

केन्द्रीय मुहर विभाग-2

संदर्भ -: केमूवी-2/16:15392

02.05.2022

विषय: IS 15392 के संशोधन सं 1 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 दिशा निर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

(आदित्य दास)

वैज्ञानिक D

प्रमुख (केमूवी 2)

सभी क्षेत्रीय शाखाकार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:15392

02.05.2022

Subject: Guidelines for implementation of Amendment No.01 to IS 15392:2003

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/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:15392

Date: 02.05.2022

Subject: Guidelines for implementation of Amendment no. 1 to IS 15392:2003 – (Aluminum and Aluminum Alloy Bare Foil for Food Packaging)

1. Amendment no. 1 to IS 15392:2003 has been published. The amendment shall be implemented with effect from **04 October 2022**.
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
cl.1.	The scope has been amended to cover Aluminum and Aluminum Alloy Bare Foil for Food Packaging of thickness from 0.011 mm(11 µm) to 0.100 mm (100 µm)
cl.3.1	Definition of Bare Foil has been amended to be defined as a “cold rolled product of rectangular cross-section, having thickness from 0.011 mm but not greater than 0.100 mm, may be either in straight length or in coil from”
cl.10., Table 2	Nominal Thicknesses of 0.080 mm, 0.090 mm and 0.100 mm have been added in the table and their Nominal Covering Areas has been specified.
cl.13.1, Table 5	Nominal Thicknesses of 0.080 mm, 0.090 mm and 0.100 mm and their min. Breaking Loads have been specified

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

5. The above amendment has been issued in order to increase the range of thickness of aluminium foil covered in the standard up to 0.100 mm (100 µm) and specify requirements for the additional thicknesses. Accordingly, no changes are required to be made to the product or in manufacturing or testing equipment by the existing licensees/applicants and no evidence of compliance to the standard with amendment needs to be submitted by existing licensees/applicants.

6. However, in case licensees/applicants are manufacturing sizes above 0.075 mm up to 0.100 mm (100 µm), they shall be advised to apply for addition of these sizes the scope of their licence/application so that thicknesses above 0.075 mm up to 0.100 mm (100 µm) are covered in the scope of their licence within **04 October 2022**, and such applications shall be processed according to this amendment.

7. Although as per the extant grouping guidelines, one sample each of highest and lowest thickness is to be tested for inclusion of that range of thickness in the scope of licence, it is requested that for implementation of the amendment, licensees may be advised to submit test reports of only sample of the highest thickness (above 0.075 mm) which is intended to be covered in the scope, based on which such extension in the scope shall be permitted by BOs.

8. No licence shall be granted and/or application processed without considering this amendment from **04 October 2022**.

9. BOs are requested to circulate this amendment to all licensees/applicants at the earliest for their information and with a request to review the scope of their licence/application and apply for addition of new thicknesses in the scope of their licence/application, if applicable.

10. 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 15392:2003 without the amendment after **04 October 2022**. Verification of implementation of the amendment, wherever required, may be done during the next visit.

11. The above guidelines shall come into force with immediate effect.

Aditya Das

Sc.D(CMD-2)

Head (CMD-2)

DDG (Certification)

AMENDMENT NO. 1 APRIL 2022

TO

IS 15392 : 2003 ALUMINIUM AND ALUMINIUM ALLOY BARE FOIL FOR FOOD PACKAGING — SPECIFICATION

(Page 1, clause 1, line 4) — Substitute ‘0.100 mm (100 μm)’ for ‘0.075 mm (75 μm)’.

(Page 1, clause 3.1, line 2) — Substitute ‘from’ for ‘over’.

(Page 1, clause 3.1, line 3) — Substitute ‘0.100 mm’ for ‘0.075 mm’.

(Page 2, clause 10, Table 2) — Insert the following new preferred thickness:

SI No.	Nominal Thickness		Nominal Covering Area (m^2/kg)
	(mm)	(μm)	
(1)	(2)	(3)	(4)
xviii)	0.080	80	4.65
xix)	0.090	90	4.13
xx)	0.100	100	3.72

(Page 2, clause 13.1, Table 5) — Insert the following new Tensile Breaking Loads:

SI No.	Nominal Thickness		Breaking Load, Kg/cm of width <i>Min</i>
	(mm)	(μm)	
(1)	(2)	(3)	(4)
xviii)	0.080	80	3.63
xix)	0.090	90	4.09
xx)	0.100	100	4.54