

केंद्रीय मुहर विभाग-2

संदर्भ : कें.मु.वि-/16:15965

09 05 2018

विषय: आई एस 15965:2012 "पूर्व रोगन की गई एल्युमीनियम जिंक मिश्र धातु लेपित इस्पात पट्टी एवं चदरे (सादा)" की संशोधित एस टी आई (डॉक: एस टी आई /15695/2 , अप्रैल 2018) का कार्यान्वयन

उत्पादकों से प्राप्त अभ्यावेदनों के आधार पर सक्षम अधिकारी ने एस टी आई, डॉक: एस टी आई /15965/1 सेप्टेम्बर 2014, में दिए साल्ट स्प्रे टेस्ट व ह्यूमिडिटी रेसिस्टन्स टेस्ट के परीक्षण आवृत्ति को परिवर्तित करने की अनुमति प्रदान की है। रिजेक्शन क्लौस को भी परिवर्तित किया गया है।

सक्षम अधिकारी द्वारा अनमोदित , संशोधित एसटीआई (डॉक: एस टी आई /15965 /2, अप्रैल 2018) तत्काल प्रभाव से अनुपालन हेतु संलग्न है ।

सभी संबन्धित से अनुरोध है कि इसका कार्यान्वयन सुनिश्चित करें।

(आदित्य दास)
वैज्ञानिक सी (कें.मु.वि.-2)

प्रमुख, (कें.मु.वि.-2)

सभी शाखा कार्यालयों/एमटीडी/प्रयोगशालाओं को परिचालित
प्रतिलिपि: ITS इंटरनेट पर अपलोड करने के लिए

CENTRAL MARKS DEPARTMENT -2

Our Ref: CMD-2/16: 15965

09 05 2018

**Subject: Implementation of Revised STI (Doc: STI/15965/2 April 2018) for IS 15965:2012
"Pre Painted Aluminium Zinc Alloy Metallic Coated Steel Strip and Sheet
(Plain)"**

Based on the representations received from manufacturers, the Competent Authority has agreed to revise the test frequency of Salt Spray Test and Humidity Resistance Test in the STI Doc: STI/15965/1 September 2014 for IS 15965:2012. The rejection clause has also been modified.

In this regard, please find enclosed revised STI (Doc: STI/15965/2, April 2018) for IS 15965:2012 which has been duly approved by Competent Authority, for immediate implementation.

This is being sent to all BOs for implementation.

(Aditya Das)
Sc. C (CMD-2)

Head, CMD-2

Circulated to: All BOs/MTD/Labs

Copy to: ITS for hosting on Intranet

**SCHEME OF TESTING AND INSPECTION FOR PRE-PAINTED ALUMINIUM ZINC
ALLOY METALLIC COATED STEEL STRIP AND SHEET (PLAIN)
ACCORDING TO IS 15965 :2012**

1.0 LABORATORY: A laboratory shall be maintained, which shall be suitably equipped and staffed, to carry out different tests and inspections according to the Standard.

1.1 Environmental conditions wherever applicable shall be maintained.

2.0 TEST RECORDS: All records of tests and analysis shall be kept in suitable formats.

2.1 Copies of any records or connected papers that may be required by BIS shall be made available at any time on request.

2.2 For all stages of manufacture, the factory shall maintain appropriate controls and checks to ensure that their product conforms to the various requirements of the Standard.

3.0 QUALITY CONTROL: It is recommended that, as far as possible, Statistical Quality Control (SQC) methods may be used for controlling the quality of the product during production as envisaged in this Scheme. See IS 397(Part 1), IS397(Part 2), IS 397(Part 3) and IS 397(Part 4)].

3.1 In addition, effort should be made to gradually introduce Quality Management System in accordance with IS/ISO 9001.

4.0 CALIBRATION: Periodic calibration of testing equipments shall be carried out and records of such calibrations kept.

5.0 STANDARD MARK: The standard mark as given in column 1 of the First Schedule of the license is specified for Pre-painted aluminium zinc alloy metallic coated steel strip and sheet (plain) specified in IS 15965:2012.

5.1 TEST CERTIFICATE: For each consignment of BIS certified material conforming to IS 15965:2012, there shall be Test Certificate (as given in Annex 1) which shall contain the Standard Mark.

5.1 MARKING: In addition, the following information shall be legibly and indelibly marked on the top of each bundle or package of sheets or shown on a tag/label attached/affixed to each coil/bundle or package:

- (a) Name of the manufacturer and/or registered trade mark, if any.
- (b) Material identification/ Coil number/ Packet number, Batch or Control Unit Number
- (c) Product Dimensions
- (d) Number of sheets or mass
- (e) Name/Class of top colour
- (f) Date of Packing / Final Inspection.

