



केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- के. मु. वि.-3/16: भा.मा. 8737(वाल्वस) एवं भा.मा. 9798 (रेगुलेटर्स) 10 दिसंबर 2021

विषय: भा.मा. 8737 एवं भा.मा. 9798 के अनुरूप लाट निरीक्षण के लिए दिशानिर्देश

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

यह इस मामले में मौजूदा दिशानिर्देशों का स्थान लेता है। सभी शाखा कार्यालय उपरोक्त दिशानिर्देश अपने लाइसेंसियों को तुरंत सूचित 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 8737 (Valves) & 9798 (Regulators)

10 Dec 2021

Subject: Guidelines for Lot inspections of Valve Fittings & Low Pressure Regulators for use with LPG Cylinders

This has reference to the subject mentioned above. Guidelines on the subject are attached for implementation with immediate effect.

This supersedes the existing guidelines in this matter.

All BOs are advised to inform the above guidelines to the licensees under their jurisdiction immediately.

The following two agencies have been approved by competent authority for carrying out lot inspections and their services are to be utilized:

- TUV India Pvt. Ltd.
- Bureau Veritas (India) Private Limited

These agencies have also been approved for carrying out lot inspections of LPG Cylinders as per IS 3196- 1 and IS 13258.

(Rakesh Kumar)
Scientist D (CMD III)

Head (CMD - III)

Circulated to: All ROs/BOs

CENTRAL MARKS DEPARTMENT-III

Our ref: CMD-III/16: IS 8737 (valves) & 9798 (regulators)

10 Dec 2021

Subject: Guidelines for Lot inspections of Valve Fittings & Low Pressure Regulators for use with LPG Cylinders

This has reference to lot inspections of Valve Fittings & Low Pressure Regulators for use with LPG cylinders as per IS 8737 & IS 9798 respectively, being conducted by BIS. After lot inspections, the batches are released with a test certificate.

2. In this regard, it has now been decided that BIS would take support of BIS empanelled agencies for lot inspections also. Based on the reports of lot inspections submitted by them, BIS will be issuing the test certificates for applicable batches of Valves and Regulators.
3. Standard operating Procedure (SOP) to be followed in this regard is attached for implementation. BIS Certification officer shall verify that all the requirements laid down in SOP have been complied with and the results of batches enclosed are conforming to the requirements of Indian Standard and issue the test certificates.
4. Technical auditor of the empanelled agency (TA) shall carry out lot inspection on behalf of BIS and submit the inspection report in the prescribed format as enclosed with the SOP. After the lot inspection, licensee will prepare the test certificate in the prescribed format and will submit that for verification by TA. BIS Certification officer shall examine the lot inspection report submitted along with the test certificate prepared by the licensee and based on the examination of the same and the conclusion that the lot is in conformity with the requirements of relevant Indian standards and SIT, shall issue the test certificate. Test certificates shall be issued by BIS Certification Officer latest by next day of the inspection.
5. Provisions for executing the above work flow in manakonline is being developed by ITSD/CDAC and is expected to become live shortly. However, till the time these provisions are made live, report of lot inspections and test certificates will be submitted by agencies in hard copy and test certificates will continue to be issued by BIS Certification Officer in hard copy in the prescribed formats.
6. For the initial minimum 2 visits, the TA of empaneled agency will accompany BIS Officer during which the TA are expected to gain adequate on-job training and competency. After this, BIS Certification Officer will accompany TA for first visit during which inspection will be done by TA and witnessed by BIS Certification Officer to see whether SOP is complied with. Report of competency of TA should be submitted by BIS Officer to the Head (BO) with recommendation on the need of any further shadow inspection. Head (BO) may allocate more such shadow inspections till the time TA is declared competent. Induction of any new TA will follow the same procedure as above. It is to be noted that only lot inspection charges are to be levied from the licensee and no additional man-days charges are to be levied for such visits.
7. The bills raised by empanelled agency for lot inspections on monthly basis will be processed centrally by CSMD for each "accepted" lot inspection. Till the time requisite provision in manakonline is being made, CSMD shall process the bills based on verification from BOs. Head (BO) shall provide necessary support and information to CSMD in this regard.

