



केन्द्रीय मुहर विभाग - III

हमारा संदर्भ- केन्द्रीय मुहर विभाग-३/१६: भा.मा. 18427

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 18427

10 September 2026

Subject: Guidelines for implementation of Amendment no. 1 to IS 18427: 2024 - "Three Piece Round Open Top Metal Cans for Foods and 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 18427

10 September 2026

Subject: Guidelines for implementation of Amendment no. 1 to IS 18427: 2024 - “Three Piece Round Open Top Metal Cans for Foods and Beverages”

1. Amendment no. 1 to IS 18427: 2024 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	5.6.2.1, Raw material Requirements for Easy Open End	Existing clause has been modified to allow aluminium alloys as per IS 737. Existing table has been removed. New ‘note’ added to allow other grades of aluminium as agreed between manufacturer and purchaser.	Conformity to new and modified requirements shall be established by manufacturers either through in-house or TPT lab test report, as applicable.
2	7.7.3.3, Overlap and percentage overlap	Existing clause has been modified to refer ‘Table 7’ for minimum acceptable overlap of thermally processed cans.	
3	5.8.1, Ring Specification	Heading of clause has been modified. Existing clause has been modified to permit aluminium as per IS 737 and other grades of aluminium as agreed between manufacturer and purchaser.	
4	7.2.1, Non Easy Open (NEO) Ends	New line has been inserted to allow: • Aluminium NEO as per IS 737. • Other grades of aluminium as agreed between manufacturer and purchaser.	
5	4, Types	New ‘note’ added to allow other types as agreed between manufacturer and purchaser.	Other types may be included in the scope of licence through a separate application for change in scope of licence (inclusion).
6	5.8, Peel Off Ends (POE)	Aluminium Ring has been permitted in addition to ETP Ring.	Licensees shall submit necessary declarations, as applicable
7	6.1, Diameter	Existing clause has been modified to bring more clarity. Cans of other nominal diameters are also allowed based on mutual agreement between the manufacturer and purchaser.	
8	7.7.2, Seam Specification	New line has been inserted to specify requirements for non-thermally processed cans.	
9	Table 6, Open Top Metal Can Capacities for Round Food Cans	Col (5) for Gross Lidded Capacities has been deleted. Note 4 has also been deleted.	No actions required.
10	5.1.4 to 5.1.10, Tinplate	Existing clauses deleted.	

4. Consequent upon publication of the Amendment, existing Product Manual has also been revised as ***PM/IS 18427/4/Sep 2026***. In this revision, minor changes have been made in Scheme of Inspection and Testing (Marking and Test Certificate).
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 well as revised list of test equipment (as per Form 2) /testing arrangement, as applicable, of the product to **new and modified requirements**, as applicable to the varieties covered, as evidence of conformity to the Amendment.
- (iii) Verification of implementation of this Amendment, shall be done during the next visit.
- (iv) 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)