6.0 SUPPLY OF MATERIAL: As per Clause 4 and Clause 11.3 of IS 15965: 2012

6.1 PACKING : As per Clause 15 of IS 15965: 2012

7.0 LEVELS OF CONTROL: The tests, as indicated in Table 1 and at the levels of control specified therein, shall be carried out on the whole production of the factory which is covered by this Scheme and appropriate records and charts maintained in accordance with paragraph 2.0 above.

7.1 In respect of all other clauses of the Standard, appropriate control and checks to be maintained in order to ensure that the product conforms to the various requirements of the Standard.

7.2 All the production which conforms to the Indian Standard and covered by this License shall be marked with the Standard Mark.

8.0 CONTROL UNIT: All sheets/coils having same cast/quality, dimensions, grade of metal coating, colour and class of paint coating manufactured in a day shall constitute a control unit.

9.0 REJECTION: Any rejected material which is potentially re-salable be sheared or cut or deformed in such a manner that it cannot be used for any other purpose except re-melting. A separate record shall be maintained giving information on quantity and cast number/coil number/control unit number, as applicable, relating to all such rejections/defective/sub-standard material of the production not conforming to the requirements of the Specification and the method of its disposal. Such material shall in no case be stored together with that conforming to the Specification. The Standard Mark (if already applied) on rejected material should be defaced.

10.0 SAMPLES: The licensee shall supply free of charge, the sample or samples required in accordance with Bureau of Indian Standards (Certification) Regulation, from his factory or godown. BIS shall pay for the samples taken by it from the open market.

11.0 REPLACEMENT: Whenever a complaint is received soon after the product with Standard Mark have been purchased and used, and if there is adequate evidence that the product has not been misused, defective product shall be replaced or repaired free of cost by the licensee in case the complaint is proved to be genuine and the warranty period (where applicable) has not expired. The final authority to judge conformity of the product to the Indian Standard shall be with BIS. The firm shall have own complaint investigation system as per IS/ISO 10002.

11.1 In the event of any damages caused by the product bearing the Standard Mark, or claim being filed by the consumers against BIS Standard Mark and “ not conforming” to the relevant Indian Standard, entire liability arising out of such non conforming product shall be of licensee and BIS shall not in any way be responsible in such cases.

12.0 STOP MARKING: The marking of the product shall be stopped under intimation to BIS, if at any time, there is some difficulty in maintaining the conformity of the product to the Standard, or the testing equipment goes out of order. The marking may be resumed as soon as the defects are removed under intimation to BIS.

The marking of the product shall be stopped immediately if directed by BIS for any reason. The marking may then be resumed only after permission by BIS. The information regarding resumption of marking shall also be sent to BIS.

13.0 PRODUCTION DATA: The licensee shall send to BIS as per the enclosed Proforma-1 authenticated by a Chartered Accountant, a statement of quantity produced, marked and exported by them and the trade value thereof at the end of each operative year of the license.

IS 15965: 2012 PRE-PAINTED ALUMINIUM ZINC ALLOY METALLIC COATED STEEL STRIP
AND SHEET (PLAIN)

TABLE 1: LEVELS OF CONTROL

(Clause 7.0 of the Scheme of Testing and Inspection)

Test Details		Levels of Control				
		Test Methods		No. of Samples	Frequency	Remarks
Sl. No	Requirement	Clause	Reference			
1	Manufacture	5	IS 15965:2012	1	Each cast of materials rolled having same quality and dimensions and grade of metallic coating OR Each consignment of same quality, dimensions and metallic coating.	Each consignment of material to be supported with test certificate. No further testing if materials are Standard Marked.
2	Coatings	7.1;7.3; 7.4,8.2	- do -	1 from every 25 t of Sheets / Coil	Each control unit	Paint coatings may also be supplied as per agreement with manufacturer and the purchaser (Note under clause 7.3 and annex F of IS 15965:2012) . In such cases, requirements to be tested against declared values
3	Physical Properties of Paint Coating	8, 8.2	- do -	Ref. Sl. No. 3.1 to 3.5 below		
3.1	T-bend Adhesion Test	8.3.1, 8.2	IS 15965:2012	1 from every 25 t of Sheets / Coil	Coil / Sheets: every 25 tonnes or each control unit	Sheets/coils of the same quality, dimensions, grade of metallic coating and colour.

