

केन्द्रीय मुहर विभाग -2

संदर्भ -: के.मू.वि. -2/16: 2507

18 05 2026

विषय: संशोधित IS 2507:2026 के अनुपालन हेतु 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।

**रंजीत कुमार
वैज्ञानिक 'ई'**

प्रमुख (के.मू.वि. - 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:2507

18 05 2026

Subject: Guidelines for implementation of Revised IS 2507:2026.

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.

**(Ranjit Kumar)
Scientist 'E'**

Head (CMD-2)

All ROs/BOs/Labs/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref:CMD-2/16: 2507

Date: 18 05 2026

Subject: Guidelines for implementation of Revised IS 2507:2026 (Cold-Reduced Carbon and Alloy Steel Sheets and Strips) and switchover of BIS licence from IS 7226:1974 to revised IS 2507:2026.

1. IS 2507:1975 ‘Specification for Cold-Rolled Steel Strips for Springs’ has been revised and published as IS 2507:2026 ‘Cold-Reduced Carbon and Alloy Steel Sheets and Strips — Specification’. This standard will also supersede IS 7226 : 1974 ‘Specification for Cold-Rolled Medium, High Carbon and Low Alloy Steel Strip for General Engineering Purposes’ as all its requirements have been amalgamated in the revised standard. The last date for implementation of the revised Standard is **23th August 2026** after which the old Standards shall stand withdrawn.
2. All BOs shall inform the Applicants and Licensees under their jurisdiction about implementation of the revised Standard within a week of issuance of these guidelines.
3. The significant changes in the revised Standard as listed in the Table below 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.

Clause (s) /Table (s) as per	Change
IS 2507:2026	
Title	Since two standards i.e. IS 2507:1975 and IS 7226:1974 have been merged to revised IS 2507:2026, the title of the standard has been modified from “Specification for Cold-Rolled Steel Strips for Springs” to “ Cold-Reduced Carbon and Alloy Steel Sheets and Strips —Specification ” Comparison of existing grades of IS 2507 : 1975 and IS 7226 : 1974 with revised grade designations has been added in Annex B of IS 2507:2026 for reference.
1 Scope	The scope of this standard has been broadened to cover cold rolled low carbon, medium carbon and high carbon and alloy steel sheets and strips for wide range of applications in place of the earlier provisions which were limited to cold-rolled steel strips for the manufacture of springs for various purposes.
3 Terminology	A new clause 3 on Terminology has been introduced.

<p>4 Classification and Designations</p>	<p>A number of new grades of carbon and alloy steels have been incorporated in the revised standard, thereby significantly expanding the range of materials covered. Consequent to this revision, the earlier table specifying chemical composition has been removed, and instead, a reference to IS 19608 (Hot-Rolled Carbon and Alloy Steel Plates, Sheets and Strips) has been provided for the relevant steel grades designations & chemical composition requirements.</p>
<p>5 Supply of Material</p>	<p>The clause with respect to Supply of Material has been modified and accordingly, the strips may be supplied with mill, trimmed or different kinds of edges as mentioned in Table 6.</p> <p>Further, the requirement of additional surface conditions and surface finishes have also been added. Accordingly, Strips may be supplied with different kinds of surface appearance and finishes as mentioned in Table 7 and Table 8 respectively.</p>
<p>8 Dimensions and Tolerances</p>	<p>The clause has been modified to provide that Products exceeding 600 mm in width or 6 mm in thickness may also be supplied by mutual agreement between the purchaser and the manufacturer. For these products, acceptance criteria will be determined based on the agreement between the purchaser and the manufacturer.</p> <p>Tolerances on Thickness, Width and Camber have been modified (Table 9 to Table 12 & Table 14) and since Sheets has also been included in the revised standard, the length tolerances for cut length have also been added (Table 13).</p>
<p>10 Mechanical Properties</p>	<p>Since in the revised standard cold-reduced sheets and strips are classified into non-alloy and alloy categories as specified under IS 19608, the corresponding hardness requirement and Tensile Properties have also been specified in new table (Table 1 to Table 4)</p>
<p>11 Grain Size</p>	<p>A new clause 11 has been added which specifies the grain size requirements which may be agreed upon between the purchaser and the supplier at the time of ordering.</p>

12 Non-Metallic Inclusions	A new clause specifying the requirement of Non-Metallic Inclusions have been added.
13 Decarburization	A new clause specifying the requirement of Decarburization have been added.
14 Spheroidization of Carbides	A new clause specifying the requirement of Spheroidization of Carbides, if agreed upon between the purchaser and the supplier, have been added.
16.4 Surface Protection	A new clause specifying requirement of Surface Protection has been added.
18 Marking	The marking clause has been modified to include the details of 'weight or mass of the product-coil or packet/bundle' in addition to the existing details.

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 2507 has been revised which is being circulated separately.

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

A. LICENSEES:

(i) All Licensee of **IS 2507:1975 & IS 7226:1974** shall switch over to IS 2507:2026 by **23rd August 2026**. Any difficulty in implementation shall be brought to the notice of CMD-2 immediately after issuance of these guidelines, and in any case, not later than seven days prior to the implementation date. BOs shall ensure that no Licences are under operation as per old Standard after **23rd August 2026**. The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within one week of the last date of concurrent running.

ii) For switchover to revised standard IS 2507:2026, Licensees shall be required to classify the grade designation(s) covered under the existing scope of licence and re-designate them as per ANNEX B of IS 2507:2026. Subsequently, licensees shall submit declaration with regards to their equivalent scope of licence as per IS 2507:2026 (Refer Scope of Licence specified in the Product Manual of IS 2507:2026). BOs shall align the scope of licence of the licensee with the scope defined in the latest Product Manual. Licensees shall also be required to submit evidence of conformity to the additional/modified requirements of re-designated grade designations (as applicable) through In-house/Independent Test Reports. Further, Licensee shall be required to submit declaration for additional Testing equipment/arrangement in Form no. II as applicable.

iii) If the licensee fails to complete all actions by **23rd August 2026** it shall be dealt with as per the prevailing guidelines.

iv) If the Licensee is holding licences for both IS 2507:1975 & IS 7226:1974, licence number of IS 2507 shall be retained and licence as per IS 7226 shall be cancelled. Further, if the licensee fails to give acceptance to revised SIT within the stipulated time norm, action shall be taken as per the prevailing guidelines.

v) 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:

i) 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.

ii) 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 up to **22nd August 2026** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **23rd August 2026**.

iii). Beyond **23rd August 2026** no Licence shall be granted as per the old Standard.

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 implementation of the revised Standard or up to **23rd August 2026** whichever is earlier.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)

ROs/BOs