8. At present, lot inspections by agencies is being operationalized only in GZBO, FRBO, NOBO and HYBO which will be extended to other BOs in due course. BOs other than the above 4 BOs (i.e. GZBO, FRBO, NOBO and HYBO) will also follow the same SOP, except that the lot inspections would be carried out by BIS Certification Officers.

9. This issues with the approval of DG.

(Rakesh Kumar)
Scientist D

H(CMD-III)

DDG (Certification)

Circulated to : All ROs/BOs

Standard Operating Procedure (SoP) for
Lot Inspection of Valve Fittings for use with LPG Cylinders for more than 5 litre
Water Capacity as per IS 8737

Sl. No.	Activity	Responsibility
1.	REQUEST FOR LOT INSPECTION	
a)	<ul style="list-style-type: none"> • Request for Lot Inspection shall be made through Manakonline Portal preferably one week in advance or latest 3 days before the day of lot inspection (<i>See the guidelines on request, planning of inspections, Sampling and fee related matters attached as Annexure- A</i>). • It is to be ensured that the offered batches are complete in all respects and have undergone all the testing as per Indian Standard and SIT and, before the inspection. • Lot Inspection Charges shall be paid through Manakonline Portal. (<i>See the guidelines on request, planning of inspections and fee related matters attached as Annexure- A</i>) 	Licensee
2.	ALLOTMENT OF INSPECTION	
a)	<ul style="list-style-type: none"> • Allotment of Lot Inspection to agency and BIS Certification Officer shall be made through Manakonline • Ensure rotation of agency and certification Officer • Monitoring to ensure that rotation among TAs is being followed by the agency to whom inspection has been assigned (<i>See Annexure- A for details</i>) 	Head (BO)
b)	<ul style="list-style-type: none"> • Assigning the lot inspection by agency in-charge to its TA ensuring rotation of TAs (<i>See Annexure- A attached for details</i>). It shall be ensured by the agency that TA is assigned by them on the same day or latest, by next day. 	Agency in-charge
3.	VERIFICATION OF BATCHES AND LOT INSPECTION	
a)	<ul style="list-style-type: none"> • The authenticity of the information provided by the Licensee regarding completion of various stages w.r.t the batches offered for lot inspection shall be ensured at the time of inspection. • During the visit for Lot Inspection, ongoing activities at various stages shall be verified to ensure that all manufacturing and testing 	CO /TA

	<p>processes for the batches offered by the licensee have been completed.</p> <ul style="list-style-type: none"> • Check and sign the inspection and testing records of various stages for the batches taken up for lot inspection 	CO/TA
b)	Ensure that the valve fittings offered for lot inspection are stored/stacked batch wise without mix up	Licensee
c)	<ul style="list-style-type: none"> • Mixing up of batches shall not be permitted. Verify whether the Valve fittings of different batches are stored as distinctly identifiable and not mixed up. • Perform physical verification of the offered batches w.r.t the Batch Numbers, Size (Quantity), etc. • Verify that the material from which the valves have been manufactured are conforming to the requirements of IS 8737 (Check the chemical composition of the material in the test certificate received for each batch) • Verify that the samples have been tested for mechanical properties (Tensile strength, % elongation, Izod impact strength) by the manufacturer as per the sampling plan and the results are conforming to IS 8737. Attach scanned copy of testing records of each tested sample with the lot inspection report (<i>Annexure-B</i>). 	CO /TA
d)	Carry out lot inspection of verified batches as per sampling plan given in <i>Annexure A</i>	CO /TA
d)	<i>It is expected that minimum of 8 hours are spent in the factory by TA during the lot inspection</i>	TA
e)	Preparation of test certificate in prescribed format (<i>attached as Annexure- C</i>)	Licensee
4.	SUBMISSION OF LOT INPECTION REPORT	
a)	<ul style="list-style-type: none"> • Verification of details in test certificate • Submit the inspection report along with the test certificate in the prescribed format (<i>Annexure- B</i>) during the lot inspection at the factory premises for consideration by BIS. 	CO/ TA
b)	<ul style="list-style-type: none"> • All rejections (process rejections/samples in destructive testing etc.) shall be deshaped in the presence of CO/TA and entered in the deshaping record. • The deshaping records shall be duly signed. 	Licensee/ CO/TA
c)	Inspection report is to be signed by licensee also and a copy of the same may be retained by the licensee	Licensee
5.	ISSUANCE OF TEST CERTIFICATE BY BIS CERTIFICATION OFFICER	
a)	Examination of the inspection report submitted by TA and Accept/Seek Clarification/Reject inspection report	CO