3.2	Reverse Impact Resistance Test	8.3.2, 8.2	IS 15965:2012	-do-	-do-	-do-
3.3	Pencil Hardness Test	8.4, 8.2	IS 15965:2012	-do-	-do-	-do-
3.4	Solvent Resistance Test	8.6, 8.2	IS 15965:2012	-do-	-do-	-do-
3.5	Dry Film Thickness	7; 8.7	IS 15965:2012	-do-	-do-	-do-
3.6	Appearance- Colour	9.2, 8.2	IS 15965:2012	-do-	-do-	Colour of sheets/coils as per agreement between the manufacturer and the purchaser (Clause 9.2 of IS 15965:2012)
3.7	Appearance- Gloss	9.3	IS 15965:2012	-do-	-do-	Gloss of sheets/coils as per agreement between the manufacturer and the purchaser (Clause 9.3 of IS 15965:2012)
3.8	Salt Spray Test (Corrosion Resistance)	10.1	IS 15965:2012	One	Once every three months	Samples of all durability classes covered in licence shall be tested in rotation
3.9	Humidity Resistance	10.2	IS 15965:2012	One	Once every three months	Samples of all durability classes covered in licence shall be tested in rotation
4	Other Tests	8.5	IS 15965:2012	As per agreement between the manufacturer and the purchaser		
5	Dimensions and Tolerances	11.1, 11.2, 11.3, 11.4.1, 11.4.2, 11.4.3	IS 15965:2012	Sheet:3 Coil : each	Each control unit	Sheets and coils may also be supplied in sizes and mass as per agreement with manufacturer and the purchaser (Clause 11.3 of IS 15965:2012). In such cases, requirements to be tested against declared values
5.1	Mass	11.2, 11.3, 13.1, 13.2	IS 15965:2012	Sheet:3 Coil : each	Each control unit	
6	Shapes	12	IS 15965:2012	Re. Sl. No. 6.1 to 6.3 below		
6.1	Camber	12.1	IS 15965:2012	Sheet:3 Coil : 1	Each control unit	

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6.2	Deviations from Squareness (Out of Square)	12.2	IS 15965:2012	Sheet:3	Each control unit	
6.3	Deviations from Flatness	9.3	IS 15965:2012	Sheet:3	Each control unit	

PERFORMA 1
PROFORMA FOR YEARLY PRODUCTION DETAILS

Period covered *

Name of Licensee

CM/L No.

Name of Articles (s)

IS No. - IS 15965:2012

Class/Sheet/Coil

1.1 Brand/Trade/Name(s) of BIS Certification Marked Products

2. Total production of the articles(s) licensed for certification marking

2.1 Total production of the article(s) conforming to Indian Standard

3. Production covered with BIS Certification Mark and its approximate value

a) Quantity

b) Invoice sale price

3.1 Brand Name used on production covered under BIS Certification Mark

3.2 Calculation of marking fee on unit rate basis: Marking Fee per unit

a) Unit

b) Quantity covered with BIS Certification Mark

*Information to be filled up by BO before forwarding to the licensee.

Note : In case a clause is not applicable, suitable remarks may be given against it.

c) Marking fee rounded off in whole rupees as obtained by applying unit rates given in
(a) on quantity given in (b)

4. Quantity not covered with BIS Certification Mark. If any, and the reasons for such non-coverage

4.1 Brand Name under which non-certified goods were sold

5.0 Quantity Exported with BIS Standard Mark and its value

5.1 Brand Name under which BIS Certified goods are exported

6.0 Authentication by Chartered Accountant

Signature of

BIS STANDARD
MARK

ANNEXURE -I
(Para 3.1 of the Scheme of Testing and Inspection)
XYZ COMPANY
(Registered Office Address and works address)

TEST CERTIFICATE FOR PRE-PAINTED ALUMINIUM ZINC ALLOY METALLIC COATED
STEEL STRIP AND SHEET (PLAIN) ACCORDING TO IS 15965:2012

TEST CERTIFICATE NO.:

DATE:
To,
M/s

It is certified that the material described below fully conforms to IS 15965:2012. Chemical composition and mechanical properties of the product, as tested in accordance with the Scheme of Testing and Inspection contained in the BIS Certification Marks Licence No.CM/L _____ are as indicated below against each order no.

{ PLEASE REFER TO IS 15965:2012 FOR DETAILS OF SPECIFICATION REQUIREMENTS }

TEST RESULTS

Order No. and date	Control unit/Coil/Package No.	Size T x W x L	Durability Class	Quantity (tonnes)	No of Sheets/Coil	Dry film thickness	Adhesion Test	Pen cil hardness test	Im pac t resi sta nt test	Solve nt resist ance test	Glos s	Na me of top col our	Al-Zn Coati ng class	Steel Grade	Rem arks

The material supplied conforms to the specified dimensions and shapes

REMARKS

SIGNATURE :

SHIPPING ADVICE NO.
WAGON NO.
TRUCK NO.

DESIGNATION :
FOR XYZ COMPANY

(It is suggested that size A-4 paper (210x297 mm) be used for this Test Certificate)