

**केन्द्रीय मुहर विभाग -2**

संदर्भ -: केमूवी-2/16:14246

09 04 2024

विषय: संशोधित **IS 14246:2024** 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 सी**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/**MTD/LPPD**

**CENTRAL MARKS DEPARTMENT-2**

Our Ref: CMD-2/16:14246

09 04 2024

**Subject: Guidelines for implementation of Revised IS 14246:2024**

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 C**

**Head (CMD-2)**

**All ROs/BOs/Labs/MTD/LPPD**

## CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 14246

09 04 2024

**Subject: Guidelines for implementation of Revised IS 14246:2024(Continuously Pre-Painted Galvanized Steel Sheets and Strips- Specification)**

1. This has reference to the above.
2. IS 14246:2013 has been revised as IS 14246:2024 and the date of withdrawal of IS 14246:2024 is **08<sup>th</sup> August 2024**.
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.

<b>Clause(s) as per IS 14246:2023</b>	<b>Change</b>
4.1 Steel Base	Reference to IS 513 has been omitted
4.3 Organic Coating	Minimum Primer Coating for each surface for Class 2, Class 3 and Class 4 has been specified  Minimum Top Side and Bottom Side Coating has been specified separately for Class 1 and Class2,Class3, Class 4  Requirements of Triple Spot Coating Thickness and Single Spot Coating Thickness have been added  Product with organic coating on only one surface has been classified as Class "0"
4.4 Dry Film Thickness	A new clause specifying test method for measurement of dry film thickness of paint coating has been added
4.5 Profiles	A new clause has been added specifying that pre-painted galvanized steel sheets can also be supplied in profiles
Note 2, Table 1, Cl.5., Classification of Durability of Paint Coating	A new note has been added specifying that the Durability tests specified in the table are for information and are not mandatory at the time of production/coating
6.4.3 Impact Resistance Test	A new clause has been added specifying that this test is applicable for minimum base cold-rolled steel thickness of 0.40 mm
6.4.6 Solvent Resistance Test	A new clause regarding Solvent Resistance Test has been added and its test method has been specified at Annex B
Table 4, 8.1 Salt Spray Test(Corrosion Resistance)	Requirements for Salt Spray Resistance Test have now been specified at Table 4
Table 5, 8.2 Salt Spray	Requirements for Humidity Resistance Test have now been specified

Test(Corrosion Resistance)	at Table 5
9.1,9.4.1 Dimensions and Tolerances	IS 513 has been replaced by IS 277
9.6 Dimensions and Tolerances	A new clause has been added stating that dimensions and tolerances of sheets of profiles shall be as agreed to between the manufacturer and purchaser
10.1,10.2, Camber, Deviation from Squareness (Out of Shape),Shape	Reference to IS 513 has been replaced by IS/ISO 16163
Annex C,Methods of Assessment of Salt Spray and Humidity Test Result	A new Annex has been added

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 14246 has been revised which is being circulated separately.

5. The guidelines for implementation of the revised Standard is given below:

**A. LICENSEES:**

**i) Switchover of existing Licences of IS 14246:2013 to IS 14246:2024:**

Consequent to revision of IS 14246:2013 to IS 14246:2024, a no. of technical changes have been introduced such as the requirements of Organic Coating have been modified, Test Method for measurement of Dry Film Thickness has been specified, Solvent Resistance Test has been added,the Durability Requirements have now been specified for information/guidance only and other profiles of sheets (apart from Plain) have been permitted.

Thus, Existing Licensees of IS 14246:2013 shall be required to submit the following evidence(s) of conformity to their respective BOs for switchover to revised IS 14246:2024:

**a) Test Equipment List (in the format Form-II) as per revised IS 14246:2024.**

**b) In-house/Independent Test Report of the Durability Classes, covered in the existing scope of licence, as per revised IS 14246:2024.**

ii) On receipt of the above evidences of conformity from the licensees, BOs shall issue endorsement for switchover of licence to revised IS 14246:2024.

iii) Licensees intending to include profiles of sheets (other than plain) in the scope of the licence shall be required to submit an application for inclusion of each profile, to their respective BOs. The requirements of each profile (as per agreement between the manufacturer and purchaser) shall be declared by the licensee. Further, independent test report of each profile as per the requirements of IS 14246:2024 including evidence of conformity of imposed load on roofs as per cl.4.2. of IS 875 (Part 2) shall be submitted along with the inclusion application. BOs shall process the inclusion application as per the existing Guidelines for Change in Scope of Licence (CSoL).

iv) All Licensees shall implement the revised Standard by **08<sup>th</sup> August 2024**. 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 **08<sup>th</sup> August 2024**. **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.**

iv) 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 upto **07<sup>th</sup> August 2024** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **08<sup>th</sup> August 2024**.
3. Beyond **08<sup>th</sup> August 2024** 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 **08<sup>th</sup> August 2024** whichever is earlier.
3. The above guidelines come into force with immediate effect.

Shivam Ahuja  
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