

केन्द्रीय मुहर विभाग-2

संदर्भ -: केमूवी-2/16:5676

04 12 2023

विषय: IS 5676:1995 के amendment no. 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 दिशानिर्देशों का तत्काल प्रभाव से अनुपालन सुनिश्चित करें।

**आदित्य दास
वैज्ञानिक D**

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखाकार्यालय/प्रयोगशालाएँ/CHD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:5676

04 12 2023

Subject: Guidelines for implementation of amendment no. 1 to IS 5676:1995

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/CHD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 5676

04 12 2023

Subject: Guidelines for implementation of amendment no. 1 to IS 5676:1995 (Moulded rubber unit outsoles — Specification)

1. Amendment no. 1 to IS 5676:1995 has been published. The last date of implementation of the amendment is **5 July 2024**.

2. The significant changes in the standard through this amendment as listed in the Table are given for the purpose of general guidance.

Clause No.	Change
1	Title/scope has been changed from Moulded solid rubber soles and heels - Specification to Moulded rubber unit outsoles — specification
4	Clause 4 (classification of soles and heels into 2 types) has been removed
5.2	Clause 5.2 (Design) has been changed to “The soles shall have anti-slip design, or any other suitable design as agreed to between the purchaser and manufacturer.”
5.3	Clause 5.3 (construction) has been removed
5.4	Clause 5.4 (Size) has been changed from “The size of the soles and heels (see IS 1638 : 1969) shall be as agreed to between the purchaser and the supplier.” to “The soles manufactured in accordance with this standard may be made in all sizes as per IS 1638.”
5.5	Clause 5.5 (Thickness) has been changed from “For cleated or any other design as agreed to between the purchaser and the supplier, the minimum thickness of sole shall be as given in Table 1” to “ The minimum thickness of sole shall be 2 mm when tested in accordance with the test method prescribed in IS 15298 (Part 1) : 2015”
5.6, 5.6.1	Clause 5.6 and 5.6.1 (Channel) has been removed
6	Clause 6 (Packing and Marking) has been modified
8.1	Clause 8.1 has been changed from “Unless otherwise agreed to between the purchaser and the supplier all tests shall be carried out within 3 months from the date of receipt of the material by the purchaser.” to “Unless otherwise agreed to between the purchaser and the supplier, all tests shall be carried out within 3 months from the date of receipt of the material by the purchaser” (editorial change)
8.2	Clause 8.2 (Test pieces for physical tests) has been removed
Table 1	Table 1 for Thickness of Soles and Heels has been removed
Table 2	Table 2 for Physical Requirements for Moulded Rubber Unit Outsole as per the amendment has replaced Table 2 Physical Requirements for Soles and Heels, as per which <ol style="list-style-type: none">i) Requirement and Method of test for relative density has been changedii) Requirement and Method of test for hardness has been changediii) Bennewart method as per Annex D of IS 15844 (Part 1) has been added as an alternate method for testing flexing resistanceiv) Requirements for Abrasion resistance at applied force of 10 N and tear strength have been added

	v) Requirements (minimum limits) for tensile strength and elongation at break have been modified vi) Requirements for Change in initial hardness IRHD after ageing at 100 ±1°C for 24 h, Change in tensile strength and elongation at break after ageing at 70 ±1°C for 168 h and Compression set, have been removed.
8.4, 8.4.1 and 8.4.2	Clause 8.4, 8.4.1 and 8.4.3 for Measurement of thickness of soles and heels, has been removed
Annex A	References have been updated
B-1.1	For sampling, reference to size has been removed from the definition of a lot

3. Consequent upon the issuance of the amendment, the existing product manual has been revised which is being circulated separately.

4. The guidelines for implementation of the amendment are given below:

A. LICENSEES:

- i) All Licensees shall implement the amendment by **5 July 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 IS 5676:1995 without the amendment after **5 July 2024**. 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) Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports as well as revised declaration of test equipment as per form 2 (if applicable). Verification of implementation of the amendment, wherever required, shall be verified through a surveillance visit within 30 days of confirmation of implementation of the amendment to standard by licensee.
- iii) Scope of licenses as per amended standard shall be modified to align with the scope in revised product manual (i.e. product name shall be modified and reference to Type 1 and Type 2 shall be removed).
- iv) If the Licensee fails to complete all actions by **5 July 2024** it shall be dealt with as per the prevailing guidelines.

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 amended Standard, a declaration may be obtained from the Applicant to that effect and the Application may be processed accordingly. An undertaking shall from such Applicants also be obtained that if the sample fails while considering the provisions of the amended Standard, 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 amended Standard. Processing of Applications as per the old Standard shall be permitted only up to **4 July 2024** and for such cases Applicant shall give a declaration that they will implement the amended Standard by **5 July 2024**.
- iii. Beyond **5 July 2024** 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 amendment or up to **5 July 2024** whichever is earlier.