b)	Provide clarification to BIS Certification Officer, when any clarification is sought	TA
c)	Provide clarification to TA, if required	Licensee
d)	Issue test certificate (s)	CO
6.	QUALITY ASSURANCE MEASURES	
a)	It shall be ensured by Head (BO) that BIS Certification officer also is deputed periodically to conduct lot inspection of every cylinder unit preferably once in every 30 days or as decided by Head (BO) to ensure adequate supervision.	Head (BO)
b)	Head (BO) may also occasionally depute BIS officer on the day of lot inspection to check the working and performance of TA during the lot inspection	
c)	Head (BO) should proactively interact with the management of licensee to have a periodic feedback about the TAs of the agencies	

Abbreviations: CO- BIS Certification officer

TA- Technical auditor of BIS empaneled agency

Annexure- A
Guidelines on Request, Planning of inspections, Sampling and fee related matters
for lot inspection of Valve Fittings as per IS 8737

1. A lot of forged valve bodies of the same type and size forged in a day/different days from the material of the same consignment/ supplier under similar process of production shall constitute a control unit.
2. Numbers of valves shall be selected by BIS officer as per sampling plan given below. The selected valves shall be tested for outside threads on valves inlet, Pneumatic Test specified in clause 8.3 of IS 8737 and all other dimensions shall be checked as per approved drawings for particular collar diameter valve. The valves shall also be tested for control dimensions (See lot inspection report- Annexure). The sampling plan will be as under:

Lot Size	No. of valves to be tested	Remarks
Upto 500 valves	20	In case of any failure observed the lot shall be reoffered by the manufacturer after complete recheck. Any repeat failure shall result in the rejection of the whole lot. Lot can be reoffered only once. All rejected valves shall be scrapped.
501-1000	32	
1001-3000	50	
3001-10000	80	
10001-25000	125	
25001 and above	125 + (2 nos.per each additional thousand or part thereof)	

Note: In case during inspection by BIS officer valves are found with defects like burrs on valves inlet/outlet connection etc. which may likely to affect the result of inspection, the firm may be advised to segregate/rectify such valves and reoffer for inspection.

3. Licensees will submit the lot inspection request along with details of batches, preferably a week in advance or latest 3 days before the proposed day of lot inspection. Request from licensee for change in date of inspection with proper reason may be considered by Head (BO) by recording the justification.
4. For proper inspection/sampling, it should be ensured that licensee has got adequate storage/ stacking space within the factory premises so that valve fittings are offered batch-wise to the officer for inspection/ clearance. Mixing of batches shall not take place and each batch should be distinctly identifiable to facilitate its proper inspection & sampling.
5. Normally not more than two visits per licence may be planned every week. However, more visits may also be permitted by Head (BO) depending upon the need and availability of manpower. For lot inspections, licensee shall submit ₹ 10,000/- + GST per man day as special inspection charges. Licensee shall also make arrangement for travel and stay of the BIS Certification officer, as applicable. Otherwise, the payment towards travel and stay (for boarding and lodging per night stay) on actual basis shall be charged in addition to inspection charges (₹ 10,000/-) as specified in Scheme - I of BIS (Conformity Assessment) Regulations. All these charges are over & above the marking fees. However, for visits paid by TA of empanelled agency, travel and stay expenses are not to be paid by the licensee.

