



केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-३/१६: भा.मा. 14407

१० सितम्बर २०२६

विषय: अनुपालन हेतु गाइडलाइन

सभी शाखा कार्यालयों से आग्रह है कि संलग्न गाइडलाइन का अनुपालन तत्काल प्रभाव से सुनिश्चित करें।

(गोथम बी जे)
वैज्ञानिक-डी/संयुक्त निदेशक

प्रमुख (के मु वि III)

सभी क्षेत्रीय/शाखा कार्यालय

CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-3/16: IS 14407

10 September 2026

Subject: Guidelines for implementation of Amendment no. 1 to IS 14407: 2023 - "Aluminium Cans for Beverages"

This has reference to the subject mentioned above.

BOs may kindly ensure implementation of the attached guidelines with immediate effect.

(Gowtham B J)
Scientist-D/Joint Director

Head (CMD - III)

Circulated to: All ROs/BOs

CENTRAL MARKS DEPARTMENT-III

Our Ref: CMD-3/16: IS 14407

10 September 2026

Subject: Guidelines for implementation of Amendment no. 1 to IS 14407: 2023 - "Aluminium Cans for Beverages"

1. Amendment no. 1 to IS 14407: 2023 has been published. **The last date for implementation of the Amendment is 19 January 2027.**
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 brought in the Standard through this Amendment as listed in the Table is given for the purpose of general guidance. BOs shall ensure that the product conforms to all the requirements, as applicable, as per the Standard read in conjunction with the Amendment.

Sl. No.	Cl. Ref.	Changes in Standard after this amendment	Actions required from existing licensees/BOs
1	5.1, Material	'Can End stock' has been modified as 'Can Shell stock'.	Conformity to new and modified requirements shall be established by manufacturers either through in-house or TPT lab test report, as applicable. Licensees shall declare the revised scope of licence in line with the latest Product Manual, which shall be reviewed by the BOs.
2	Table 1B, Composition of Aluminium Alloy	In title of the table, 'Can End Stock (Shell)' has been modified as 'Can Shell stock'.	
3	5.2, Temper of Aluminium Alloy	In second row of the table, 'End' has been modified as 'Shell'. In third row of the table, Temper H18 & H19 has been newly added for Tab.	
4	5.3, Mechanical Properties for alloys	'Closure' has been modified as 'Shell and Tab'.	
5	Table 2B, Mechanical Properties of Aluminium Alloy	In title of the table, 'Can Closure' has been modified as 'Can Shell and Tab'. Also, Mechanical Properties for H48 and H49 has been defined.	
6	6.1.2.3, Can Ends	'closure components' has been modified as 'can end'.	
7	Col (4) of Table 3, Dimensions of Aluminium Beverage Cans	Requirement for Finished Can Height (A) has been modified for Nominal Capacity 150 ml (Slim) and 355 ml (Standard)	
8	Col (4) of Table 4, Dimensions for Can Ends	Requirement for Outside Curl Diameter (A) has been modified for Can End Type B64 for sizes 200 and 202 & Can End Type CDL for size 202	
9	Col (6) of Table 4, Dimensions for Can Ends	Requirement for Curl Height (C) has been modified for Can End Type B64 for size 200 & Can End Type CDL for sizes 200 and 202	
10	Col (7) of Table 4, Dimensions for Can Ends	Requirement for Inside Curl Diameter (E) has been modified for Can End Type B64 for sizes 200 and 202 & Can End Type CDL for sizes 200 and 202	
11	Col (8) of Table 4, Dimensions for Can Ends	Requirement for Countersink Depth (D) has been modified for Can End Type B64 for sizes 200	

4. Consequent upon publication of the Amendment, existing Product Manual has also been revised as **PM/IS 14407/4/Sep 2026**. In this revision, changes have been made in Scope of licence, Grouping Guidelines and Scheme of Inspection and Testing.

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

A. LICENSEES:

- (i) All Licensees shall implement the Amendment by **19 January 2027**. Any difficulty in implementation shall be brought to the notice of CMD III within 30 days of issuance of these guidelines. BOs shall ensure that no Licences are under operation without this Amendment to the Standard after **19 January 2027**. The status of implementation of the Amendment shall be confirmed by Head (BO) to CMD-III within two weeks of the last date of concurrent running.
- (ii) In order to establish conformity to this Amendment, licensee shall submit in-house or independent test report, as applicable, of the product to **new and modified requirements**, as applicable to the varieties covered, as evidence of conformity to the Amendment.
- (iii) All licensees shall declare the revised scope of licence in line with the latest Product Manual, which shall be reviewed by the BOs.
- (iv) Verification of implementation of this Amendment, shall be done during the next visit.
- (v) If the Licensee fails to complete all actions by **19 January 2027**, 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 without this Amendment. However, if the Applicant is desirous of considering the application with this 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 this Amendment, Licence will not be granted without this Amendment.
- (ii) Applications which are recorded henceforth may be processed with or without this Amendment. Processing of Applications without this Amendment shall be permitted only up to **19 January 2027** and for such cases Applicant shall give a declaration that they will implement the Amendment by **19 January 2027**.
- (iii) Beyond **19 January 2027**, no Licence shall be granted without considering this 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 this Amendment shall be permitted only up to the date of implementation of the Amendment by the licensee or up to **19 January 2027**, whichever is earlier.

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

(Gowththam B J)
Scientist-D/Joint Director

Head (CMD III)
DDG (Certification)