

केन्द्रीय मुहर विभाग -2

संदर्भ -: के मू वी-2/16:1397

21 08 2020

विषय: संशोधित IS 1397:2020 का Scheme of Inspection and Testing (SIT)

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित SIT अनुपालन हेतु संलग्न है।

सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की SIT का अनुपालन सुनिश्चित करें।

आदित्य दास
वैज्ञानिक D

प्रमुख (के मू वी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/ CHD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:1397

21 08 2020

Subject: Scheme of Inspection and Testing for Revised IS 1397:2020

This has reference to the subject mentioned above.

The Competent Authority has approved the enclosed SIT for implementation.

All ROs/BOs are requested to ensure the implementation of the SIT.

(Aditya Das)
Scientist D

Head (CMD-2)

All ROs/BOs/Labs/CHD/LPPD

**SCHEME OF INSPECTION AND TESTING
FOR KRAFT PAPER FOR PACKING AND WRAPPING ACCORDING TO IS 1397:2020**

1. LABORATORY - A laboratory shall be maintained which shall be suitably equipped (as per the requirement given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.

1.1 The manufacturer shall prepare a calibration plan for the test equipments.

2. TEST RECORDS –The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. PACKING AND MARKING –The Standard Mark, as given in the Schedule of the license shall be printed on each package or roll of Kraft paper or on the label attached to it, provided that the product thus marked conforms to the requirement of the specification.

3.1 Packing and Marking shall be done as per the provisions of the Indian Standard. In addition, following details shall be marked on each package or roll or label:

- i) BIS Licence Number CM/L—
- ii) BIS website details as follows “For details of BIS certification please visit www.bis.gov.in”

3.2 For consignment to be transshipped, the pictorial marking “USE NO HAND HOOKS” and “KEEP AWAY FROM RAIN” as contained in IS 1260 (Part 2):1999 – Packaging – Pictorial Marking for Handling and Labelling of Goods Part 2 General Goods, shall be stenciled on the packages or rolls.

4. CONTROL UNIT – For the purpose of this scheme, 50 tonnes of production or part thereof made from the same batch of raw material on a particular machine continuously in a period not exceeding 8 hours (per shift) shall constitute a control unit.

5. LEVELS OF CONTROL - The tests as indicated in column 1 of Table 1 and the levels of control in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with paragraph 2 above.

5.1 All the production which conforms to the Indian Standards and covered by the licence should be marked with Standard Mark.

6. REJECTIONS—Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act, 2016.

TABLE 1
LEVELS OF CONTROL

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or)S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods	Cl. Reference		No. of Sample	Frequency	Remarks
5.1	Materials	5.1	IS 1397	R		Each control unit	See Note 3
5.2	Finish	5.2	-do-	R	One	Each package/roll	See Note 4
5.3	Size		IS 1064	R	One	Each control unit	
5.4	Substance		IS 1060 (Pt 5/Sec 5)	R	Six	-do-	
5.5 Table 1	Requirements for Kraft Paper						
(i)	Moisture Content		IS 1060 (Pt 5/Sec 2)	R	3	Each control unit	
(ii)	pH	10	IS 1060 (Pt 1)	R	-do-	-do-	
(iii)	Burst Index		IS 1060 (Pt 6/Sec 2)	R	-do-	-do-	
(iv)	Tear Index (each direction)		IS 1060 (Pt 6/Sec 1)	R	-do-	-do-	
(v)	Tensile Index (MD/CD)		IS 1060 (Pt 5/Sec 6)	R	-do-	-do-	
(vi)	Folding Endurance (No. of double folds) (60/80 g/m ²)		IS 1060 (Pt 6/Sec 3)	R	-do-	-do-	
(vii)	Cobb Value (Front/Back)		IS 1060 (Pt 5/Sec 4)	R	-do-	-do-	

5.6 Table 2	Optional requirements for Kraft Paper, Grade 1						
(i)	pH	10	IS 1060 (Pt 1)	R	One	Each control unit	
(ii)	Ash at 900°C		IS 1060 (Pt 4/Sec 3)	R	-do-	-do-	
(iii)	Elongation at break (CD/MD)		IS 1060 (Pt 5/Sec 6)	R	-do-	-do-	
(iv)	Chlorides (as NaCl)		IS 1060 (Pt 4/Sec 8)	R	-do-	-do-	
(v)	Sulphates (as Na ₂ SO ₄)	18	IS 1060 (Pt 2)	R	-do-	-do-	
(vi)	Fatty and/or similar acids	19	IS 1060 (Pt 2)	R	-do-	-do-	
(vii)	Alkalinity	Annex B	IS 1397	R	-do-	-do-	

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empaneled by the Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit/batch/lot and submit his own levels of control in column 3 with proper justification for approval to BO head.

Note-3: Routine analysis of each consignment of raw material received in the factory shall be carried out and appropriate records maintained. Adequate inspection at various stages of manufacture shall be ensured. Requirement of materials as per 5.1 of IS 1397 shall be ensured.

Note-4: Each package/roll constituting the control unit shall be examined for formation, finish and visual defects and shall satisfy the requirements given in the Indian Standard. In case the product is found defective, it shall be segregated and shall not be marked with Standard Mark.