6. Preparation of schedule and allocation of visits for lot inspections- Monthly schedule shall be prepared by Head (BO) and Inspection agency/ BIS Certifying Officer shall be assigned for each visit requested by the licensee. BIS Certification officer shall issue the test certificate based on the examination of lot inspection report submitted along with the test certificate by TA. In addition to adherence to principle of rotation given below, Head BOs shall rotate the visits for consequent production week equally amongst all the available certification officers (or agents, if applicable) in the Branch as far as possible in line with guidelines circulated vide CMD-I/2:12:6 dated 25 Jan 2021:

- a. Rotation of BIS Certification officer issuing test certificate to be ensured.
- b. Multiple visits to a single licensee are rotated amongst all the available certification officers/Technical Auditors of agencies equitably as far as possible.
- c. No particular certification officer/Technical Auditors of agencies is allocated unusually large number of visits in respect to a specific licensee.

7. In case a manufacturer has licences for more than one product at the same premises and quantum of work is less on the day of visit, the remaining period may be utilized by the officer for lot inspection of other licence(s) held by the licensee against one man-day charge already paid by the licensee to BIS.

Annexure- B
Bureau of Indian Standards
Format for report of Lot inspection of LPG Valve fittings as per IS 8737

- 1) Name of the unit-
 2) Licence No.: / CML
 3) Date of Inspection:
 4) Batch No.
 5) Testing and Release: -

Batch No.	Control Unit No.	Quantity Offered	Quantity Released	T.C. No.

- 6) No. of S.C. Valves Tested (Cycle Test):
 Result: Passed/Failed

- 7) Details of Rejected S.C. Valves: -

Control Unit No.	No of Rejected S.C. Valves (in process as per records)	Manner of disposal

- 8) Results of Inspection and testing:

(A) INLET CONNECTION					
Sr. No.	DIMENSION	REQUIRED	OBSERVED		RESULT
			MIN.	MAX.	
1	L1	0.786 – 4.414			
2	L8	L1+1.80 – 0.0			
3	Truncation	L1 + 2.60 – 0.0			
4	Adj. Screw height with Dial Gauge	0.0 – 0.4			
5	Unscrewing torque	5 kgf.cm (Min.)			
6	Thread length	22.3 – 23.3			

(B) OUTLET CONNECTION

Sr. No.	DIMENSION	REQUIRED (mm)	OBSERVED		RESULT
			MIN.	MAX.	
1	Outer dia with gauge	25.60 – 25.70			
2	Outer dia with gauge	25.65 – 25.80			
3	Neck dia with gauge	20.50 – 20.70			
4	Inner dia with gauge	12.00 – 12.10			
5	Length measured at dia 23.10 mm	7.60 – 7.90			
6	Spindle travel with dial gauge	3.50 – 4.50			
7	Spindle height with dial gauge	8.20 – 8.80			
8	Position of joint packing	0.40 – 0.90			
9	Collar height	4.40 – 4.60			
10	Overall height	52.10 – 52.90			
11	Across flat	27.60 – 28.00			
12	Tight joint groove bore	15.05 – 15.15			
13	Tight joint groove height	6.80 – 7.00			
14	Minimum Valve Thickness	2.5			

(C) PNEUMATIC TESTS

Sr. No.	PNEUMATIC TEST	REQUIREMENT	OBSERVED	RESULT
1	17kgf/cm ² (Open)	NO LEAK		
2	17kgf/cm ² (Closed)	NO LEAK		
3	0.25kgf/cm ² (Closed)	NO LEAK		
4	Soundness (1000 mm W.C)	NO LEAK		

9) Verification of Mechanical properties from Manufacturers' test record: (Attach scanned copy of testing records of each tested sample)

- a) Tensile Strength (kgf/mm²) :
b) % Elongation :
c) Izod Impact Strength (kgm)

MIN	MAX


10) Attach copy of test certificate prepared by licensee after verification:

- 11) Lot Acc./Rej.:
12) Qty. offered for inspection:
13) Qty. Accepted:
14) Remarks, if any:

Signature of QCI

Signature of CO/TA of BIS empanelled agency:
Name & Designation:

Annexure- C
Bureau of Indian Standards
Test Certificate for Valve Fittings for use with LPG Cylinders as per IS 8737

Name of the Manufacturer	IS 8737  CM/L-----
Certificate No:	Date:
Purchaser:	
Order No.	
Control Unit No:	Batch No
Quantity offered for inspection	
VALVE FITTINGS DESCRIPTION	
This is to certify that the valve fittings as mentioned below were inspected at M/s. ----- and these meet the requirements of IS 8737: 2017 and Drawing. No:	
RESULTS OF INSPECTION	
	No. of Valves
	Inspected Passed Rejected
a) Visual inspection	
b) External threads on Valve inlet	
c) Valve outlet connection	
d) Pneumatic Test	
(i) Tightness of joint packing (in valve outlet) & Valve spindle (Clause 8.3.1 of IS 8737: 2017)	
(ii) Tightness of valve spindle and valve Housing (Clause 8.3.2 of IS 8737: 2017)	
(iii) Tightness of joint packing and housing (Clause 8.3.3 of IS 8737: 2017)	
(e) Cycle Test with batch number	
(f) From the test records of manufacturer	
(i) Tensile Strength (Kgf/ mm ²)	
(ii) % elongation	
(ii) Impact strength (kg.m)	
QUANTITY PASSED :	
Rejected valve fittings and the method for their disposal	
Signature with date:	Signature with date:
Name & Designation of the representative of Licensee	Name and Designation of certification Officer of Bureau of Indian Standards

Standard Operating Procedure (SoP) for
Lot Inspection of Low Pressure Regulators for use with LPG as per IS 9798

Sl. No.	Activity	Responsibility
1.	REQUEST FOR LOT INSPECTION	
a)	<ul style="list-style-type: none"> • Request for Lot Inspection shall be made through Manakonline Portal preferably one week in advance or latest 3 days before the day of lot inspection (<i>See the guidelines on request, planning of inspections, Sampling and fee related matters attached as Annexure- 1</i>). • It is to be ensured that the offered batches are complete in all respects and have undergone all the testing as per Indian Standard and SIT and, before the inspection. • Lot Inspection Charges shall be paid through Manakonline Portal. (<i>See the guidelines on request, planning of inspections and fee related matters attached as Annexure- 1</i>) 	Licensee
2.	ALLOTMENT OF INSPECTION	
a)	<ul style="list-style-type: none"> • Allotment of Lot Inspection to agency and BIS Certification Officer shall be made through Manakonline • Ensure rotation of agency and certification Officer • Monitoring to ensure that rotation among TAs is being followed by the agency to whom inspection has been assigned (<i>See Annexure- 1 for details</i>) 	Head (BO)
b)	<ul style="list-style-type: none"> • Assigning the lot inspection by agency in-charge to its TA ensuring rotation of TAs (<i>See Annexure- 1 attached for details</i>). It shall be ensured by the agency that TA is assigned by them on the same day or latest, by next day. 	Agency in-charge
3.	VERIFICATION OF BATCHES AND LOT INSPECTION	
a)	<ul style="list-style-type: none"> • The authenticity of the information provided by the Licensee regarding completion of various stages w.r.t the batches offered for lot inspection shall be ensured at the time of inspection. • During the visit for Lot Inspection, ongoing activities at various stages shall be verified to ensure that all manufacturing and testing processes for the batches offered by the licensee have been completed. • Check and sign the inspection and testing records of various stages for the batches taken up for lot inspection 	CO /TA
		CO /TA