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

Aditya Das
Sc. D

Head (CMD-2)
DDG (Certification)

AMENDMENT NO. 1 OCTOBER 2023

TO

**IS 5676 : 1995 MOULDED SOLID RUBBER SOLES AND HEELS —
SPECIFICATION**

(Second Revision)

(Coverpage, Title) — Substitute the existing title for the following:

‘MOULDED RUBBER UNIT OUTSOLES — SPECIFICATION’

(Page 1, Title) — Substitute the existing title for the following:

‘MOULDED RUBBER UNIT OUTSOLES — SPECIFICATION’

(Page 1, clause 1) — Substitute the following for the existing:

‘This standard prescribes requirements, and methods of sampling and test for moulded rubber unit outsoles’

(Page 1, clause 4) — Delete.

(Page 1, clause 5.1, first line) — Delete ‘solid’.

(Page 1, clause 5.2) — Substitute the following for the existing:

‘The soles shall have anti-slip design, or any other suitable design as agreed to between the purchaser and manufacturer.’

(Page 1, Fig. 1) — Delete.

(Page 1, clause 5.3) — Delete.

(Page 3, clause 5.4) — Substitute the following for the existing:

‘The soles manufactured in accordance with this standard may be made in all sizes as per IS 1638.’

(Page 3, clause 5.5) — Substitute the following for the existing:

‘The minimum thickness of sole shall be 2 mm when tested in accordance with the test method prescribed in IS 15298 (Part 1) : 2015.’

(Page 3, clause 5.6 and 5.6.1) — Delete.

(Page 3, clause 6) — Substitute the following for the existing:

‘6 PACKING AND MARKING

6.1 Packing

The Outsoles may be packed as agreed to between the purchaser and the supplier. Each package may contain outsoles of same size only and may be marked with the name of the item, batch/code number, size, manufacturer’s name or its recognized trade-mark, if any.

Price Group 2

6.2 Marking

6.2.1 Each Outsole shall be marked legibly and indelibly with the following:

- a) Identification of source of the manufacturer or brand name, if any; and
- b) Size of the footwear for which it is intended.

6.2.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.’

(Page 3, clause 8.1) — Substitute the following for the existing:

‘Unless otherwise agreed to between the purchaser and the supplier, all tests shall be carried out within 3 months from the date of receipt of the material by the purchaser.’

(Page 3, clause 8.2) — Delete.

(Page 4, Table 1) — Delete.

(Page 4, Table 2) — Substitute the following for the existing table:

Table 2 Physical Requirements for Moulded Rubber Unit Outsole

(Clause 5.7)

SI No.	Characteristics	Requirement	Method of Test, Ref to IS
(1)	(2)	(3)	(4)
i)	Relative density, <i>Max</i>	1.3	Annex C-1 of IS 10702
ii)	Hardness, degree, Shore A	50 to 85	IS 12240 (Part 2)
iii)	Flexing resistance		
	Bennewart method, cut growth at the end of 30 000 cycles, mm, <i>Max</i>	6.0	Annex D of IS 15844 (Part 1)
	OR		
	Ross Flex method, cut growth at the end of 1 50 000 cycles, mm, <i>Max</i>	6.0	IS 3400 (Part 16)
iv)	Abrasion resistance at applied force of 10 N (Volume loss), mm ³ , <i>Max</i>	350	IS 3400 (Part 3)
v)	Tensile strength, MPa, <i>Min</i>	5.0	IS 3400 (Part 1)
vi)	Elongation at break, percent, <i>Min</i>	250	IS 3400 (Part 1)
vii)	Tear strength (average force), kN/m, <i>Min</i>	5.0	Method A of IS 3400 (Part 12)

(Page 5, clause 8.3, 8.4, 8.4.1 and 8.4.2) — Delete.

(Page 5, Annex A) — Substitute the following for the existing Annex A:

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS 1638 : 1969	Specification for sizes and fittings of footwear (<i>first revision</i>)	(Part 16) : 1974	Measurement of cut growth of rubber by the use of the ross flexing machine
IS 2050 : 1991	Glossary of terms relating to footwear (<i>first revision</i>)	IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 3400	Methods of test for vulcanized rubber:		
(Part 1) : 2021/ ISO 37 : 2017	Tensile stress-strain properties (<i>fourth revision</i>)	IS 10702 : 2023	Hawai chappal — Specification (<i>third revision</i>)
(Part 3) : 2021/ ISO 4649 : 2016	Abrasion resistance using a rotating cylindrical drum device (<i>third revision</i>)	IS 12240 (Part 2) : 1988	Methods of test for polyvinyl chloride boots: Part 2 Determination of durometer hardness, Shore A
(Part 12) : 2022/ ISO 34-1 : 2015	Tear strength — Trouser, angle and crescent test piece (<i>first revision</i>)	IS 15844 (Part 1) : 2023	Sports footwear: Part 1 General purpose (<i>first revision</i>)

(Page 5, clause **B-1.1**, line 2) — Delete “size”.