केंद्रीय मुहर विभाग-2

संदर्भ : कें.मु.वि-/16:13428 **17 04 2018**

विषय: आई एस 13428:2005 "पैकैजबंद प्राकृतिक मिनरल जल " की संशोधित एस टी आई (डॉक: एस टी आई /13428/6, अप्रैल 2018) का कार्यान्वयन

शाखा कार्यालयों से प्राप्त अभ्यावेदनों के आधार पर सक्षम अधिकारी ने एस टी आई, डॉक: एस टी आई /13428/5, अगस्त 2011, में दिए ऐनायोनिक सरफेस एक्टिव रिएजंट के परीक्षण आवृत्ति को परिवर्तित करने की अनुमति प्रदान की है।
सक्षम अधिकारी द्वारा अनमोदित , संशोधित एसटीआई (डॉक: एस टी आई /13428/6, अप्रैल 2018) तत्काल प्रभाव से अनुपालन हेतु संलग्न है ।

सभी संबन्धित से अनुरोध है कि इसका कार्यान्वयन सुनिश्चित करें।

(आदित्य दास)
वैज्ञानिक सी (कें.मु.वि.-2)

प्रमुख, (कें.मु.वि.-2)
सभी शाखा कार्यालयों/एफएडी/प्रयोगशालाओं को परिचालित
प्रतिलिपि: ITS इंट्रानेट पर अपलोड करने के लिए

CENTRAL MARKS DEPARTMENT -2

Our Ref: CMD-2/16: 13428 **17 04 2018**

Subject: Implementation of Revised STI (Doc: STI/13428/6, April 2018) for IS 13428: 2005, "Packaged Natural Mineral Water".

Based on the representations received from BOs on the frequency of test of Anionic Surface Active Agents in the STI Doc: STI/13428/5 August 2011 for IS 13428: 2005, the Competent Authority has agreed to revise the test frequency of Anionic Surface Active Agents.

In this regard, please find enclosed revised STI (Doc: STI/13428/6, April 2018) for IS 13428: 2005, "Packaged Natural Mineral Water" which has been duly approved by Competent Authority, for immediate implementation.

This is being sent to all BOs for implementation.

(Aditya Das)
Sc. C (CMD-2)

Head, CMD-2
Circulated to: All BOs/FAD/Labs
Copy to: ITS for hosting on Intranet

DOC:STI/13428/6
April 2018

SCHEME OF TESTING AND INSPECTION FOR CERTIFICATION OF PACKAGED NATURAL MINERAL WATER ACCORDING TO IS 13428:2005 (Second Revision)- (Incorporating Amendment No. 1 to 5)

1. **Laboratory -** A laboratory shall be maintained which shall be suitably equipped and staffed to carry out the different tests in accordance with the methods given in the Indian standards.

2. **Test Records** – All records of analysis and tests shall be kept in suitable forms approved by the Bureau of Indian Standards (BIS).

2.1 Copies of any records that may be required by BIS shall be made available at any time on request.

2.2 **Quality Control -** It is recommended that, as far as possible, Statistical Quality Control (SQC) methods may be used for controlling the quality of the product as envisaged in this Scheme [*See* IS 397(Part 1), IS 397 (Part 2), and IS 397 (Part 3)].

2.2.1 All instruments/equipments are required to be brought under calibration control, as per frequency to be decided depending upon the usage.

2.3 In addition, effort should be made to gradually introduce a Quality Management System in accordance with IS/ISO 9001 or Food Safety Management System as per IS/ISO 22000.

3.0 **Standard Mark** – The Standard Mark(s), as given in column (1)of the First Schedule of the licence shall be clearly marked legibly and indelibly on the label of the bottle/container, as the case may be provided always that the material in each bottle/container to which this mark is applied conforms to every requirement of the specification. The dimension of standard mark shall be in accordance with preferred specified design.

4.0 **Packing –** The packaged natural mineral water shall be packed as per clause 3.2, clause 7 and Annex B of IS 13428:2005. The pouches and bottles/ containers shall be supplied in secondary packaging as agreed to between the purchaser and the supplier.

