



## केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-३/१६: भा.मा. 7285 (भाग 2)

०७ जुलाई २०२१

विषय: अनुपालन हेतु गाइडलाइन

सभी शाखा कार्यालयों से आग्रह है कि संलग्न गाइडलाइन का अनुपालन तत्काल प्रभाव से सुनिश्चित करें।

(राकेश कुमार)  
वैज्ञानिक 'डी' (के मु वि III)

प्रमुख (के मु वि III)

सभी क्षेत्रीय/शाखा कार्यालय

### CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-3/16: IS 7285 (Part 2)

07 July 2021

**Subject: Guidelines for implementation of Amendment No. 1 to IS 7285 (Part 2): 2017-Refillable Seamless Steel Gas Cylinders - Quenched and Tempered Steel Cylinders with Tensile Strength less than 1100 MPa (112 kgf/mm<sup>2</sup>)**

This has reference to the subject mentioned above.

BOs may kindly ensure implementation of the attached guidelines with immediate effect.

(Rakesh Kumar)  
Scientist D (CMD III)

Head (CMD - III)

Circulated to: All ROs/BOs

### CENTRAL MARKS DEPARTMENT III

Our Ref: CMD III/16: IS 7285 (Part 2)

07 July 2021

**Subject: Guidelines for implementation of Amendment No. 1 to IS 7285 (Part 2): 2017- Refillable Seamless Steel Gas Cylinders - Quenched and Tempered Steel Cylinders with Tensile Strength less than 1100 MPa (112 kgf/mm<sup>2</sup>)**

1. Amendment No. 1 to IS 7285 (Part 2): 2017 has been published. The last date for implementation of the revised Standard is 02 June 2023.
2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the amendment within **a week of issuance of these guidelines**.
3. The significant changes in the amendment as listed in the Table are given for the purpose of general guidance. BOs shall ensure that the product conforms to all the requirements, as applicable, as per the amendment.

<b>Clause</b>	<b>Requirement</b>
Page 2, Cl. 3.4	Definition of batch is modified to specify that steel of same heat number constitute a batch.
Page 2, Cl. 4	Symbols for minimum guaranteed tensile strength and actual value of tensile strength are changed in ISS.
Page 3, Cl. 5.1.4	New test introduced for cylinders made from continuously cast billet material
Table 1, Table 2	Chemical composition requirements are changed
Page 4, Cl. 6.2.3	Minimum guaranteed value of tensile strength is modified.
Page 4, Cl. 6.3.1	Formula for calculation of guaranteed minimum wall thickness of cylindrical shell is changed.
Page 10, Cl. 9.2.3	Requirements of Pressure cycling test is changed
Page 12, Cl. 10.1.4	New test introduced for cylinders made from continuously cast billet material
Page 15, Cl. 10.5.3	Requirements of Burst test is changed
Page 17, Cl. 11.4	Test procedure for Pressure cycling test for CNG/Bio-CNG cylinders is changed
Page 18, Cl. 14 (n)	Additional marking requirements for dissolved acetylene cylinders have been specified

4. Consequent upon issuance of the amendment, existing Product Manual has been revised as Doc: PM/IS 7285 (Part 2)/2/July 2021. In this revision of Product Manual, changes have been made in definition of batch in SIT and the type tests have been elaborated under Cl. 9.2. Further, sampling guidelines have been aligned with that applicable for IS 15490 and IS 15660.

5. The guidelines for implementation of the amendment is given below:

**A. LICENSEES:**

- (i) All Licensees shall implement the amendment by 02 June 2023. Any difficulty in implementation shall be brought to the notice of CMD III at the earliest but in any case at least 30 days before the last date of implementation. BOs shall ensure that no Licences are under operation Standard without Amendment after 02 June 2023. **The status of implementation of the amendment shall be confirmed by Head (BO) to CMD-III within two weeks of the last date of concurrent running.**
- (ii) Design wall thickness of existing varieties and other requirements as per the amendment shall be reviewed by the licensees in view of this Amendment. In case fresh prototype approval (as per Cl. 9 of IS 7285 (Part 2): 2017) is not required to be carried out, the in-house test results shall be submitted by the licensees for establishing conformity to the amendment. Verification of implementation of the amendment, wherever required, may be done during the next visit **which may normally be completed within six months of the last date of concurrent running.**
- (iii) In case fresh prototype approval (as per Cl. 9 of IS 7285 (Part 2): 2017) is required to be carried out, joint inspection shall be carried with PESO as per the prevailing guidelines.
- (iv) If the Licensee fails to complete all actions by 02 June 2023 it shall be dealt with as per the prevailing guidelines.

**B. APPLICATIONS FOR GRANT OF LICENCE:**

- (i) Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed without consideration of the Amendment. However, if the Applicant is desirous of considering the amendment, a declaration may be obtained from the Applicant to that effect and the Application may be processed accordingly. An undertaking shall also be obtained from such Applicants that if the sample fails in the new test requirements, Licence will not be granted without consideration of the amendment.
- (ii) Applications which are recorded henceforth may be processed with or without consideration of the amendment. Processing of Applications without consideration of the amendment shall be permitted only up to 02 June 2023 and for such cases Applicant shall give a declaration that they will implement the amendment by 02 June 2023.
- (iii) Beyond 02 June 2023 no Licence shall be granted without consideration of the amendment.

**C. CHANGE IN SCOPE OF LICENCE:**

- (i) For change in scope of licence, the relevant provisions as given above for Applicants shall apply.
  - (ii) However, processing of such applications for change in scope of licence without consideration of the amendment shall be permitted only upto the date of implementation of the amendment by the licensee or up to 02 June 2023 whichever is earlier.
6. The above guidelines come into force with immediate effect.

**(Rakesh Kumar)**  
**Sc D**

Head (CMD III)  
**DDG (Certification)**