

केन्द्रीय मुहर विभाग-2

हमारा संदर्भ: के मू वी-2/16:12650

16 01 2019

विषय: संशोधित IS 12650:2018 की एस आई टी (Scheme of Inspection and Testing)

सक्षम अधिकारी द्वारा अनुमोदित संशोधित IS 12650:2018 की एस आई टी अनुपालन हेतु संलग्न है।

(आदित्य दास)
वैज्ञानिक सी

प्रमुख (के मू वी-2)

सभी क्षेत्रीय/शाखा कार्यालय/टी एक्स डी

प्रतिलिपि :

आई टी एस विभाग – बी आई एस इंटरनेट पर डालने हेतु

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 12650

16 01 2019

Subject: Scheme of Inspection and Testing (SIT) for Revised IS 12650:2018

Scheme of Inspection and Testing for Revised IS 12650:2018, duly approved by the CA, is enclosed for implementation.

(Aditya Das)
Scientist C

Head (CMD-2)

All ROs/BOs/TXD

Copy to:

ITSD - for hosting on BIS Intranet.

**SCHEME OF INSPECTION AND TESTING
FOR TEXTILES – JUTE BAGS FOR PACKING 50 KG FOODGRAINS
ACCORDING TO IS 12650:2018**

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 equipments.

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

3.PACKING, LABELLING AND MARKING– The Standard Mark as given in the Schedule of the licence document shall be stenciled with indelible ink on each bale provided always that all the bags packed in the bale on which this mark is applied conform to every requirement of the specification.

3.1 Labelling, Marking and packing shall be done as per the requirements of the standard. In addition, each bag shall be marked with the BIS license number and the following details shall be marked on each bale.

i) Licence No. (CM/L.....)

ii) BIS website details: For BIS Certification details for the jute bags visit www.bis.gov.in

4. CONTROL UNIT – For the purpose of this scheme, all the bags manufactured in a day or part thereof shall constitute a control unit.

NOTE: One of the sizes shall be tested for all the characteristics of the specification. For other sizes of bags, only length, width, mass of bag and stitching to be tested, if same fabric is used.

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.

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

6. SAMPLING FOR FLOOR INSPECTION: One bag shall be drawn every hour of production and tested for freedom from defects, dimensions, mass, moisture regain, ends and picks per dm and stick per dm. If the sample fails in any of the criteria, double the sample shall be tested and in case of any failure in second sample production of that duration shall be rejected. Suitable corrective action shall be taken to avoid recurrence of the failure and its records shall be kept. Five bags and two bags shall be drawn at an equal interval and tested and breaking strength and oil content respectively and in case of any failure the entire control unit shall be declared unfit for marking with BIS certification Marks. Moreover, cloth at each loom shall be checked for ends and Picks per dm and width at least twice daily. Bags from each stitching machine shall also be checked for stitch at least twice daily. Continuous checking for fabric defects shall be done at calendaring machine.

6.1 In respect of all other clauses of the specification and all stages of manufacture, the factory will maintain appropriate controls and checks to ensure that their product conforms to

the various requirements of the specification including contract mass of the bale, total number of bags in a bale, number of bags per bundle and corrected net mass of bale.

6.2 It is recommended that routine analysis of each consignment of raw material received in the factory shall be carried out and records maintained.

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. Any rejected material which is potentially resalable shall be deformed in such a manner that it cannot be used for any other purpose. A separate record shall be maintained giving information relating to all such rejections/defective/substandard material of the production not conforming to the requirements of the Specification and the method of its disposal. Such material shall in no case be stored together with that conforming to the Specification. The Standard Mark (if already applied) on rejected material should be defaced.

TABLE 1
LEVELS OF CONTROL

(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				
4.1	Manufacture	4.1	IS 12650	R	One	Each Control Unit	If the sample fails, two samples shall be tested. In case of any failure, the production shall be declared unfit for marking with BIS Certification Mark.
4.2	Seam		IS 9113	R	One per hour	-do-	
4.3	Safety Stitch		IS 9113	R	-do-	-do-	
4.4	Hemming at the mouth		IS 9113	R	-do-	-do-	
4.5	Freedom From Defects	Annex A	IS 12650	R	-do-	-do-	
5.1 Table1	i) Dimensions	8.3.2	IS 9113	R	-do-	-do-	
	ii) Ends/dm iii) Picks/dm	8.4.2	IS 9113	R	-do-	-do-	
	iv) Corrected mass per bag	8.5.2	IS 9113	R	-do-	-do-	
	v) Avg breaking strength of sacking	8.6.2	IS 9113	R	5 bags	-do-	
	vi) Avg side seam strength	8.7	IS 9113	R	5 bags	-do-	
	vii) Moisture regain	8.2	IS 9113	R	One	-do-	
	viii) Oil content on de-oiled material	8.8	IS 9113	R	2 bags	-do-	
5.3	Contract moisture regain	8.2	IS 9113	R	One	-do-	
5.2 Table 2	i) Total no of bags per bale	8.9	IS 9113	R	Each bale	-	
	ii) No of bags per bundle	-	-	R	Each bundle	-	
	iii) Contract mass of a bale	-	-	R	Each bale		

	iv) Corrected net mass of a bale	8.1	IS 9113		Each bale	-	
	v) No of joined bags per bundle of 25 bags	Visual	-	R	Each bundle	-	
5.4.2 Table 3	i) Non halogenated hydrocarbons	See Note 2		R	As agreed between purchaser and supplier		
	ii) a) Pesticides (Sum parameter) b) Banned Pesticides	See Note 2, 3		R	-do-		
	iii) pH of aqueous extract	See Note 2		R	-do-		
	iv) Coupled amines from azo-dyes (Sum parameters)	See Note 2, 4		R	-do-		

Note-1: 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.

Note-2: The methods of tests for ECO-parameters are being developed by BIS and Textiles Committee. Till the methods of tests are standardized, the manufacturer shall declare conformance taking into consideration the chemicals, auxiliaries and dyes used.

Note-3: The list of pesticides used on jute, banned restricted or withdrawn is listed in Annex B to IS 12650

Note-4: The list of coupled amines released from azodyes is listed in Annex C to IS 12650