5.0 **Marking** – In addition to the Standard Mark, the following information shall be given on each Pouch/bottle/container or its label or directly printed on the bottle/container:

a) Name of the product (i.e. Natural Mineral Water);
b) Supplementary designations, if any (Ref. Cl. 3 of IS 13428)
c) Name and address of the processor;
d) Brand Name, if any;
e) Batch or Code Number;
f) Date of processing/packing;
g) Best for consumption up to – (date/month/year in capital letters); OR Best for consumption within…days or months from the date of processing/packing;
h) Net quantity;
i) Location and name of the source of natural mineral water;
j) Direction for storage; and
k) Any other marking required under the Standards of Weights and Measures (Packaged Commodities) Rules, 1977 and the Prevention of Food Adulteration Act, 1954 and the Rules framed there under.

5.1 Each secondary packing of pouches shall be marked with the following:

a) Indication of the source of manufacture of pouch;
b) Number of pouches of 200/250/300/500 ml.; and
c) Brand name, if any

5.2 Each secondary packing of bottles/containers shall be marked with the following:

a) Nominal capacity; and
b) Batch No. or Code No.

6.0 **Labelling Prohibitions -** The label on the bottles/ containers, pouches and/or the secondary packaging shall not contain claims which are prohibited as per clause 8.2 of IS 13428:2005.

7.0 **Levels of Control -** The Analysis and tests as indicated in Table 1 and at the levels of control specified therein, shall be carried out on the entire production of the natural mineral water and appropriate records and charts maintained in accordance with clause 2.0 above. All the production, which conforms to the Indian Standard and covered under the scope of licence shall be marked with the Standard Mark.

7.1 **Control Unit** – For the purpose of this scheme, the quantity of natural mineral water treated/processed and/or packed in one day shall constitute a control unit.

7.1.1 On the basis of tests and analysis results the decision regarding conformity or otherwise of a control unit to the given requirements shall be made.

7.2 In respect of all other clauses of the standard (other than those mentioned under levels of control – Table 1 of this scheme) the factory shall maintain appropriate controls and checks to ensure that their product conforms to the various requirements of the standard.

7.3 The material shall be held for 48 hours before dispatch so as to ensure that it conforms to all the requirements applicable for "Each Control Unit" except for yeast and mould which shall be reviewed for conformity on availability of their reports on completion of test duration of five days.

7.4 **Microbiological Requirements** – As and when a failure is noticed in any of the microbiological requirements in a control unit during in-process quality control, the control unit shall not be dispatched. Also the previous control units available in stock shall be released into the market only after rechecking. The manufacturer should reject or re-process the entire previous defective stock including the control unit found failing.

7.4.1 The licensee shall take immediate corrective actions, which would involve complete investigation of the reasons for contamination and non-conformity. The manufacturer should re-start marking and despatch only after the completion of satisfactory corrective actions and availability of satisfactory results of all microbiological tests as applicable for each control unit, for next five consecutive control units. The original frequency of despatch after 48 hours shall be restored, if all the five control units are found conforming to the microbiological requirements. The manufacturer shall keep complete records of such instances for review by BIS.

8.0 **Source Water** – The source water used in processing of Packaged Natural Mineral Water may be initially tested for Colour, Odour, Taste, Turbidity, pH, Total Dissolved

Solids, Microbiological & Chemical requirements including Toxic Elements & Pesticides Residues and Radioactive Residues.

Subsequently, its quality may be regularly assessed at least once in three months through in-house testing for Colour, Odour, Taste, and Turbidity, pH, Total Dissolved Solids and Microbiological requirements. In addition, any other requirements as considered necessary for process control, are to be tested where the incidence of their presence in higher levels has been detected during the previous tests.

8.1 The permitted treatment under cl 4 of IS 13428 shall only be carried out on condition that the mineral content of water is not modified. Whenever, the quality of processed mineral water is found to be not meeting the requirements of Table 1, 2, 3 & Clause 6.3 of IS 13428, the source water shall be checked again for such parameters in which failure is observed for deciding upon the necessary controls/change of source to be exercised for conformance of quality of processed mineral water to IS 13428.

