

## केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-3/16: IS 14587

दिनांक: 03 10 2018

**विषय: अनुपालन हेतु एस आई टी**

सभी शाखा कार्यालय से आग्रह है कि एस आई टी का अनुपालन तत्काल प्रभाव से सुनिश्चित करें।

(अमित कुमार)  
वैज्ञानिक 'सी' (सी एम डी-III)

**प्रमुख (सी एम डी-III)**

सभी क्षेत्रीय/शाखा कार्यालय  
आई टी एस विभाग – बीआईएस इंटरनेट पर अपलोड करने हेतू

### CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-3/16: IS 14587

Date: 03 10 2018

**Subject: SIT for IS 14587 : 1998 'Prelaminated medium density Fibre boards for general purposes' .**

This has reference to the subject mentioned above.

BOs may kindly ensure implementation of the SIT with immediate effect.

Amit Kumar  
Sc. C (CMD III)

**Head (CMD - III)**

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**SCHEME OF INSPECTION AND TESTING  
FOR CERTIFICATION OF PRELAMINATED MEDIUM DENSITY FIBRE  
BOARDS FOR GENERAL PURPOSES ACCORDING TO IS 14587 : 1998**

**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. LABELLING AND MARKING**– As per the requirements of IS 14587 : 1998.

**4. CONTROL UNIT** – **Prelaminated medium density fibre boards for general purposes of the same designation (Class/type and grade) and formaldehyde class, manufactured with the same batch of adhesive compound during a shift of eight hours subject to a maximum 1000 boards** shall constitute a control unit.

**5. LEVELS OF CONTROL** - The tests as indicated in column 1 of Table 1 and the levels of control submitted by the manufacturer 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 Standard 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**

<b>(1)</b>				<b>(2)</b>	<b>(3)</b>		
<b>Test Details</b>				<b>Test equipment requirement</b> R: required (or) S: Sub-contracting permitted	<b>Recommended Levels of Control</b>		
Clause	Requirement	<b>Test Methods Clause Reference</b>			No. of Sample	Frequency	Remarks
5.1	Medium density fibre board	5.1	IS 14587 IS 12406	S	Two	Each Lot	No further testing is required if accompanied with test certificate or ISI Marked.
5.2	Impregnated base paper	5.2	IS 14587	S	Two	Each lot	No further testing is required, if received with test certificate.
5.3	Impregnated overlay	5.3	IS 14587	S	Two	Each Lot	
7	Finish	7	IS 14587	R	Each board	-	-
8	Dimensions and Tolerances	8	IS 14587 IS 12406 IS 2380 (Part 2)	R	Three	Every hour production	In case of failure in dimensions, all boards manufactured during the hour shall be checked and only those conforming shall be marked.
9.2 (a), 10.2 and Table 1	Density	10.2	IS 14587 IS 2380 (Part 3)	R	Two	Each control unit	##
9.2 (b), 10.3 and Table 1	Moisture content	10.3	IS 14587 IS 2380 (Part 3)	R	Two	Each control unit	
9.2 (c), 10.4 and Table 1	Water absorption test a) 2 h and b) 24 h	10.4	IS 14587 IS 2380 (Part 16)	R	Two	Each control unit	
9.2 (d), 10.5 and Table 1	Swelling in water test	10.5	IS 14587 IS 2380 (Part 17)	R	Two	Each control unit	

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub-contracting permitted	Recommended Levels of Control		
Clause	Requirement	Test Methods Clause Reference			No. of Sample	Frequency	Remarks
9.2 (e), 10.6 and Table 1	Modulus of rupture (MOR) and Modulus of elasticity (MOE)	10.6	IS 14587 IS 2380 (Part 4)	R	Two	Each control unit	##
9.2(f), Table 1 and 10.7	Tensile strength perpendicular to surface	10.7	IS 14587 IS 2380(Part 5)	R	Two	Each control unit	##
9.2(g), Table 1 and 10.8	Tensile strength perpendicular to surface after ageing test a) Cyclic test or	10.8	IS 14587 IS 2380(Part 5)	S	Two	Once in three months for each type, Class and grade.	@@
	b) Accelerated water resistance test	10.8	IS 14587 IS 2380(Part 5)	R	Two	Each control unit	##
9.2(h), Table 1 and 10.9	Screw withdrawal test	10.9	IS 14587 IS 2380(Part 14)	R	Two	Each control unit	##
9.2(j), Table 1 and 10.10	Resistance to abrasion	Annex B	IS 14587	R	Two	Each control unit	##
9.2(k) and 10.11	Resistance to steam	Annex C	IS 14587		Two	Each control unit	##
9.2(m) and 10.12	Resistance to crack	Annex D	IS 14587		Two	Each control unit	##
9.2(n) and 10.13	Resistance to cigarette burns	Annex E	IS 14587		Two	Each control unit	##
9.2(p) and 10.14	Resistance to stain	Annex F	IS 14587		Two	Each control unit	##

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub-contracting permitted	Recommended Levels of Control		
Clause	Requirement	Test Methods Clause Reference			No. of Sample	Frequency	Remarks
10.15	Formaldehyde content/Emission value	10.15 10.15.1	IS 14587 IS 13745  Or  IS 14587	R	Two	Each control unit	## The manufacturer may test the product either for formaldehyde content or Steady state formaldehyde emission value.
		10.15 10.15.2	IS/ISO 12460-1: 2007	S	Two	Once in three months for each type and grade	

## If both the samples fail, the control unit shall be rejected and shall not be marked. If one sample fails, then two additional samples shall be taken from the same control unit for retesting. If any retested sample fails, the control unit shall be rejected and shall not be marked.

@@ If any sample fails, marking shall be stopped. Marking shall be resumed only after passing of improved lots produced after taking corrective actions. Frequency of testing shall be maintained as once in a month for each type , grade/subclass of boards till three consecutive samples pass and there after original frequency of testing shall be resumed.

Note- 1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the Bureau.

Note-2 The control unit and levels of control as decided by the Bureau are obligatory to which the licensee shall comply with.