

केन्द्रीय मुहर विभाग -2

संदर्भ -: के.मू.वि. -2/16 : 733

12-03-2026

विषय: संशोधित IS 733:2025 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-2/16:733

12-03-2026

Subject: Guidelines for implementation of Revised IS 733:2025.

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-2/16:733

Date: 12-03-2026

Subject: Guidelines for implementation of Revised IS 733:2025 (Wrought Aluminium and Aluminium Alloy Bars, Rods, Sections, Extruded Tubes, Hollow Sections and Profiles for General Engineering Purposes) and switchover of BIS licence from IS 1285:2023 to revised IS 733:2025.

IS 733:1983 has been revised and published as IS 733:2025. This standard will also supersede IS 1285: 2023 ‘Wrought Aluminium and Aluminium Alloys — Extruded Round Tube and Hollow Sections for General Engineering Purposes’.

2. IS 1285 : 2023 covers extruded round tubes and hollow sections for general engineering purposes whereas IS 733: 1983 covers bars, rods and solid sections for general engineering purposes. For all the specific information related to alloy composition and mechanical properties, IS 1285: 2023 gives reference of IS 733 : 1983. Furthermore, the manufacturing process, process flow, testing, in-process controls, etc. for both hollow and non-hollow extruded sections are similar. Therefore, the concerned committee felt that there is no need to have separate standards for hollow and non-hollow extruded sections. Accordingly, the revised IS 733 standard has been prepared by including the requirements for hollow and non-hollow extruded sections.

3. The last date for implementation of the revised Standard is **29th June 2026** after which the old Standards (IS 733:1983 & IS 1285:2023) shall stand withdrawn.

4. 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) /Table (s) as per IS 733:2025	Change
Title	Title of the standard has been modified from “Specification for Wrought Aluminium and Aluminium Alloy Bars, Rods and Sections (For General Engineering Purposes)” to “Wrought Aluminium and Aluminium Alloy Bars, Rods, Sections, Extruded Tubes, Hollow Sections and Profiles for General Engineering Purposes ”
1 Scope	The scope has been enhanced to include requirements for wrought aluminium and aluminium alloy extruded structural and seamless tubes (round and other than round), hollow sections and profiles for general engineering purposes as well, in addition to the existing requirements for bars, rods and sections.

4 Supply of Material	Reference to Indian Standard for General requirements for the supply of aluminium and aluminium alloy products has been modified from IS 1387 to IS 10259 .
5 Freedom from Defects	A new clause 5.2 specifying ‘Slight discoloration due to heat treatment, minor polishing marks and spiral marks due to roll straightening shall not be a cause for rejection’ has been added.
6 Chemical Composition	<p>In this revised version of the standard, the international alloy designations, many of which are widely used in the country, have been added. The Indian standard designations which were there in the previous version of this standard have been retained but they have been given new designations in line with the international system of nomenclature considering the nearest equivalent alloy.</p> <p>Earlier only 16 grades/alloy designations were specified. Now, in the revised standard total 08 series covering 249 different alloy designations have been specified which are as under:</p> <ul style="list-style-type: none"> (1) 1000 series (Al)- 23 Alloy designations (2) 2000 series (Al Cu)- 22 Alloy designations (3) 3000 series (Al Mn)- 17 Alloy designations (4) 4000 series (Al Si)- 17 Alloy designations (5) 5000 series (Al Mg)- 63 Alloy designations (6) 6000 series (Al Mg Si)- 60 Alloy designations (7) 7000 series (Al Zn)- 32 Alloy designations (8) 8000 series (Miscellaneous)- 15 Alloy designations <p>In view of the addition of new alloy designations, the Table on Chemical Compositions have also been modified.</p>
9 Dimensions & Tolerance	The clause 9 has been modified to include the dimensions & tolerances Extruded Tubes (Round & Other than round), Hollow Sections, Irregular Solid Sections and Profiles
10 Selection of Test Samples	The requirement of selection of test samples have been modified.

12 Packaging & Marking	<p>The packaging and marking requirements have been modified to include following additional information (highlighted in bold) to be legibly marked or printed on the product or package:</p> <p>a) Name of the manufacturer;</p> <p>b) Alloy designation;</p> <p>c) Condition of the material;</p> <p>d) Size or identification of size such as drawing number or profile identification number or section number; and</p> <p>e) Surface condition (type of surface coating, if any, to be mentioned).</p>
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5. Consequent upon the issuance of the revised Standard, the existing product manual of IS 733 has been revised which is being circulated separately.

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

A. LICENSEES:

i) All Licensee of IS 733:1983 & IS 1285:2023 shall switch over to IS 733:2025 by **29th June 2026**. 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 29th June 2026. 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) For switchover to revised standard IS 733:2025, Licensees shall be required to classify the alloy designations, covered under the existing scope of licence and re-designate them as per ANNEX B of IS 733:2025. Subsequently, licensees shall submit declaration with regards to their equivalent scope of licence as per IS 733:2025 (Refer Scope of Licence specified in the Product Manual of IS 733:2025). BOs shall align the scope of licence of the licensee with the scope defined in the latest Product Manual. Licensees shall also be required to submit evidence of conformity to the additional/modified requirements of re-designated alloy designations (as applicable) through In-house/Independent Test Reports.

iii) If the licensee fails to complete all actions by 29th June 2026 it shall be dealt with as per the prevailing guidelines.

iv) If the Licensee is holding licences for both IS 733:1983 & IS 1285:2023, licence number of IS 733 shall be retained and licence as per IS 1285 shall be cancelled. Further, if the licensee

fails to give acceptance to revised SIT within the stipulated time norm, action shall be taken as per the prevailing guidelines.

v) 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 28th June 2026 and for such cases Applicant shall give a declaration that they will implement the revised Standard by 29th June 2026.

iii). Beyond 29th June 2026 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 29th June 2026 whichever is earlier.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)

ROs/BOs