8.2 In case non-conformity is observed for radioactive residues, the source of raw water shall be abandoned and water shall be recalled immediately.

8.3 As and when there is change in source water, it shall be intimated to BIS. The source water collected from the new source shall be tested in accordance with Clause 8.0 as above and the processed mineral water produced from such source water shall be tested for conformity to IS 13428. The reports of source water and the product water produced from the new source shall be submitted to BIS for approval before commissioning for regular production and marking.

8.4 **Plastic Bottles/Containers -** The plastic container used for packing the material shall conform to IS 15410:2003. The conformity assessment shall be carried in accordance with the levels of controls as given under Table 2.

8.4.1 In addition, the top lid for glasses/cups shall be of suitable peel able structure in accordance with Clause 4.2.1 of IS 15410:2003.

8.5 **Pouches** – The polyethylene film and pouches shall conform to IS 15609:2005. The conformity assessment shall be carried in accordance with the levels of controls as given under Table 3.

8.6 **Reused Containers –** Licensee shall ensure use of only such jars for packing the product water whose transparency continues to meet the requirements as per IS 15410 even after its repeated use. Jars which get soiled,

de-shaped and/or mutilated during the course of use and refilling shall not be used.

8.7 Water to be used for the purpose of cleaning etc. IS 4251:1967 may be followed as Good Manufacturing Practices.

9.0 **Hygienic Conditions –** The Natural Mineral Water shall be collected, processed, handled, packed and marketed in accordance with the hygienic practices given in Annex B of IS 13428:2005. Other clauses shall also be complied in day-to-day production and quality control activities. Schedules for each activity for this purpose shall be displayed prominently in the factory premises and records of compliance shall be maintained for BIS scrutiny. The hygienic conditions shall also be maintained at the site of source water. A checklist for good hygienic practices and food safety system for Packaged Natural Mineral Water processing units is given at the end of Annex B.

10. **Rejection -** A separate record shall be maintained giving information relating to the rejection of units of Packaged Natural Mineral Water, which do not conform to the specification, and the method of their disposal. Such material, if packed in containers, shall in no case be stored together with that conforming to the specification.

11. **Samples** - The licensee shall supply, free of charge, the sample or samples required in accordance with the Bureau of Indian Standards (Certification) Regulations from his factory or godowns. BIS shall pay for the samples taken by it from the open market.

12. **Replacement**- Whenever a complaint is received soon after the goods with the Standard Mark have been purchased and used, and if there is adequate evidence that the goods have not been misused, defective goods or their components shall be replaced or repaired free of cost by the licensee in case the complaint is proved to be genuine and the warranty period (where applicable) has

not expired. The final authority to judge conformity of the product to the Indian Standard shall be with BIS. The firm should have its own complaint investigation system as per IS/ISO 10002.

12.1 In the event of any damages caused by the goods bearing the Standard Mark, or claim being filed by the consumers against BIS Standard Mark and not "conforming to" the relevant Indian Standard, entire liability arising out of

such non conforming product shall be of licensee and BIS shall not in any way be responsible in such cases.

13. **Stop Marking** - The marking of the product shall be stopped under intimation to BIS, if at any time, there is some difficulty in maintaining the conformity of the product to the specification, or the testing equipment goes out of order. The marking may be resumed as soon as the defects are removed under intimation to BIS.

The marking of the product shall be stopped immediately if directed to do so by BIS for any reason. The marking may then be resumed only after permission by BIS. The information regarding resumption of marking shall also be sent to BIS.

14. **Production Data**– The licensee shall send to BIS, as per the enclosed Proforma to be authenticated by a Chartered Accountant or by the manufacturer by giving an affidavit/ undertaking, a statement of the quantity produced, marked and exported by him and the trade value thereof at the end of each operative year of the licence.

TABLE 1 .....

