

केन्द्रीय मुहर विभाग -2

संदर्भ -: के मू वी-2/16:7328

14 09 2022

विषय: IS 7328:2020 के amendment no. 2 के अनुपालन के दिशा निर्देश

यह उपरोक्त विषय के संदर्भ में है।

सक्षम अधिकारी द्वारा अनुमोदित दिशा निर्देश अनुपालन हेतु संलग्न है ।

सभी क्षेत्रीय/शाखा कार्यालयों से अनुरोध है की दिशा निर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

आदित्य दास
वैज्ञानिक D

प्रमुख (के मू वी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/ PCD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:7328

14 09 2022

Subject: Guidelines for implementation of amendment no. 2 to IS 7328:2020

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.

(Aditya Das)
Scientist D

Head (CMD-2)

All ROs/BOs/Labs/PCD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:7328

Date: 14 09 2022

Subject: Guidelines for implementation of Amendment no. 2 to IS 7328:2020 – SPECIFICATION FOR POLYETHYLENE MATERIAL FOR MOULDING AND EXTRUSION

1. Amendment no. 2 to IS 7328:2020 has been published. The amendment shall be implemented with effect from 1 Feb 2023 i.e. the standard without the amendment as mentioned above shall remain in force till **1st Feb 2023**.
2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the above amendment within a week of issuance of these guidelines.
3. The significant changes in the standard through this amendment 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 amendment.

Clause	Change
-	In the foreword, two new paras have been added regarding polyethylene manufacturing process and stating that Since polymerization is a continuous process, during transition from one grade to another, there will be virgin polymer grades produced with broad melt flow index and density range with respect to declared specifications by respective resin manufacturers and will be classified as blending resins or grades. These grades are used as blends with other polymer grades by the converters in various applications without affecting performance in the intended end-use application
3	Under terminology clause, the definition for LDPE, LLDPE, and HDPE has been modified essentially to clarify that the density ranges specified for these polymers is indicative and to remove the definitions of type and acceptance tests
4.2.3	For data block 3, Code used for the intended application or method of Processing, the application for Code Z has been changed from "Others" to "Blending/Miscellaneous "
4.3	Typical Example of Designatory Code has been modified (Correction)
5.2.1.1, Para 1	Clause on Density has been modified to clarify that Density of the material shall be designated " as per table 1 , based on the value as agreed between purchaser and supplier" instead of "as agreed between the purchaser and the supplier"
5.2.1.1, Para 4	New clause has been inserted to state that in case of resin or grade used for blending application , designation code of density in data block 4 shall be based on the actual tested value for density of particular batch/lot and 'intended application or method of processing' will be codified as 'Z' (clause 4.2.3).The value of density may vary up to ± 8 Kg/m ³ from the measured/reported value

5.2.1.2, Para 1	Clause on Melt Flow Rate (MFR) / Melt Flow Index (MFI) has been modified to clarify that “The melt flow rate/melt flow index of the material shall be designated as per Table 3 , based on the value as agreed between purchaser and supplier” instead of “as agreed to between the purchaser and the supplier”
5.2.1.2, Para 2	New clause has been inserted to state that In case of resin or grade used for blending application , designation code of melt flow index in data block 4 shall be based on the actual tested value for melt flow index of batch/lot ‘intended application or method of processing’ will be codified as ‘Z’ (clause 4.2.3). The value of melt flow rate may vary up to ± 40 percent from the measured/reported value.’
5.3	The clause has been renamed from “Additional Requirements” to “Additional Requirements for Compounded Materials” Under 5.3.1, Additional properties to be selected as per 5.3.2 the term “compounded material” has replaced “compounds or an article” Under 5.3.2, the clause has been modified to state that “The typical additional properties as given in Table 6 shall be as agreed between purchaser and supplier based upon the requirements of end product properties”
5.4.6	For Dispersion of Carbon Black for Black Compound, the clause number has been changed from 5.5.6 to 5.4.6 (correction)
5.5.3	A new clause has been added to specify that The requirements mentioned in 5.5.2 i.e. Special Requirements of Polymer Used for Molding or Extrusion Articles in Contact with Food Stuffs, Pharmaceutical and Drinking Water will remain valid as long as the chemical composition and manufacturing process remains the same. In case of any change in chemical composition and/or manufacturing processes, the requirements mentioned in 5.5.2 shall be tested.’
6	The references to type tests and acceptance tests has been removed. It has been now stated under 6.1 that for product approval in the manufacturing of LDPE/LLDPE/HDPE materials and the compound made thereof, Density and Melt flow rate or melt flow index shall be tested. Under 6.2 - Product Identification Tests for Compounded Materials, it has been specified that For the compounded materials to establish the end use application properties, the applicable requirement as listed in 5.3.2 shall be tested, by correlating the required properties of the compounded materials
Annex B	Annexure on PRODUCT TYPE APPROVAL process has been removed
ANNEX D	In ANNEX D, clause reference has been changed from 6.4.2 to 5.5.2 (correction) and it has been added at the end that “The sample preparation shall be as per the intended end-use of material”

4. The existing product manual has been revised to incorporate the amendment and it is being circulated separately through BIS website

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

A. LICENSEES:

i) All Licensees shall implement the amendment by **1st Feb 2023**. 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 IS 7328:2020 without the amendment after **1st Feb 2023**. **The status of implementation of the amendment shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.**

ii) **Manufacturers who are making resin or grade used for blending application shall be required to get the same included in the scope of their licence within 1st Feb 2023. However, licensees who are not making resin or grade used for blending application are not required to submit any evidence of conformity to the requirements of the standard with amendment, since there is no change with respect to the existing grades.**

B) APPLICATIONS FOR GRANT OF LICENCE:

i) Existing Applications where Sample has been submitted in the Laboratory/Test Report has been issued by the Laboratory may be processed without consideration of the amendment. However, if the Applicant is desirous of considering the amendment, 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 while considering the provisions of the amendment, Licence will not be granted as per the old version.

ii) Applications which are recorded henceforth may be processed with or without consideration of the amendment. Processing of Applications without consideration of the amendment shall be permitted only up to 31 Jan 2023 and for such cases Applicant shall give a declaration that they will implement the amendment by **1st Feb 2023**.

iii) Beyond **1st Feb 2023** no Licence shall be granted without consideration of the amendment.

C) CHANGE IN SCOPE OF LICENCE:

i) For change in scope of licence, the relevant provisions as given above for Applicants shall apply.

ii) **For the purpose of addition of new grades in the scope of licence, Licensees who already have Special Requirements of Polymer Used for Molding or Extrusion Articles in Contact with Food Stuffs, Pharmaceutical and Drinking Water covered in the scope of their licence need not submit evidence of conformity to these requirements again subject to confirmation that there is no change the chemical composition and manufacturing process.**

iii) However, processing of such applications for change in scope of licence without consideration of the amendment shall be permitted only upto the date of implementation of the amendment by the licensee or upto **1st Feb 2023** whichever is earlier.

6. The above guidelines come into force with immediate effect.

Aditya Das
Sc. D

Head (CMD-2)
DDG (Certification)