



## केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-३/१६: भा.मा. 6455

१८ जून 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 6455

18 June 2026

**Subject: Guidelines for implementation of revised Indian Standard IS 6455: 2026 - "Single Row Deep Groove Ball Bearings"**

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 6455

18 June 2026

**Subject: Guidelines for implementation of revised Indian Standard IS 6455: 2026 - “Single Row Deep Groove Ball Bearings”**

1. IS 6455: 2020 has been revised and published as IS 6455: 2026. **The last date for implementation of the revised Standard is 27 August 2026.**
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 through this revision 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 revised Standard.

Sl. No.	Cl. Ref.	Changes in Revised Standard	Actions required from existing licensees/BOs
1.	Cl. 3 Terms and Definitions	Terms and definitions has been modified.	No actions required.
2.	Cl. 9 Surface Finish	Requirement of surface finish of the functional surfaces have been removed.	No actions required.
3.	Cl. 11 Load Rating	Clauses on Basic Dynamic Radial Load Rating and Basic Static Radial Load Rating modified such that these values shall be declared by the manufacturer.	Licensees shall submit declaration of Load Ratings and Designations to concerned BOs.
4.	Cl. 14 Designations	New clause has been added for the purpose of this standard	
5.	Cl. 4 Boundary Dimensions	Clause has been modified to permit dimensions as per IS 5669 for Radial Ball Bearings in addition to those in Table 1. Dimensions for Radial Bearings with Locating Snap Ring and Radial Bearings with Circlips are newly defined.	
6.	Cl. 7 Materials	Material for Rings have been added. Material for Cages have been modified. Material for Races and Balls have been removed.	
7.	Cl. 8 Radial Internal Clearance	Test Method for Radial Internal Clearance has been added.	Conformity to new and modified requirements shall be established by manufacturers either through in-house or TPT lab test report as per the new or modified test methods, as applicable. Scope of licence shall be reviewed by BOs as per revised Product Manual.
8.	Cl. 10 Hardness	Clause has been modified to include Hardness in Vickers Scale. Test methods for Hardness has been added.	
9.	Cl. 12.4 Temperatures	Clause has been modified to include test method and requirements.	
10.	Cl. 12.5 Protection against corrosion	Application of Rust Preventive oil has been included.	
11.	Cl. 13 Measuring and Gauging Methods	New clause has been added to define measuring and gauging methods.	
12.	Cl. 16 Marking	Country of Origin has been included in the Marking clause	

4. Consequent upon revision of the Standard, existing Product Manual has also been revised as *PM/IS 6455/3/June 2026*. In this revision, changes have been made in Scope of Licence, Grouping Guidelines, List of Test Equipments & 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 revised Standard by **27 August 2026**. 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 as per the old Standard after **27 August 2026**. The status of implementation of the revised Standard 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 revised Standard, licensee shall submit in-house or independent test report, as applicable, of the product to **new and modified requirements in line with the new and modified test methods** [*Boundary Dimensions (Cl. 4), Materials (Cl. 7), Radial Internal Clearance (Cl. 8), Hardness (Cl. 10), Temperatures (Cl. 12.4), Protection against corrosion (Cl. 12.5), Measuring and Gauging Methods (Cl. 13) and Marking (Cl. 16)*], as applicable to the varieties covered, as evidence of conformity to the revised Standard.
- (iii) Verification of implementation of the revised Standard, shall be done during the next visit **which shall be completed within one month from the date of submission of compliance by licensee.**
- (iv) If the Licensee fails to complete all actions by **27 August 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 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 while considering the provisions of the revised Standard, Licence will not be granted as per the old version.
- (ii) Applications which are recorded henceforth may be processed as per old or revised Standard. Processing of Applications as per the old Standard shall be permitted only up to **27 August 2026** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **27 August 2026**.
- (iii) Beyond **27 August 2026**, no Licence shall be granted without consideration of the revised 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 old Standard shall be permitted only upto the date of implementation of the revision by the licensee or up to **27 August 2026**, whichever is earlier.
6. The above guidelines come into force with immediate effect.

**(Gowtham B J)**  
**Scientist-D/Joint Director**

**Head (CMD III)**  
**DDG (Certification)**