IS 13428:2005
PACKAGED NATURAL MINERAL WATER
Table 1 LEVELS OF CONTROL
(Clause 7 of the Scheme of Testing and Inspection)

TEST DETAILS				LEVELS OF CONTROL		REMARKS
Clause	**Requirement**	**Test Method**		**No. of Sample**	**Frequency**	
		Clause	**Reference**			
6.1	Microbiological Requirement					
6.1.1	Escherichia coli	-	IS 5887 (Part 1)* or IS 15185	One	Each Control Unit	
6.1.2	Coliform Bacteria	-	IS 5401 (Part 1)* or IS 15185	One	-do-	
6.1.3	Faecal Streptococci and Staphylococus aureus	-	IS 5887 (Part 2)*or IS 15186	One	Once a month**	
6.1.4	Sulphite Reducing anaerobes	-	Annex C IS 13428	One	Each Control Unit	
6.1.5	Pseudomonas aeruginosa	-	Annex D IS 13428	One	-do-	
6.1.6	Yeast and Mould count	-	IS 5403	One	-do-	
6..1.7	Salmonella and Shigella	-	IS 15187 and IS 5887 (Part 7)	One	Once a month**	
6.1.8	Vibrio Cholera and V parahaemolyticus	-	IS 5807 (Part 5)	One	-do-**	
6.2 and Table 1	i) Colour	-	IS 3025 (Part 4)	One	Every four hour	
-do-	ii) Odour	-	IS 3025 (Part 5)	One	-do-	

TEST DETAILS				LEVELS OF CONTROL		REMARKS
Clause	**Requirement**	**Test Method**		**No. of Sample**	**Frequency**	
		Clause	**Reference**			
6.2 and Table 1	iii) Taste	-	IS 3025 (Part 8)	One	Every four hour	
-do-	iv) Turbidity (NTU)	-	IS 3025 (Part 10)	One	-do-	
-do-	v) pH	-	IS 3025 (Part 11)	One	-do-	
-do-	vi) Total dissolved solids	-	IS 3025 (Part 16)	One	Each control unit	
6.2. and Table 2	i) Nitrate (as NO_3)	-	IS 3025 (Pt 34)	One	Once a week	
-do-	ii) Nitrite (as NO_2)	-	IS 3025 (Pt 34)	One	-do-	
-do-	iii) Sulphide (as H_2S)	-	IS 3025 (Pt 29)	One	-do-	
-do-	iv) Manganese (as Mn)	-	IS 3025 (Pt 59)* or IS 3025 (Pt-2)	One	-do-	
-do-	v) Copper (as Cu)	-	IS 3025 (Pt. 42)* or IS 3025 (Pt-2)	One	-do-	
-do-	vi) Zinc (as Zn)	-	IS 3025 (Pt.49)* or IS 3025 (Pt-2)	One	-do-	
-do-	vii) Fluoride (as F)		IS 3025 (Pt 60)	One	Once in six months	
-do-	viii) Barium (as Ba)		Annex F* of IS 13428 or IS 15302 or IS 3025 (Pt-2)	One	Once a week	
-do-	ix) Antimony (as Sb)		Annex G* of IS 13428 or IS 15303	One	Once a month	
-do-	x) Borate (as B)		Annex H* of IS 13428 or IS 3025 (Pt-2)	One	-do-	
-do-	xi) Chloride (as Cl)		IS 3025 (Pt 32)	One	Each control unit	
-do-	xii) Sulphate as (SO_4)		IS 3025 (Pt. 24)	One	-do-	