b)	Ensure that the Regulators offered for lot inspection are stored/stacked batch wise without mix up	Licensee
c)	<ul style="list-style-type: none"> Mixing up of batches shall not be permitted. Verify whether the Regulators of different batches are stored as distinctly identifiable and not mixed up. Perform physical verification of the offered batches w.r.t the Batch Numbers, Size (Quantity), etc. Verify that the material from which the Regulators have been manufactured are conforming to the requirements of IS 9798 (Check the chemical composition of the material in the test certificate received for each batch). Attach copy of test certificate with the lot inspection report. 	CO /TA
d)	<ul style="list-style-type: none"> Carry out lot inspection of verified batches as per sampling plan given in <i>Annexure 1</i> 	CO /TA
d)	<i>It is expected that minimum of 8 hours are spent in the factory by TA during the lot inspection</i>	TA
e)	<ul style="list-style-type: none"> Preparation of test certificate in prescribed format (<i>attached as Annexure- 3</i>) 	Licensee
4.	SUBMISSION OF LOT INPECTION REPORT	
a)	<ul style="list-style-type: none"> Verification of details in test certificate Submit the inspection report along with the test certificate in the prescribed format (<i>Annexure- 2</i>) during the lot inspection at the factory premises for consideration by BIS. 	CO/ TA
b)	<ul style="list-style-type: none"> All rejections (process rejections/samples in destructive testing etc.) shall be deshaped in the presence of CO/TA and entered in the deshaping record. The deshaping records shall be duly signed. 	Licensee Licensee/ CO/TA
c)	Inspection report is to be signed by licensee also and a copy of the same may be retained by the licensee	Licensee
5.	ISSUANCE OF TEST CERTIFICATE BY BIS CERTIFICATION OFFICER	
a)	Examination of the inspection report submitted by TA and Accept/Seek Clarification/Reject inspection report	CO
b)	Provide clarification to BIS Certification Officer, when any clarification is sought	TA
c)	Provide clarification to TA, if required	Licensee
d)	Issue test certificate (s)	CO
6.	QUALITY ASSURANCE MEASURES	

a)	It shall be ensured by Head (BO) that BIS Certification officer also is deputed periodically to conduct lot inspection of every cylinder unit preferably once in every 30 days or as decided by Head (BO) to ensure adequate supervision.	
b)	Head (BO) may also occasionally depute BIS officer on the day of lot inspection to check the working and performance of TA during the lot inspection	Head (BO)
c)	Head (BO) should proactively interact with the management of licensee to have a periodic feedback about the TAs of the agencies	

Abbreviations: CO- BIS Certification officer

TA- Technical auditor of BIS empaneled agency

Annexure-1
Guidelines on Request, Planning of inspections, Sampling and fee related matters for lot inspection of Low pressure regulators as per IS 9798

1. **Sampling Plan for Lot Inspection for Certification of LPG regulators as per IS 9798:** All the regulators of the same size manufactured from the same consignment of material under similar conditions of production shall be grouped together to constitute a lot. The lot may consist of one or more control units. Samples for lot inspection shall be selected depending on the number of regulators in a lot as given below:

Lot Size	Sample Size
Upto 500	20
501 to 1000	32
1001 to 3000	50
3001 to 10000	80
10001 to 25000	125
25001 & above	200

Note: When a lot consists of more than one control unit, the sample size shall be divided, as far as possible, equally between the control units

Criteria for Acceptance of a lot:

- (i) Each of the regulator selected in the sample shall be subjected to the following tests:
 - a) Construction and workmanship (clause 5.2 of IS 9798).
 - b) Inter-changeability (Cl. 5.3 of IS 9798)
 - c) Pneumatic test (Cl. 6.2, 6.4 of IS 9798)
 - d) Performance test (Cl. 8.9.1 of IS 9798)
 - e) Chatter (Cl. 8.9.2 of IS 9798)
- (ii) 2 regulators from the selected samples of each lot shall be tested for;
 - a) Outlet connection: [2 for non-threaded (Cl. 5.6.1) & 10 % of sample size for threaded (Cl. 5.6.2 of IS 9798).
 - b) Excess flow valve (5.9), if regulator is to be used with excess flow valve – (one Regulator)
 - c) Hydrostatic test (Cl. 6.3 of IS 9798)
 - d) Mechanical Strength of Connection (Cl. 8.11 of IS 9798).
- (iii) A regulator failing to meet any of the requirements of above tests shall be termed as defective. The lot shall be accepted if no defective is found in the sample size. In case of failure(s), the entire control unit(s) of the defective regulator(s) to be rechecked for the failed

parameter and reoffered for inspection, after taking corrective action, wherever required.

