केन्द्रीय मुहर विभाग –2

संदर्भ -: केमूवी-2/16:4824 16-03-2026

विषय: **आई एस 4824:2022 के संशोधन संख्या 01 का कार्यान्वयन के लिए दिशानिर्देश ।**

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 (केमूवी 2)
सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:4824 16-03-2026

Subject: Guidelines for implementation of Amendment No.01 to IS 4824:2022.

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

OurRef:CMD-2/16:4824 **Date: 16-03-2026**

Subject: Guidelines for implementation of Amendment No. 01 to IS 4824:2022 (Bead Wire for Tyres)

1. Amendment no. 1 to IS 4824:2022 has been published. The last date for implementation of the amendment is **03rd June 2026**.

2. 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**
1 Scope	Clause 1.2 has been modified to expand the scope of the standard by including the requirement of flat wires as well, in addition to the existing round wires.
6 Chemical Composition	The Clause 6.1 has been modified to state that the ladle analysis of steel **should** be as given in Table 1. **However, any other chemical composition may also be permitted, if agreed upon between the purchaser and the manufacturer.** Further, under Table-1 the range of Carbon (%) for HT (High tensile strength) has been relaxed from '**0.77 to 0.90**' to '**0.70 to 0.90'**
Table 3 Requirements for Tensile Strength and Elongation	The requirements for tensile strength in Table-3 has been modified for round wire. Further, upon inclusion of flat wires in the scope of the standard, the requirements for tensile strength and elongation have also been added in Table 3.
7.3 Torsion Test	Clause 7.3 (Torsion Test) has been modified to state that **Torsion test shall not be applicable for flat wires.**
7.4 Protective Coating	Clause 7.4.1 has been modified to include Zinc coating on the wire as well, in addition to coating of low-tin bronze or high-tin bronze, brass or copper. However, However, zinc coating is applicable for flat wires only. The methods for determination of chemical composition of coating material other than XRF test method has also been allowed. Other established methods such as Atomic Absorption Spectrometry

	(AAS) or Titrimetric Method may also be used if mutually agreed between the purchaser and the manufacturer. Further, in addition to metallic coating, Coumarone Resin residue coating is also allowed based on mutual agreement between the purchaser and the supplier.
Table 5 Chemical Composition of the Coating	Upon inclusion of Zinc Coating for flat wires, the requirement of chemical composition of Zinc coating is also added in the Table 5.
Table 6 Coating Weight	Table 6 (Coating Weight) has been modified to specify the coating weight based on diameter ranges, whereas earlier the coating weight was specified without reference to diameter ranges. Further, upon inclusion of Zinc coating for flat wires, the requirement of coating weight of Zinc has also been added in Table 6.
7.6 Dimensions and Tolerances	Upon inclusion of flat wires in the scope of the standard, the requirement of dimensions and tolerances for flat wires have also been added under clause 7.6.1 & 7.6.2 respectively.
7.6.4 Requirements for Adhesion	The clause 7.6.4 has been modified and now the method for adhesion test other than specified in Annex A is also allowed as per mutual agreement between the purchaser and the manufacturer.
8.3 Protective Coating test	Clause 8.3 has been modified to include alternate method (Other than XRF method specified in Annex B) for checking coating weight for brass or zinc coating. **Now For brass or zinc coating, coating weight shall be checked either by XRF method (Refer Annex B) or any other established method such as Atomic Absorption Spectrometry (AAS) or Titrimetric method as per mutual agreement between the purchaser and the manufacturer.**
Annex A Method for Adhesion Test Between Wire and Rubber	The design of mould has been modified. Now the mould is designed for a **12.5 mm** thick block of rubber, **200 mm** long and 50 mm wide across the short dimension of the mould, in place of the earlier specification of a 13 mm thick block of rubber, 205 mm long and 50 mm wide across the short dimension of the mould.
Annex B Test Methods to Determine Coating Weight for Copper and Bronze Coating	A new clause B-1.8 has been introduced specifying testing steps for XRF Equipment Which Can Measure Radiation Intensity Directly from Solid Sample (Without Dissolution into Stripping Solution).

3. Consequent upon the issuance of aforementioned amendment, the existing product manual of IS 4824:2022 has been revised which is being circulated separately.

4. The guidelines for implementation of amendment no 01 to the IS are given below:

A. LICENSEES:

i) All Licensees shall implement the amendment by **03rd June 2026**. Any difficulty in implementation shall be brought to the notice of CMD-2 immediately after issuance of these guidelines. BOs shall ensure that no Licences are under operation without this amendment after 03rd June 2026. The status of implementation of the amendment shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of implementation.

ii) Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports.

iii) Licensee intending to include the new variety i.e Flat Wire in the scope of the licence may submit an application for inclusion of these varieties to their respective BOs. Inclusion shall be processed as per existing Guidelines for Change in Scope of Licence (CSoL).

iv) BOs shall plan an early surveillance visit for verification of the implementation of the amendment preferably within 30 days from confirmation of implementation of the amendment to standard by licensee.

v) If the Licensee fails to complete all actions by 03rd June 2026, 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 IS with/without the amendment. However, if the applicant is desirous of considering the application, with the amendment to the IS, 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 IS incorporating the amendment, Licence will not be granted by BIS without considering the amendment.

ii) Applications which are recorded henceforth may be processed with or without considering amendment to the IS. Processing of applications without considering the amendment, shall be permitted only up to 02nd June 2026 and for such cases Applicant shall give a declaration that they will implement the amendment by 03rd June 2026.

iii). Beyond 03rd June 2026, no Licence shall be granted without considering 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) However, processing of such applications for change in scope of licence without considering the amendment shall be permitted only up to the date of implementation of the amendment or up to 03rd June 2026 whichever is earlier.

5. BOs are requested to circulate these guidelines to licensees and applicants under their jurisdiction immediately within 7 days of issuance of this circular.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)