TEST DETAILS				LEVELS OF CONTROL		REMARKS
Clause	**Requirement**	**Test Method**		**No. of Sample**	**Frequency**	
		Clause	**Reference**			
6.2 & Table 2	xiii)Magnesium (as Mg)		IS 3025 (Pt. 46)* or IS 3025 (Pt-2)	One	Once a week	
-do-	xiv) Calcium (as Ca)		IS 3025 (Pt. 40)* or IS 3025 (Pt-2)	One	- do -	
-do-	xv) Sodium(as Na)		IS 3025 (Pt. 45)* or IS 3025 (Pt-2)	One	Once in six months	
-do-	xvi) Alkalinity as (HCO_3)		IS 3025 (Pt. 23)	One	Each control unit	
-do-	xvii) Selenium (as Se)		IS 3025 (Pt. 56) or IS 15303*	One	Once in six months	
-do-	xviii) Mineral Oil		6 of IS 3025 (Pt 39)	One	Once a month	May be got tested preferably from outside approved laboratory
-do-	xix) Phenolic compounds (as C_6H_5OH		6 of IS 3025 (Pt.43)	One	Once a month	
-do-	xx) Anionic surface active agent		Annex K of IS 13428	One	Once a month	
-do-	xxi) Silver	-	Annex J of IS 13428	One	Once in six months	
6.2 & Table 3	i) Arsenic (as As)	-	IS 3025 (Pt 37)	One	Once in six months	
-do-	ii) Cadmium (as Cd)	-	IS 3025 (Pt 41)	One	-do-	
-do-	iii) Cyanide (as CN)	-	2 of IS 3025 (Pt 27)	One	-do-	
-do-	iv) Chromium (as Cr)	-	Annex J* of IS 13428 or IS 3025 (Pt-2)	One	-do-	
-do-	v) Mercury (as Hg)	-	IS 3025 (Part 48)	One	-do-	
-do-	vi) Lead (as Pb)	-	IS 3025 (Part 47)	One	-do-	
-do-	vii) Nickel (as Ni)	-	Annex L of IS 13428	One	-do-	
-do-	viii) Polychlorinated biphenyle (PCB)	-	Annex M of IS 13428	One	-do-	
-do-	ix) Polynuclear Aromatic	-	APHA 6440 I	One	-do-	

	Hydrocarbons (PAH)					
6.2. & Table –4	i) Alpha emitters		IS 14194 (Pt.2)**	One	Once in two years	
	ii)Beta emitters	-	IS 14194(Pt 1)**	One	Once in two years	
6.3	Pesticides residues	-	Annex N of IS 13428***	One	***Initially once in six months for first operative period and thereafter once in a year.***	See Note 1

* In case of dispute, the method indicated by* shall be the reference method.
** Shall be got tested from outside laboratory
*** Shall be got tested from recognized laboratory using internationally established test method as specified in Annex N of IS 13428

Note 1 Operative period for the purpose of testing pesticide residues shall begin from 1 September 2005. For existing licensees, in case no failure is observed during the first operative period (sample tested every 6 months) the frequency of such test may be reduced to one year. In case any failure is observed, the frequency shall be increased to once in three months. The original frequency of once in 6 months may be restored only if two consecutive samples pass.

FORM 1

REPORT FOR FOUR HOURLY TESTINGS

Date of Production	Batch Number/control unit number	Quantity packed in each type of packing			Total quantity packed in kl	Time of production	Colour	Odour	Taste	Turbidity	pH	Remarks
		Type of packing	Capacity of pack	Quantity			Every four hour	Every four hour	Every four hour	Every four hour	Every Four hour	

FORM 2

REPORT FOR DAILY/ EACH CONTROL UNIT TESTING

Date of Production	Batch Number/ control unit number	Chloride	Sulphate	Alkalinity	TDS	E.coli	Coliform Bacteria	Sulphite reducing anaerobes	Pseudomonas Aeruginosa	Yeast & Mould	Remarks
1	2	3	4	5	6	7	8	9	10	11	12

FORM 3

REPORT FOR WEEKLY & MONTHLY TESTING

Date	Batch/ control unit no.	Barium	Copper	Mangan-ese	Nitrate	Nitrite	Zinc	Calcium	Sulphide	Magnesium	Anionic surface active agent	Antimony	Borate	Phenolic Compounds	Remarks
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16

FORM 4

FORMAT FOR TESTING FROM OUTSIDE LABORATORY

Month & Year	Batch No./DOM	Type of packing	Dates on which sample sent	Lab to which sample sent	Test report number & date	Results	Remarks

A) REPORT FOR MONTHLY TEST

1. **Faecal streptococci and S. Aureus, Salmonella and Shigella, V. cholera and V. parahaemolyticus**
2. **Mineral Oil, Antimony, Borate, Phenolic compounds, Anionic surface active agent**

