

**केन्द्रीय मुहर विभाग-2**

हमारा संदर्भ: सीएमडी-2/16:15392

01-जून-2018

**विषय: आई एस 15392:2003 के अनुसार खाद्य पकेज़बंदी के लिए एल्युमिनियम एवं एल्युमिनियम मिश्रधातु से बनी अनवरत पत्री के प्रमाणन हेतु समूहिकरण दिशा निर्देश**

सक्षम प्राधिकारी द्वारा अनुमोदित, आई एस 15392:2003 के प्रमाणन हेतु समूहिकरण दिशा निर्देश तत्काल प्रभाव से अनुपालन हेतु संलग्न है।

(आदित्य दास)  
वैज्ञानिक सी

**प्रमुख (सी एम डी -2)**

सभी क्षेत्रीय कार्यालय/शाखा कार्यालय/एम टी डी को परिचालित

प्रतिलिपि: आई टी एस विभाग -भा मा ब्यूरो इंटरनेट पर परिचालन हेतु

**CENTRAL MARKS DEPARTMENT-2**

Our ref: CMD-2/16:15392

01-June-2018

**Subject: Grouping Guideline for Aluminium and Aluminium Alloy Bare Foil for Food Packaging as per IS 15392: 2003.**

Please find enclosed grouping guidelines for certification of IS 15392:2003, duly approved by the Competent Authority, for immediate implementation.

(Aditya Das)

Sc. C

**Head CMD-2**

**Circulated to ROs/BOs/MTD**

**Copy to:**

**ITSD - with a request to host on BIS intranet**

## CENTRAL MARKS DEPARTMENT-2

Our ref: CMD-2/16:15392

01-06-2018

Subject: Grouping Guideline for Aluminium and Aluminium Alloy Bare Foil for Food Packaging as per IS 15392: 2003.

1. IS 15392 covers Aluminium and Aluminium Alloy Bare Foil for Food Packaging of following varieties:-

(i) Preferred Nominal Thickness: 11,12,14,16,18,20,22,25,28,30,35,40,45,50,60,70 & 75  $\mu\text{m}$

(ii) Surface Condition (a) Dry Annealed & (b) Slick Annealed

2. In order to follow a uniform policy for drawl of samples for independent testing as per IS 15392: 2003 (Aluminium and Aluminium Alloy Bare Foil for Food Packaging) for the purpose of grant of licence/ inclusion of additional varieties in the existing licence, the following guidelines may be followed:-

(i) In order to cover the entire preferred nominal thickness range and both surface conditions i.e dry & slick annealed, samples of lowest and highest preferred nominal thickness has to be drawn separately for each surface condition. In case of dry annealed condition, the IO shall record the type of condition i.e. dry annealed A, dry annealed B or dry annealed C in the test request.

For example, If sample of foil 11  $\mu\text{m}$  & 30  $\mu\text{m}$  of any surface condition i.e dry annealed A or dry annealed B or dry annealed C is tested for all the requirements of the specification, then foil of preferred nominal thickness from 11  $\mu\text{m}$  upto and including 30  $\mu\text{m}$  having surface finish dry annealed shall be considered for grant of licence/inclusion.

3. During Preliminary inspection, testing for dimensional tolerances as per clause 12.2 & 12.3 of IS 15392: 2003 shall be ensured in factory testing. For the purpose of inclusion, licensee shall submit the factory test report for these requirements along with OSL test report and conformity of the dimensions to the same shall be verified during next surveillance visit.

4. While considering grant of licence/ inclusion of new varieties, it shall be ensured that the firm has necessary manufacturing and testing facilities for all the sizes proposed to be covered under the scope of BIS Certification.

5. During the operation of licence, BOs shall ensure testing of different thickness covered in the licence in rotation, so that all thickness are tested over a period of time.