**OSHO TOOLS PVT. LTD.**

Works : Vill. Jandiali, Chandigarh Road, LUDHIANA
Regd. Off. : 65, Sant Nagar, Civil Lines, LUDHIANA-141001
Phones : 91 161 2843638, 2843657, 98722 36361
www.oshotools.com
website : (OEM) sales@oshotools.com
e-mail : (Local) care@oshotools.com
CIN No. U27109PB1996PTC018279
GSTIN : 03AAAAC02003L1Z0

OPTL/2022-23/MKT/919

Dt.02/02/2023

**Bureau of Indian Standards
Northern Regional Office
Plot No. 4A, Sector 27-B, Madhya Marg
Chandighar-160019**

Respected Sir,

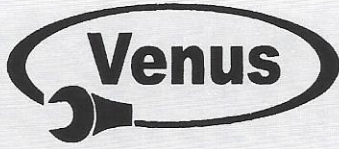
Refer to the draft of Pipe Wrenches- specification part-1 general purpose (second revision of IS 4003(part-1)). The following changes are suggested in the drafts standard.

Nominal Size	Minimum Capacity	Maximum Capacity Thickness	Jaw	Approximate Length of Movable Jaw	Approximate Length of Handle	Width off Nut N Min
L		D	T Min	l_1	l_2	
200	6	20	15	85	160	12
250	6	26	17	110	200	13
300	9	32	19	125	240	16
350	13	38	21	140	285	17
450	25	52	24	165	370	18
600	38	65	28	200	495	25
900	50	95	34	260	750	35
1200	65	130	40	330	1000	35

**the jaw thickness of 1200 should be 40 instead of 60.

2. The following changes the made in the material clause.

Component	Material
Handle and movable	40C8, 50C4, 55C8, 55C4, 60C4, 65C6 of IS 1570 (Part 2) ,31CrV ₃ or 40Cr (See Annex A) (**55C8 Added)
Frame	Malleable cast iron conforming to IS 14329 Specification for malleable iron castings, or SG Iron grade SG 500/7, 450/10 of IS 1865 (Reaffirmed 2005) or 20C8, 25C4, 15C4 or 15C8 of IS 1570 (Part 2) for HR sheet frames.
Spring	Steel to designation 50Cr4 of IS 1570 (Part 4)or any suitable spring steel grade from IS 1570.
Adjusting nut and hinge pin	Suitable carbon steel selected from IS 1570 (Part 2)

**OSHO TOOLS PVT. LTD.**

Works : Vill. Jandiali, Chandigarh Road, LUDHIANA
Regd. Off. : 65, Sant Nagar, Civil Lines, LUDHIANA-141001
Phones : 91 161 2843638, 2843657, 98722 36361
www.oshotools.com
website : (OEM) sales@oshotools.com
e-mail : (Local) care@oshotools.com
CIN No. U27109PB1996PTC018279
GSTIN : 03AAACO2003L1Z0

Annex -A**Chemical composition of steel grades**

Grade	C	Si	Mn	S(Max)	P(Max)	Cr	V
31CrV3	0.28-0.35	0.25-0.40	0.40-0.60	0.040	0.040	0.40-0.70	0.07-0.12
40Cr	0.37-0.44	0.17-0.37	0.50-0.80	0.040	0.040	0.8-1.10	Nil

Rest of standard is ok as per our knowledge and experience.

Thanking you,

For Osho Tools Pvt. Ltd.

Ashok Kumar Gupta
Chairman and Managing Director