B) REPORT FOR SIX MONTHLY TESTS

1. **Mercury, Cadmium, Arsenic, Cyanide, Lead, Chromium, Nickel, Fluoride, Selenium, Sodium, PCB, PAH**
2. **Silver**
3. **Pesticide Residues (Please see frequency in Table 1 and Note 1 also)**

C) REPORT FOR TWO YEARLY TESTS

1. **Radio Active Residues (Alpha and Beta Emitters)**

FORM 5

SOURCE WATER TESTING (3 MONTHLY TESTS)

Month & Year	Source of water	In-house testing (if done)	Outside testing (if done)			Record of in-house testing/outside TR	Results	Remarks
			Name of lab	sample sent on	TR No. & Date			

FORM 6

RECORD FOR PLASTIC CONTAINERS USED FOR PACKING NATURAL MINERAL WATER

Date of receipt	Type of packing material	Name of supplier	Quantity received	Whether ISI marked	Suppliers TC number & date	Details of outside testing/ suppliers TC		Results			Remarks
						Name of lab	Date of spending samples	Overall migration	Colour migration	Remaining parameters as per IS 15410	

FORM 7

RECORDS FOR SHELF LIFE ASSESSMENT (SEPARATE FOR EACH TYPE OF CONTAINER BEING USED)

Date on which sample kept	Batch No./DOM	Type of packing whose sample kept	Declared shelf life	Periodicity of testing (like Monthly)	Date of Testing	Requirements Tested	Results	Remarks

FORM 8

A) FORMAT FOR PE FILM

Date of Receipt of Rolls	Name of Supplier	Quantity Received (No. of Rolls)	Details of Test Certificate from supplier / O S Lab. With date	Description	Film Form	Winding of Film	Odour	Thickness	Width	Overall Migration	Tensile Strength	Elongation at Break	Dart Impact Resistance	Results	Remark
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(7)	(8)	(9)	(10)	(11)	(12)	(13)	(14)	(15)

B) FORMAT FOR POUCH TESTING

Date of Pouch Production	Time of production	Total quantity produced	Drop Test					Vibration Leakage Test	Stack Load Test	Ink Adhesion of Printed Pouches	Product Resistance of Printed Pouches	Water Potability Test	Results	Remarks
			Machine No.											
			1	2	3	4	Etc.							
(1)	(2)	(3)	(4)					(5)	(6)	(7)	(8)	(9)	(10)	(11)

Table 2
Guidelines on ensuring conformity of containers used for Packaged Natural Mineral Water

Type of container	Parameters	Options for mode of conformity	Frequency to be followed by licensee
a) Plastic Jars	i) Overall migration and colour migration as per Clause 7 of IS 13428: 2005 & ii) Conformity to IS 15410: 2003	i) 'ISI' marked ii) Test certificate of conformity by the manufacturer of jars iii) In-house Test Reports of licensee, if facilities exist iv) Outside laboratory Test Report of the samples got tested by licensee v) Combination of the above.	Each consignment of specific size/ material of jars received by the licensee All consignments of plastic material (raw/moulded) and of the same chemical composition shall be treated as one consignment as verified from the test certificate of original manufacturer.
b) Plastic Bottles, Glass/ cups	i) Overall migration and colour migration as per Clause 7 of IS 13428: 2005 & ii) Conformity to IS 15410:2003	i) 'ISI' marked ii) Test certificate of conformity by the manufacturer of plastic bottles, glasses/ cups iii) In-house Test Reports of licensee, if facilities exist iv) Outside laboratory Test Report of the samples got tested by licensee v) Combination of the above.	a) In case bottles, glasses/ cups are received from outside source options as given at i) to v) as given in Column 3 may be followed for any one consignment received during a period of **every three months** for each capacity, shape and material b) In case bottles, glasses/ cups are manufactured from preforms in licensee's own premises, licensee to ensure conformity of containers through in-house or outside lab testing or combination thereof, for each type/ capacity/ shape/ material once in a period of **three months.**
c) Plastic cap (closures) of containers	i) Overall migration and colour migration as per Clause 7 of IS 13428: 2005 & ii) Conformity to IS 15410:2003	i) Declaration/ certificate w.r.t. food grade quality, as permitted under IS 13428 ii) Test certificate from manufacturer for overall migration and colour migration.	**Once in a year** for each type/ shape/ size/ material of closure received from each manufacturer.
d) Foil (for sealing of plastic cups/ glasses)	i) Overall migration and colour migration as per Clause 7 of IS 13428: 2005& ii) Conformity to IS 15410:2003	Declaration/ certificate w.r.t. food grade quality of the material used for the plastic film.	**Once in a year** for each type of material received from each manufacturer.

