

केन्द्रीय मुहर विभाग -2

संदर्भ :- के.मू.वि. -2/16 : 17111

03-12-2025

विषय: संशोधित IS 17111 : 2025 के अनुपालन हेतु 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।

**रंजीत कुमार
वैज्ञानिक 'ई'**

प्रमुख (के.मू.वि. - 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LRMD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 17111

03-12-2025

Subject: Guidelines for implementation of Revised IS 17111: 2025.

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

Our Ref:CMD-2/16 : 17111

Date: 03-12-2025

Subject: Guidelines for implementation of Revised IS 17111:2025 (Heat-Treatable Steels, Alloy Steels and Free-Cutting Steels — Ball and Roller Bearing Steels)

1. IS 17111:2019 has been revised and published as IS 17111:2025. This revision of IS 17111 replaces IS 17111: 2019 'Heat-treatable steels, alloy steels and free-cutting steels — Ball and roller bearing steels' and IS 4398: 1994 'Carbon — Chromium steel for the manufacture of balls, rollers and bearing races — Specification (second revision)'. IS 4398 shall stand withdrawn subsequently. The last date for implementation of the revised Standard is **23rd December 2025** after which the old Standard shall stand withdrawn.
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 in the revised Standard as listed in the Table below are 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.

Clause (s) as per IS 17111:2025	Change
Table 3	New grades i.e. 50CrMo4 under Induction hardening steel group and X30CrMoN15-1 under stainless steel group have been added.
7.2 Table 3 Chemical Composition	Requirements for Ca and Ti content have been added for through-hardening bearing steels. Requirements for Oxygen (O) content have been further restricted for through-hardening and induction hardening bearing steels. Earlier the O content for through-hardening and induction hardening bearing steels were 0.0015% max and 0.002% max respectively. Now, the O content is restricted to 0.0012% max for through-hardening steel and 0.0015% max for induction hardening bearing steels. Option for Hydrogen (H) content for premium bearing steels has been added for through-hardening, case hardening and induction-hardening bearing steels; and

7.3.1 Table A.1 Microscopic inclusions	Option for verification of microscopic inclusions in Table A.1 for through-hardening bearing steels has been revised.
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4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 17111 has been revised which is being circulated separately.

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

A. LICENSEES:

i) Switchover of Existing Licensees of IS 17111:2019.

a) For switchover to revised standard, Licensees shall submit evidence of conformity to the additional/modified requirements through In-house/Independent Test Reports.

b) All Licensees shall implement the revised Standard by **23rd December 2025**. Any difficulty in implementation shall be brought to the notice of CMD-2 immediately after issuance of these guidelines, and in any case, not later than seven days prior to the implementation date. BOs shall ensure that no Licences are under operation as per old Standard after 23rd December 2025. The status of implementation of the revised Standard shall be confirmed by Head (BO) to CMD-2 within one week of the last date of concurrent running.

ii) Switchover of Existing Licensees of IS 4398:1994 who does not hold licence as per IS 17111:

a) For switchover to revised standard IS 17111:2025, licensees shall be required to classify the steel grades/designations, covered under the existing scope of licence and re-designate them as per cl. 7.1.2 Table 3 & 4 of IS 17111:2025. Subsequently, licensees shall submit declaration with regards to their equivalent scope of licence as per IS 17111:2025 (Refer Scope of Licence specified in the Product Manual of IS 17111:2025).

b) Licensee shall submit declaration for additional Testing equipment in Form no. II as applicable.

c) Submit In-house/Independent Test Reports of the re-designated grades under applicable groups of steel as per IS 17111:2025.

iii) BOs shall plan an early surveillance visit for verification of the implementation of the revised standard preferably within 30 days of switchover by the licensee.

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 in new test requirements, 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 revised Standard. Processing of Applications as per the old Standard shall be permitted only up to 22nd December 2025 and for such cases Applicant shall give a declaration that they will implement the revised Standard by 23rd December 2025.

iii). Beyond **23rd December 2025** 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 revised Standard or up to 23rd December 2025 whichever is earlier.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)

ROs/BOs