, any four adjacent prongs in case of ballast forks and any five adjacent prongs in case of coke forks. The permanent set is noted. At the end of this test, the prongs shall show no sign of permanent set or damage.

## 13 PACKING

The forks shall be securely packed in suitable packing cases or crates of a size convenient for handling in transit, or bundled and secured suitably with wire or as may be specified by the purchaser. Each type of the fork shall be kept separate when packed and no package shall contain more than one variety of forks.

## 14 MARKING

14.1 The forks shall be clearly marked with the type, manufacturer's name or trade-mark/initials and year of manufacture.

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**14.2 BIS Certification Marking**

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product(s) may be marked with the Standard Mark.