(iv) If a control unit has been re-offered, then the same sampling criteria should be applied as indicated above; but with double the sample size.

2. Licensees will submit the lot inspection request along with details of batches, preferably a week in advance or latest 3 days before the proposed day of lot inspection. Request from licensee for change in date of inspection with proper reason may be considered by Head (BO) by recording the justification.

3. For proper inspection/sampling, it should be ensured that licensee has got adequate storage/ stacking space within the factory premises so that valve fittings are offered batch-wise to the officer for inspection/ clearance. Mixing of batches shall not take place and each batch should be distinctly identifiable to facilitate its proper inspection & sampling.

4. Normally not more than two visits per licence may be planned every week. However, more visits may also be permitted by Head (BO) depending upon the need and availability of manpower. For lot inspections, licensee shall submit ₹ 10,000/- + GST per man day as special inspection charges. Licensee shall also make arrangement for travel and stay of the BIS Certification officer, as applicable. Otherwise, the payment towards travel and stay (for boarding and lodging per night stay) on actual basis shall be charged in addition to inspection charges (₹ 10,000/-) as specified in Scheme - I of BIS (Conformity Assessment) Regulations. All these charges are over & above the marking fees. However, for visits paid by TA of empanelled agency, travel and stay expenses are not to be paid by the licensee.

5. Preparation of schedule and allocation of visits for lot inspections- Monthly schedule shall be prepared by Head (BO) and Inspection agency/ BIS Certifying Officer shall be assigned for each visit requested by the licensee. BIS Certification officer shall issue the test certificate based on the examination of lot inspection report submitted along with the test certificate by TA. In addition to adherence to principle of rotation given below, Head BOs shall rotate the visits for consequent production week equally amongst all the available certification officers (or agents, if applicable) in the Branch as far as possible in line with guidelines circulated vide CMD-I/2:12:6 dated 25 Jan 2021:

- a. Rotation of BIS Certification officer issuing test certificate to be ensured.
- b. Multiple visits to a single licensee are rotated amongst all the available certification officers/Technical Auditors of agencies equitably as far as possible.
- c. No particular certification officer/Technical Auditors of agencies is allocated unusually large number of visits in respect to a specific licensee.

6. In case a manufacturer has licences for more than one product at the same premises and quantum of work is less on the day of visit, the remaining period may be utilized by the officer for lot inspection of other licence(s) held by the licensee against one man-day charge already paid by the licensee to BIS.

Annexure- 2
Bureau of Indian Standards
Format for report of Lot inspection of LPG Regulators as per IS 9798

- 1) Name of the unit-
 3) Date of Inspection:
 4) Batch No.

2) License No.: / CML

5) Testing and Release:-

Batch No.	Regulator Serial No.		Purchaser	Quantity Offered	Quantity Released
	From	To			

6) No. of Regulator Tested (mech. Strength Test):

Result: Passed/Failed

7) No. of Regulator Tested (HST):

Result: Passed/failed

8) Details of Rejected Regulators:-

Control Unit No.	No. of Rejected Regulators (in process as per records)	Manner of disposal

9) Results of inspection and testing

S. No.	Tests	No. of pieces tested	Results
1.	Construction & Workmanship (including Knob operation) (Cl. 5.2)		Satisfactory / Not satisfactory
2.	Interchangeability (Cl. 5.3)/Leakproof Test		Satisfactory / Not satisfactory
3.	Leakproof Test for Inlet Connection (Cl 5.5)		Satisfactory / Not satisfactory
4.	Soundness Test (Cl. 6)		
	a) Pneumatic Test (Cl.6.4) (from outlet)		Satisfactory / Not satisfactory
	b) Pneumatic Test (Cl. 6.2) (from outlet)		Satisfactory / Not satisfactory

