

**केन्द्रीय मुहर विभाग-2**

हमारा संदर्भ: के मू वी-2/16: 1848 (Part 1)

25 02 2019

**विषय: संशोधित IS 1848 (Part 1):2018 की एस आई टी (Scheme of Inspection and Testing)**

1. यह उपरोक्त विषय व 07 01 2019 को जारी किए गए कार्यान्वयन दिशा निर्देशों के संदर्भ में है।
2. सक्षम अधिकारी द्वारा अनुमोदित संशोधित IS 1848 (Part 1):2018 की एस आई टी अनुपालन हेतु संलग्न है।

(आदित्य दास)  
वैज्ञानिक सी

**प्रमुख (के मू वी-2)**

सभी क्षेत्रीय/शाखा कार्यालय/सी एच डी

प्रतिलिपि :

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

**CENTRAL MARKS DEPARTMENT-2**

Our Ref: CMD-2/16: 1848 (Part 1)

25 02 2019

**Subject: Scheme of Inspection and Testing (SIT) for Revised IS 1848 (Part 1):2018**

1. This has reference to the above and further to the implementation guidelines issued on 07 01 2019
2. Scheme of Inspection and Testing for Revised IS 1848 (Part 1):2018, duly approved by the CA, is enclosed for implementation.

(Aditya Das)  
Scientist C

**Head (CMD-2)**

**All ROs/BOs/CHD**

Copy to:

**ITSD** - for hosting on BIS Intranet.

**SCHEME OF INSPECTION AND TESTING  
FOR CERTIFICATION OF  
WRITING AND PRINTING PAPERS  
Part 1: Account Book, Azure Lead, Bond, Cream Laid and  
Cream Wove/Printing coloured/Printing Offset, Printing Maplitho,  
Printing White Super Calendared and Typewriting Types  
ACCORDING TO IS 1848 (Part 1):2018  
(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 equipments.

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

**3. PACKING AND MARKING** -The Standard Mark as given in Schedule of the license shall be incorporated shall be stenciled or printed on each ream or reel of white printing paper or printed on the label applied to it in such a way that the mark is destroyed on opening the ream or reel; provided always that the paper in the ream or reel so marked conforms to every requirement of the specification,

3.1 Packing and Marking shall be done as per the provisions of IS1848 (Part 1):2018. In addition, details of BIS Licence No. CM/L- \_\_\_\_ and BIS website shall be marked as follows: "For details of BIS certification please visit [www.bis.gov.in](http://www.bis.gov.in)"

**4. CONTROL UNIT** – For the purpose of this scheme, 50 tonnes of production or part thereof made on a particular machine continuously in period not exceeding 48 hours, shall constitute a control unit

4.1 On the basis of test results, decision shall be taken regarding conformity of the control unit as a whole to the requirements of the specification.

**5. LEVELS OF CONTROL** - The tests, as indicated in 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. STORAGE** – Instruction for storage as given in the Indian Standard shall be complied.

**7. REJECTION** - 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 re-salable be sheared or cut or deformed in such a manner that it cannot be used for any other purpose. A separate record shall be maintained giving information on quantity and batch number/control unit number, as applicable, relating to all such rejections/defective/sub-standard 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.

**WRITING AND PRINTING PAPERS**  
**Part 1: Account Book, Azure Lead, Bond, Cream Laid and**  
**Cream Wove/Printing coloured/Printing Offset, Printing Maplitho,**  
**Printing White Super Calendared and Typewriting Types**  
**ACCORDING TO IS 1848 (Part 1):2018**

**SCHEME OF INSPECTION AND TESTING**

**TABLE 1: LEVELS OF CONTROL**

(1)				(2)	(3)			(4)
Test Details				Test equipment requirement R:required (or) S: Sub-contracting permitted	Levels of Control			Remarks
Clause	Requirements	Test Method			No. of Samples	Size	Frequency	
		Clause	Reference					
4.1	General	4.1	IS 1848:2007	R	One ream or reel	Each		
4.2	Substance	4.2	-do- , IS 1763:1961 and IS 1060 (Part 5/Sec 5)	R	Six	One control unit		

4.3	Thickness**	7	IS 1060 (Part 1)	R	-do-	-do-		** Specified tolerance shall be permitted on the nominal thickness, if specified by the purchaser.
4.4	Size	4	IS 1064	R	One ream or reel	Each		
4.5	pH	10	IS 1060 (Part 1)	R	Six	One control unit		
4.6,4.7 & Table	a) Tensile Index i) Cross Direction ii) Machine direction		IS 1060 (Part 5/Sec 6)	R	-do- -do-	-do- -do-		
	b) Brightness*		IS/ISO 2470 (Part 1)	R	-do-	-do-		* In the case of coloured paper, the colour should be an approximate match to the shade approved by the purchaser. The requirement for brightness shall not apply in case of coloured paper and printed paper. Applicable only for white paper.
	c) Opacity%		IS/ISO 2471	R	-do-	-do-		
	d) One minute Cobb test		IS 1060 (Part 5/Sec 4)	R	-do-	-do-		
	e) Double Fold i) Cross Direction ii) Machine direction	12.6 12.6	IS 1060 (Part 6/Sec 3)	R	One ream or reel -do-	One control unit -do-		

	f) Gloss percent	15	IS/ISO 8254 (Part 1)	R	-do-	-do-		Applicable only for white paper.
4.6,4.7 & Table 1	g) Wax pick	8	IS 1060 (Part 3)	R	One ream or reel	Once control unit		
	h) Smoothness (Bendtsen)	3	IS 9894	R	-do-	-do-		
	j) Tear Index i) Cross Direction ii) Machine Direction		IS 1060 (Part 6/Sec 1)	R	-do- -do-	-do- -do-		

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. 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.