

केन्द्रीय मुहर विभाग -2

संदर्भ -: केमूवी-2/16:16585

18 10 2023

विषय: संशोधित **IS 16585:2023** के अनुपालन के 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।

शिवम आहूजा
वैज्ञानिक सी

प्रमुख (केमूवी 2)

सभी क्षेत्रीय/शाखा कार्यालय/प्रयोगशालाएँ/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16:16585

18 10 2023

Subject: Guidelines for implementation of Revised IS 16585:2023

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.

(Shivam Ahuja)
Scientist C

Head (CMD-2)

All ROs/BOs/Labs/MTD/LPPD

CENTRAL MARKS DEPARTMENT-2

Our Ref: CMD-2/16: 16585

18 10 2023

Subject: Guidelines for implementation of Revised IS 16585:2023/IEC 60604-8-11:2018, MOD (Magnetic Materials- Specifications for Individual Materials-Fe-Based Amorphous Strip Delivered in the Semi-Processed State)

1. This has reference to the above.
2. IS 16585:2016 is under compulsory BIS Certification with no licences operative domestically and 03 licences in operation under FMCS.
3. Licence as per IS 16585 is being operated under factory testing basis.
4. IS 16585:2016 has been revised as IS 16585:2023 and the date of withdrawal of IS 16585:2023 is **03rd May 2024**.
5. All BOs and FMCD shall inform the Applicants and Licensees under their jurisdiction about implementation of the revised Standard within a week of issuance of these guidelines.
6. The significant changes in the revised Standard as listed in the Table 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 16585:2016	Change
1 Scope	The clause has been revised to state that "Other nominal thicknesses in the range from 0.020 mm to 0.030 mm can be supplied by agreement between the manufacturer and purchaser at the time of enquiry and order"
7.1.1 Technical Requirements, Magnetic Properties, Reference Condition	Para 2 has been omitted Para 4 has been added stating that the " the test specimen shall be kept flat during the magnetic annealing"
7.1.3 Technical Requirements, Magnetic Properties, Specific Total Loss	It has been added in the clause that "in addition to the nominal thickness of 0.025 mm, the specified values given in Table 1 and Table 2 at 50 Hz also holds applicable to other sizes of nominal thicknesses in the range of 0.020 mm to 0.030 mm" This addition is not a part of IEC 60604-8-11:2018
Table 1, Technological properties and magnetic properties of the conventional grades of Fe-based	Material names i.e. AM-08-25S5-90, AM1025S5-90, AM12-25S5-90,AM16-25S5-90 having a minimum stacking factor of 0.90 have been added in the Table

amorphous strip	
Table Technological properties and magnetic properties of the high permeability grades of Fe-based amorphous strip	2 Material names i.e. AM-08-25P5-90, AM1025P5-90, AM12-25P5-90, AM16-25P5-90 having a minimum stacking factor of 0.90 have been added in the Table
7.2.1, Thickness, Geometrical characteristics and tolerances	The words “direction parallel to the longitudinal axis of the strip” have been replaced by “ direction parallel to the casting direction ” The words “direction perpendicular to the longitudinal axis of the strip” have been replaced by “ direction perpendicular to the casting direction ”
8.1 Inspection and Testing	The clause has been revised to state that in case of a order without inspection, the manufacturer shall supply an inspection document type 3.1 (inspection certificate 3.1) according to ISO 10474 giving the specific total loss and the stacking factor of the supplied strip
8.2 Selection of test samples	Para 3 of the clause has been revised to state that the selection shall be made from the first external turns, excluding the wrapping turns
8.3.1, Preparation of Test Specimens, Magnetic Properties	Para 1 of the clause has been revised to state that the test specimen for the single sheet tester shall consist of one sheet having the dimensions as specified in the clause Para 3 and Para 4 of the clause have been omitted
8.3.2, Geometrical Characteristics and Tolerances	Para 1 has been revised to omit square test specimen for measurement of thickness In Para 2 which specified measurement of width, specified length of the test specimen has been revised to at least 250 mm In Para 3 which specified measurement of flatness (edge wave (wave factor) and edge camber, width of the test specimen has been omitted In Para 4 which specified measurement of residual curvature, length of the test specimen has been specified.
8.4.3.2 Test Methods, Width	The clause has been revised to state that the width shall be measured perpendicular to the casting direction of the strip
8.4.3.5 Test Methods, Residual Curvature	The clause has been revised to state that the residual curvature in the casting direction shall be determined in accordance with IEC 60404-9.
8.4.4.2 Test Methods, Strip Tear Ductility	It has been stated that the tearing shall be carried out by hand Further, the location and distance of the 5 tears from the edges of the strip have been revised

B.3, Annex B, Test Method of determination of stacking factor for Fe-based amorphous strip	A new para 4 regarding distance between the rams has been added Figure B.1-Schematic Diagram of a stacking specimen and a linear measuring device has been added
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7. The existing Product Manual has also been revised on account of the revision and the same is being circulated separately.

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

A. LICENSEES:

i) All Licensees shall implement the revised standard by **03rd May 2024**. Any difficulty in implementation shall be brought to the notice of CMD 2 at the earliest but in any case at least 30 days before the last date of implementation. BOs shall ensure that no Licences are under operation as per the old version i.e IS 16585:2016 after **03rd May 2024**. **The status of implementation of the revised standard shall be confirmed by Head (BO) to CMD-2 within two weeks of the last date of concurrent running.**

ii) For switchover to revised standard, licensees shall submit evidence of conformity to the additional/modified requirements through In-house Test Reports ,of the thicknesses and material names already covered under the scope of the licence. Verification of implementation of the revised standard, wherever required, may be carried out during the next surveillance visit.

iii) For inclusion of new varieties covered under the revised standard, a special inspection shall be planned and factory testing for the varieties intended to be included in the scope of the licence, as per Grouping Guidelines, shall be carried out and inclusion may be granted based upon the results of factory testing.

B. APPLICATIONS FOR GRANT OF LICENCE:

1. Existing Applications where preliminary inspection/complete factory testing has been carried out may be processed as per the old Standard.

2. 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 upto **02nd May 2024** and for such cases Applicant shall give a declaration that they will implement the revised Standard by **03rd May 2024**.

3. Beyond **03rd May 2024** no Licence shall be granted as per the old Standard.

C. CHANGE IN SCOPE OF LICENCE:

1. For change in scope of licence, the relevant provisions as given above for Applicants shall apply.

2. 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 **03rd May 2024** whichever is earlier.

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

Shivam Ahuja
Sc. C

Head (CMD-2)
DDG (Certification)
ROs/BOs