	c) Hydrostatic Test (Cl. 6.3)		Satisfactory / Not satisfactory
5.	Outlet Connection (Cl. 5.6)		Satisfactory / Not satisfactory
6.	Chatter (Cl.8.2, 8.9.2)		Satisfactory / Not satisfactory
7.	Performance Test (Cl. 8.9.1)		Satisfactory / Not satisfactory
	a) Inlet pr: 0.5(kgf/cm ²) and 100% flow rate (not <225)		Satisfactory / Not satisfactory
	b) Inlet pr: 17 (kgf/cm ²) and Lock up (not>400)		Satisfactory / Not satisfactory
	c) Inlet pr: 17 (Kgf/cm ²) and Lock up (not >450)		Satisfactory / Not satisfactory
8.	Mechanical Strength of Connection (Cl. 8.11)		Satisfactory / Not satisfactory
			Satisfactory / Not satisfactory
			Satisfactory / Not satisfactory

10) Whether routine and type tests frequency is being maintained by firm: Yes/No

11) Whether raw material is conforming to IS 9798: Yes/ No (Attach copy of test certificate)

12) Attach copy of test certificate prepared by licensee after verification:

13) Lot Acc./Rej.:

14) Qty. offered for inspection:

15) Qty. Accepted:

16) Remarks, if any:

Signature of QCI

Signature of CO/TA of BIS empanelled agency:
Name & Designation:

Annexure-3
BUREAU OF INDIAN STANDARDS
TEST CERTIFICATE FOR LPG REGULATORS as per IS 9798

Certificate No.:

Date:

Name and address of the manufacturer

Batch No.:

Order No. & Date:

Purchaser:

Description: Low Pressure LPG regulator (Max. working Pressure 16.87 kgf/cm²) 500 l/h outlet for 6.4/7mm Rubber Tubing to be used on SC valves with 22.0/25 6 mm outlet diameter.

This is to certify that the following regulators are inspected and tested on _____ at M/s _____ in accordance with Scheme Of Inspection and Testing attached with BIS License No. _____ meet the requirement of IS 9798: 2013 & drawing No. _____ approved by Chief Controller of Explosives vide letter No. _____ dated _____.

Raw Material Specification:

Supplier's Name:

Test Cert. No. & Date:

CHEMICAL COMPOSITION

Constituent	Al	Mg	Cu	Pb	Fe	Cd	Sn	Tl & In	Ni	Zn
Specified										
As per TC										
Remark										

Regulators bearing serial Nos from to covered by Lot no: and Control Unit no. are checked/tested for the following:

Sr No	Parameter	Clause no.	Specified value/ or as per	No of pieces inspected	Result
1	Construction and workmanship	5.2	5.2		
2	Interchangeability	5.3	5.3		
3	Leak proof test for inlet connection	5.5	5.5		
4	Soundness test	6			
4 a)	Pneumatic test (at Kgf/Cm ²)	6.4	17		
4 b)	Pneumatic test (at gf/Cm ²)	6.2	150		
4 c)	Hydrostatic test (at Kgf/Cm ²)	6.3	25.4		
5	Outlet connection	5.6	5.6		
6	Chatter	8.2, 8.9.2	8.2, 8.9.2		
7	Performance test	8.9.1	Delivery pressure (mm of water column)		

7 (a)	Inlet pressure: 0.5 Kgf/Cm2 and 100 % flow rate	8.9.1	225 min		
7 (b)	Inlet pressure: 17 Kgf/Cm2 and 10 % flow rate	8.9.1	400 max		
7 (c)	Inlet pressure: 0.5 Kgf/Cm2 and lock up	8.9.1	450 max		
8	Excess flow valve	5.9	5.9		
9	Mechanical strength of connection	8.11	8.11		

Quantity inspected:

Quantity Passed:

SR. NO. OF REGULATORS REJECTED:

(Include the Regulators tested for Hydrostatic test as per cl: 6.3)

Method of disposal of rejected regulators: De-shaped/Dismantled:

Signature with date
Name & Designation
Firm's QC Incharge

Signature with date
Name & designation
BIS Certification Officer