

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:617

11 07 2024

विषय: संशोधित IS 617:2024 के अनुपालन के दिशा निर्देश

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित दिशानिर्देश अनुपालन हेतु संलग्न है।

सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की दिशानिर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

**शिवम आहूजा
वैज्ञानिक सी**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:617

11 07 2024

Subject: Guidelines for implementation of Revised IS 617:2024 (Aluminium and Aluminium Alloys Ingots for Remelting and Castings for General Engineering Purposes)

This has reference to the subject mentioned above.

The Competent Authority has approved the enclosed Guidelines for implementation.

All ROs/BOs are requested to ensure the implementation of the above Guidelines with immediate effect.

**(Shivam Ahuja)
Scientist C**

Head (CMD-2)

All ROs/BOs/Labs/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 617

11 07 2024

Subject: Guidelines for implementation of Revised IS 617:2024 (Aluminium and Aluminium Alloys Ingots for Remelting and Castings for General Engineering Purposes)

1. This has reference to the above.
2. IS 617:1992 has been revised as IS 617:2024 and the date of withdrawal of IS 617:1992 is **10th November 2024**.
3. Presently, 160 licences (all domestic) are operative for IS 617:1992.
4. The significant changes in the revised Standard 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 revised Standard.

Clause(s) as per IS 617:2024	Change
Title	The title of the standard has been revised to “Aluminum and Aluminum Alloys Ingots for Remelting and Castings for General Engineering Purposes”
5 Designation	A new clause specifying Alloy Designation, Temper Designations, Casting Process and Product Designation has been added
Annex B	Writing rules for the designation and chemical composition of alloyed Aluminium ingots for remelting and castings have been specified at Annex B
5 Chemical Composition	Requirements of samples of ingots/ castings to be tested by emission spectrometry have been specified 63 new grades of Aluminum and Aluminum alloys have been added and their chemical composition have been specified at Table 1.
7 Mechanical Properties (Applicable for Only Castings)	Clause has been modified to specify that for processes and tempers other than the commonly used methods of castings and tempers (as specified under Tables 2, 3 & 4), mechanical properties shall be agreed between the manufacturer and purchaser. Test Method for Tensile test has been updated to IS 1608 (Part 1).
7.3 Test Pieces	A new clause on Test Pieces has been added specifying conditions for Separately Cast Test Bars for Sand Cast, Chill Cast and Investment Cast pieces
Annex C	Mechanical Properties of some of the Pressure Cast Test bars have been specified at Table 5 of Annex C for Guidance Purposes
7.4 Hardness	Clause has been modified to state that Hardness testing shall be carried out as per IS 1500 (Part 1) on porosity free areas of castings

	or on the portion of a broken test piece which has not been stressed (not applicable for ingots) It has also been specified that for other processes and tempers (other than the commonly used methods of castings and tempers for which Hardness values have been specified), the hardness shall be as agreed between manufacturer and purchaser.
---	Clause 8 (Condition) and Clause 9 (Tolerances on Dimensions of Castings) have been omitted
9 Sampling	Sampling requirements for Chemical Composition, Tensile test for castings have been modified
10 Pressure Test (Optional Test)	Requirements of pressure test have been specified that "All castings shall be leak proof"
12 Packaging	A new clause on Packaging has been added specifying packaging methods. Reference to IS 10259 for packaging methods has also been added
13 Marking	Clause has been modified to add reference to IS 10259 for marking and labelling methods

5. Consequent upon the issuance of the revised Standard, the existing product manual of IS 617 has been revised which is being circulated separately.
6. The guidelines for implementation of the revised Standard is given below:

A. **LICENSEES:**

a) Switchover of existing Licensees of IS 617:1994 to revised IS 617:2024

i) Consequent to revision of IS 617:1994 to IS 617:2024, 63 new grades of Aluminum and Aluminum Alloys have been added and the existing grades have been re-designated. Further, Mechanical Properties (for Castings) for 4 Casting Processes (Sand Cast, Chill or Permanent Mould, Pressure Die Casting and Investment Casting) have been specified separately for these grades in different Temper Conditions (M, O, T1, T4, T5, T6, T64, T7).

However, it has also been specified that For other processes and tempers (other than those specified) mechanical properties shall be agreed between manufacturer and purchaser.

ii) For switchover, the licensees shall be required to do the following tasks:

a) Re-designate the Alloys(Grades), covered under existing scope of licence as per IS 617:1994, as per Table 1 of IS 617:2024 and declare the Alloys (grades) manufactured through each Casting Process (as per manufacturing capability). Accordingly, prepare a revised scope

of licence (equivalent to the existing scope) as per the Scope specified in the Product Manual of IS 617:2024.

b) Submit the revised scope of licence along with in-house/independent test reports of the existing Alloy Grades/Tempers etc. as per the Grouping Guidelines specified in the Product Manual of IS 617:2024 to the concerned BO.

iii) On receipt of the above evidences of conformity, BOs shall issue endorsement for switchover of the licence to IS 617:2024 along with revised scope of licence. BOs shall ensure that the revised scope of licence shall not be granted beyond the Alloys/Tempers/Casting Processes etc.covered/verified at the time of grant of licence as per IS 617:1994.

iv) Inclusion of new Alloys/Tempers/Casting Processes etc. shall be dealt as per the existing Guidelines for Change in Scope of Licence (CSoL).

v) All Licensees shall implement the revised Standard by **10th November 2024**. Any difficulty in implementation shall be brought to the notice of CMD 2 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 as per old Standard after **10th November 2024**. **The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.**

vi) BOs shall plan an early surveillance visit for verification of the implementation of the revised standard preferably within 30 days of switchover by the licensee.

B. APPLICATIONS FOR GRANT OF LICENCE:

1. Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed as per the old Standard. However, if the Applicant is desirous of considering the Application as per the revised Standard, 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 new test requirements, Licence will not be granted by BIS as per the old version.
2. Applications which are recorded henceforth may be processed as per the old Standard or the revised Standard. Processing of Applications as per the old Standard shall be permitted only upto **09th November 2024** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **10th October 2024**.
3. Beyond **10th November 2024** no Licence shall be granted as per the old Standard.

C. CHANGE IN SCOPE OF LICENCE:

1. For change in scope of licence, the relevant provisions as given above for Applicants shall apply.
2. However, processing of such applications for change in scope of licence as per the old Standard shall be permitted only up to the date of implementation of the revised Standard or up to **10th November 2024** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja
Sc. C

Head (CMD-2)
DDG (Certification)
ROs/BOs