

केन्द्रीय मुहर विभाग -2

कें.मु.वि - 2/16: 3327

दिनांक 24/09/2025

विषय: संशोधित आई एस IS 3327 : 2025 के अनुपालन के दिशानिर्देश

- 1) यह उपरोक्त विषय के संदर्भ में है।
- 2) सक्षम अधिकारी द्वारा अनुमोदित दिशानिर्देश अनुपालन हेतु संलग्न है।
- 3) सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की दिशानिर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

(अमित चौधरी)
वैज्ञानिक ई

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/FAD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 3327

24/09/2025

Subject: Guidelines for Implementation of revised IS 3327: 2025 (Pedal-Operated Paddy Threshers– Specification).

1. This has reference to the subject mentioned above.
2. The Competent Authority has approved the enclosed Guidelines for implementation.
3. All BOs are requested to inform the Applicants and Licensees under their jurisdiction about implementation of the revised Standard.

(Amit Choudhary)
Scientist-E

Head(CMD-2)

All ROs/BOs/ FAD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 3327

24/09/2025

Subject: Guidelines for implementation of revised IS 3327: 2025 (Pedal-Operated Paddy Threshers— Specification).

1. IS 3327: 1982, Pedal-Operated Paddy Threshers — Specification, has been revised to IS 3327: 2025.
2. IS 3327: 1982, Pedal-Operated Paddy Threshers — Specification, and IS 3327: 2025 are under concurrent running till 22 November 2025 and the last date for implementation of revised IS 3327: 2025 is **22 November 2025**.
3. The product is under Voluntary certification. There are currently 05 Licences in India for IS 3327: 2025, all under KKBO. There is no application pending for GOL in India against the IS.
4. The major changes in IS 3327: 1982 due to the revision in comparison to IS 3327: 2025 are given below for general guidance:

Major Changes in IS 3327: 2025 in comparison to revised IS 3327 : 1982

Clause	Changes
6.1.2, 6.1.3, 6.2.1	The upper limit of thickness range of side boards, front grain shield and slat made of mild steel sheet has been increased from 0.8 to 1.0, and the thickness range now specified is 0.5 mm to 1.0 mm .
5, Table 1	Under Materials for Various Components , material of EN8D C45 and Forged mild steel has been added respectively for Threshing teeth and Gears. Also, additionally GI sheet has been included as a material under the two components a) Front grain shield, and b) Rear grain shield, along with its applicable IS.
6.3	Under the note of the CI the operating speed of the thresher has been modified from <i>400 rev/min to 250 rev/min to 300 rev/min</i> . The note now reads as “The thresher is normally operated with a speed of 250 rev/min to 300 rev/min.”
6.3.1	The Gear ratio has been modified from 3·5:1 to 4 : 1 .
6.3.2	The minimum diameter of bar for the crank has been modified from 9 to 10 mm
6.5	A new clause on the requirement for Lifting Handle has been added
8.3	Under the clause, reference to <i>IS 12239 (Part 1) or IS 16814</i> has been added for information.
11	Marking requirement for Batch or code number, Size of drum, Type and “Any other markings required under the <i>Standards of Legal Metrology (Packaged Commodities) Rules, 2011</i> and any other statutory requirement”, have been added.

5. The existing Product manual has been revised to incorporate the changes due to the revised IS and it is being circulated separately, through BIS website, as Product Manual Doc: PM/IS 3327/2 September 2025.
6. The guidelines for implementation of the revised IS are as given below:
 - A. LICENSEES:
 - a) Licensee shall implement the revised Indian Standard by 22 November 2025. Any difficulty in implementation shall be brought to the notice of CMD-2 within 30 days from the date of issuance of these guidelines. BO shall ensure that the no Licence is under operation as per IS 3327: 1982 (old standard) after 22 November 2025. The status of implementation

of the revised Indian Standard shall be confirmed by Head (BO) to CMD-II within two weeks of the last date of implementation of concurrent running.

- b) Inclusion of the requirement for **Lifting Handle** and modification in Gear ratio from **3:5:1** to **4 : 1** are the important changes in the revised IS. Licensee is required to submit evidence of conformity through In-house Test Reports.
- c) Verification of implementation of IS 3327: 2025, shall be done through a surveillance visit preferably within 30 days of confirmation of implementation of the standard by licensee.
- d) If the Licensee fails to complete all actions by 22 November 2025, it shall be dealt with as per the prevailing guidelines.

B. APPLICATIONS FOR GRANT OF LICENCE:

- a) Existing Applications for GOL where Sample has been tested in the factory, may be processed as per the old standard i.e. IS 3327: 1982. A declaration may be obtained from the Applicant that the Licence, if granted shall be switched over to IS 3327: 2025 before the last date of concurrent running of the ISs. BOs shall ensure that such licenses granted are switched over to the IS 3327: 2025 before the last date of withdrawal of IS 3327: 1982 i.e., 22nd November 2025. If, however, the Applicant is desirous of considering the Application as per IS 3327: 2025, a declaration may be obtained from the Applicant to the effect and the Application may be processed accordingly. An undertaking from such Applicants shall also be obtained that if the sample fails considering IS 3327: 2025, Licence will not be granted by BIS as per IS 3327: 1982.
- b) Applications which are recorded henceforth may be processed as per the IS 3327: 1982/ IS 3327: 2025. Processing of Applications as per the old Standard, shall be permitted only upto 22 November 2025. For such cases Applicant shall give a declaration that they will switchover to IS 3327: 2025 by 22 November 2025.
- c) Beyond 22 November 2025, no Licence shall be granted as per IS 3327: 2025.

C. CHANGE IN SCOPE OF LICENCE:

- i. For change in scope of licence, the relevant provisions as given above for Applicants shall apply.
 - ii. 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 switchover to the IS 3327: 2025.
7. BOs are requested to circulate this guideline to licensees and applicants immediately within 7 days of issuance of this circular.
8. The above guidelines come into force with immediate effect.

(Amit Choudhary)
Scientist E

Head (CMD-2)

DDG(Certification)

Circulated to:

All RO/BOs

All other concerned - through BIS intranet