

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:15905

01 01 2025

विषय: संशोधित IS 15905:2024 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 डी**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:15905

01 01 2025

Subject: Guidelines for implementation of Revised IS 15905:2024

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 D**

Head (CMD-2)

All ROs/BOs/Labs/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 15905

01 01 2025

Subject: Guidelines for implementation of revised IS 15905:2024(Hubless Centrifugally Cast (Spun) Iron Pipes, Fittings and Accessories- Specification)

1. This has reference to the above.
2. IS 15905:2011 has been revised as IS 15905:2024 and the date of withdrawal of IS 15905:2011 is **12th March, 2025**.
3. 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 15905	Change
1 Scope	Scope has been modified to include 3 new sizes of Pipes and Fittings i.e. 250 mm, 300 mm and 400 mm
5.1 Manufacture	Clause has been modified to state that the Cast Iron used for the manufacture of pipes, fittings and accessories shall conform to FG Grade 150 (min) , as appropriate, specified in IS 210.
6.2 Joints	Requirements of Rubber Gaskets have been specified at Table 29, Table 30 and Table 31 of Annex B
Table 1, 6.3., Minimum Free Length	Table has been modified to specify Minimum Free Length for the newly added sizes i.e. 250 mm, 300 mm and 400 mm
6.4 Joints	Clause has been modified to specify that in case Stainless Steel is used for manufacture of clamping components, the material shall usually be Austenitic stainless steels of 300 series, preferably of 304 or 316 grades.
7 Visual Inspection and Hammer Test	Clause has been modified by modifying the first sentence from "Each pipe, fitting, and accessories shall be visually inspected..." to "All pipe, fitting, and accessories are visually inspected...."
Table 2, 10.2, External Diameters and Tolerances	Table has been modified to specify Tolerance on External Diameter for the newly added sizes i.e. 250 mm, 300 mm and 400 mm
Table 3, 10.3, Thickness and Tolerances	Table has been modified to specify Nominal and Minimum Thickness of Pipes and Fittings of the newly added sizes i.e. 250 mm, 300 mm and 400 mm
10.3 Length and Tolerances	Clause has been modified to specify that the normal manufacturing length of pipes shall be 3 000 mm. However, other lengths of pipes are permitted and can be supplied by the agreement of manufacturer and purchaser
10.5 Masses and Tolerances	Clause has been omitted
10.6 Straightness of Pipe	A new clause specifying requirements of Straightness of Pipe has been added

10.7 End Faces	A new clause specifying requirements of End Faces of Pipes and Fittings has been added
10.8.2.2 Other Dimensions, Fittings	Requirement of “88° Bend” has been replaced with the requirement of “88° Bend with or without access door “
10.8.2.8 Other Dimensions, Fittings	Requirement of “88° Single branch has been replaced with the requirement of “ 88° Single branch with or without access door”
10.8.2.20, 10.8.2.21 , 10.8.2.22 , 10.8.2.23, 10.8.2.24, 10.8.2.25 Other Dimensions, Fittings	Tolerances on Nominal Dimensions of new types of Fittings i.e. Unequal trap, 88° Single branch with or without door (sweep type), 88° Single branch socketed with access door (sweep type) , Multi inlet pipe , Floor trap (deep seal) and Access door have been added
Table 23 to Table 28	Nominal Dimensions of new types of Fittings i.e. Unequal trap, 88° Single branch with or without door (sweep type), 88° Single branch socketed with access door (sweep type) , Multi inlet pipe , Floor trap (deep seal) and Access door have been specified under Tables 23 to Table 28, respectively.
11 Coating	Clause has been modified to specify the requirements of mean thickness of coating and the local minimum thickness
11.2 Resistance to Salt Spray	A new clause has been added specifying duration of salt spray test, test method (as per ISO 9227) and degrees of blistering and rusting of coating on pipes and fittings
Annex B Drawing and Dimensions for Stainless Steel Shielded Coupling	Drawing and dimensions for stainless steel shielding coupling have been modified

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 15905 has been revised which is being circulated separately.
5. The guidelines for implementation of the revised Standard is given below:

A. LICENSEES:

1. For switchover of existing Licence as per IS 15905:2011 to IS 15905:2024, licensees shall submit:

- i) In-house/Independent Test Reports of the size range of Pipes and/or Fittings, covered under existing scope of licence, as per the revised standard i.e. IS 15905:2024. The test reports shall be of the sizes of Pipes and/or Fittings as per the Grouping Guidelines specified in Product Manual of IS 15905:2024.

ii) Test Equipment List (in Form-II) as per the requirements of IS 15905:2024.

2. On receipt of the above evidences of conformity, BOs shall issue endorsement with regards to switchover of licence to IS 15905:2024.

3. All Licensees shall implement the revised Standard by **12th March, 2025**. 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 **12th March, 2025**. **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.**

4. 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 up to **11th March, 2025** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **12th March, 2025**
3. Beyond **12th March, 2025** 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 **12th March, 2025** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja
Sc. D

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