Note: Licensee to keep records for all types of containers and closures received along with the corresponding test certificate/ reports and to be verified by BIS during periodic inspections for adequacy of the system being followed by licensee to control quality of packaging material received, accepted, rejected and method of disposal.

Table 3

Levels of control for Polyethylene Flexible Pouches for the packing of Natural Mineral Water and Packaged Drinking Water as per IS 15609:2005

Test details				Levels of Control		
Clause	Requirement	Test Method		No. of Samples	Lot size	Remarks
		Clause	Reference			
5	Material	5	IS 15609: 2005	One	Each consignment of Polyethylene film	i) Test certificate of conformity by the manufacturer of film OR ii) Outside laboratory Test Report of the samples got tested by licensee iii) Combination of the above.
6.1	Requirement for Polyethylene Film					
6.1.1	Description	6.1.1	IS 15609:2005	One	Each roll of polyethylene film	All rolls to be checked before using the same for making pouches. All such rolls Which do not conform to the requirement shall be rejected
6.1.2	Film Form	6.1.2	-do-	-do-	-do-	-do-
6.1.3	Winding of film	6.1.3	-do-	-do-	-do-	-do-
6.1.4	Odour	6.1.4	-do-	-do-	-do-	-do-
6.1.5	Thickness	6.1.5	-do-	-do-	-do-	-do-
6.1.6	Width	6.1.6	-do-	-do-	-do-	-do-
6.1.7	Overall Migration	6.1.7	-do-	-do-	Each consignment from one source	i) Test certificate of conformity by the manufacturer of film OR ii) In house test report, if facility exist with the licensee OR iii) Outside approved laboratory test report of the sample got tested by licensee OR iv) Combination of the above If the sample does not conform to the requirement, the consignment shall be rejected

Test details				Levels of Control		
Clause	Requirement	Test Method		No. of Samples	Lot size	Remarks
		Clause	Reference			
6.1.8	Tensile strength	6.1.8	-do-	-do-	-do-	-do-
6.1.9	Elongation of break	6.1.9	-do-	-do-	-do-	-do-
6.1.10	Dart impact resistance	6.1.10	-do-	-do-	-do-	-do-
7 Requirement for Flexible Pouches						
7.1	Vibration leakage test	Annex D	IS 15609:2005	-do-	One day production	If the sample does not confirm to the requirement the licensee shall follow the criteria for acceptance and retesting as per clause D-5 of IS 15609:2005. If it does not confirm then the same day production shall be rejected.
7.2	Water Potability Test	Annex E	-do-	-do-	Once in two months	Sample of each size shall be tested by rotation so that all the sizes shall be tested in one operative period.
7.3	Stack load Test	Annex F	-do-	-do-	One day production	If the sample does not confirm to the requirement the same day production shall be rejected.
7.4	Drop test	Annex G	-do-	-do-	Every hour for each machine	If the sample does not confirm to the requirement, the licensee shall follow the criteria for acceptance and retesting as per clause G-3 of IS 15609:2005. If it does not confirm then the same day production shall be rejected.
7.5	Ink Adhesion of Printed Pouches	Annex H	IS 15609:2005	-do-	One day production	If the sample does not confirm to the requirement the same day production shall be rejected.
7.6	Product resistance of printed Pouches	Annex J	-do-	One	-do-	-do-