

केन्द्रीय मुहर विभाग -2

संदर्भ -: के.मू.वि. -2/16:10773

13- 03-2026

विषय: संशोधित IS 10773:2025 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-2/16:10773

13- 03-2026

Subject: Guidelines for implementation of Revised IS 10773:2025.

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-2/16:10773

Date: 13- 03 2026

Subject: Guidelines for implementation of Revised IS 10773:2025 (Wrought Copper Tubes for Refrigeration and Air-Conditioning Purposes).

1. IS 10773:1995 has been revised and published as IS 10773:2025. The last date for implementation of the revised Standard is **28th May 2026** after which the old Standard shall stand withdrawn.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) /Table (s) as per IS 10773:2025	Change
1 Scope	The scope has been enhanced to include requirements for inner groove tubes/fin tubes , in addition to the existing requirements for solid drawn (seamless) copper tubes..
3 Terminology	The terminology for ‘Inner Groove/Fin Tube’ and ‘Bottom Wall Thickness’ have been added and the requirement of ‘Mean Wall Thickness’ has been modified for more clarity.
5.1 Chemical Composition	The grades have been modified. In place of the two grades (Grade 1 and Grade 2) specified in the earlier version of IS 10773, the revised standard now specifies three grades, namely Cu-OF, Cu-DLP, and Cu-DHP . Accordingly, the chemical composition (Table 1) has also been modified.

<p>6 Manufacture</p>	<p>The requirements related to the process of manufacture have been modified to include ‘billet’ and ‘bars’, in addition to the existing ‘tube shell’, as inputs for drawing tubes.</p> <p>Further, the supply conditions have also been modified to include the ‘hard drawn’ condition, along with the existing supply conditions of ‘soft-annealed’, ‘light annealed’, and ‘light drawn’.</p>
<p>8.1 & Table 2 Tensile test</p>	<p>The requirement of tensile properties has also been modified.</p>
<p>9.1 and Table 3, Table 4 & Table 5 Dimensions and Tolerances for Smooth Tubes</p>	<p>New Table 3, Table 4 & Table 5 have been added specifying Tolerances on Mean Wall Thickness, Mean Outside Diameter and Length respectively for smooth Tubes.</p> <p>In the earlier version of IS 10773, the tolerances on mean wall thickness, mean outside diameter, straightness, and length were specified with reference to IS 5493.</p>
<p>9.2 and Table 6, Table 7 & Table 8 Dimensions and Tolerances for Inner Groove Tubes</p>	<p>With the inclusion of requirements for Inner Groove Tubes, new Table 6, Table 7, and Table 8 have been added specifying the tolerances for bottom wall thickness, mean outside diameter, and length, respectively.</p>
<p>8.2 & 8.3 Flattening Test & Drift Expanding Test</p>	<p>With the inclusion of the hard drawn supply condition for tubes, the requirements of the Flattening Test and Drift Expanding Test have been modified to also cover hard drawn tubes, with the provision that such tubes shall be soft annealed before testing.</p>
<p>10.1 Eddy Current Test</p>	<p>The Eddy Current Test has been modified incorporating the provision that ‘Tubes that are not of a size suitable for eddy current test (OD>50mm) shall be tested by hydrostatic or pneumatic test.</p>
<p>10.2 & 10.3 Hydrostatic Test & Pneumatic Test</p>	<p>The requirements for the Hydrostatic Test and Pneumatic Test have been revised by modifying the sample size, whereby one sample</p>

	from each lot shall now be subjected to these tests instead of testing each tube as specified earlier.
10.4 Microscopic Examination	The requirement for Microscopic Examination has been modified, and the reference to IS 4748 specified earlier has also been modified to IS 18829.
10.5 Hydrogen Embrittlement Test	The Hydrogen Embrittlement Test has been modified, specifying that this test is only applicable to Cu-OF grade tubes.
14 Marking	The marking clause has been modified incorporating 'type of tube' in addition to the existing details.

4. Consequent upon the issuance of the revised Standard, the existing product manual of IS 10773 has been revised which is being circulated separately.

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

A. LICENSEES:

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

ii) All Licensees shall implement the revised Standard by **28th May 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 **28th May 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.

iii) The scope of the licence shall be accordingly modified in line with the Scope of Licence specified in the Product Manual of IS 10773:2025.

iv) 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 27th May 2026 and for such cases Applicant shall give a declaration that they will implement the revised Standard by 28th May 2026.

iii). Beyond 28th May 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 28th May 2026 whichever is earlier.

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

Ranjit Kumar
Scientist-E

Head (CMD-2)

DDG (Certification)

ROs/BOs