

PM/16372/1
August 2022



उत्पाद मैनुअल
Textiles — Jute Bags for Packing up to 30 kg Foodgrains — Specification
IS 16372:2015 के अनुसार

PRODUCT MANUAL
FOR Textiles — Jute Bags for Packing up to 30 kg Foodgrains — Specification
ACCORDING TO IS 16372:2015

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना- I के तहत प्रमाणन के संचालन में अभ्यास और पारदर्शिता के संचालन में पारदर्शिता सुनिश्चित करने के लिए इस उत्पाद मैनुअल का उपयोग सभी क्षेत्रीय / शाखा कार्यालयों और लाइसेंसधारियों द्वारा संदर्भ सामग्री के रूप में किया जाएगा। दस्तावेज़ का उपयोग बीआईएस प्रमाणन लाइसेंस/प्रमाणपत्र प्राप्त करने के इच्छुक संभावित आवेदकों द्वारा भी किया जा सकता है।

This Product Manual shall be used as reference material by all Regional/Branch Offices & licensees to ensure coherence of practice and transparency in operation of certification under Scheme-I of Bureau of Indian Standards (Conformity Assessment) Regulations, 2018 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification licence/certificate.

1.	उत्पाद Product	:	IS 16372:2015
	शीर्षक Title	:	Textiles — Jute Bags for Packing up to 30 kg Foodgrains
	संशोधनों की संख्या No. of amendments	:	NIL
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	The bags shall be made from single piece of plain woven jute hessian of uniform construction having nominal mass of 267 g/m ² Conformity to the requirement for raw material may be established through supplier's test certificate, test report of NABL or third party lab, or in house testing.
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Bags of ANY type may be tested to cover all the types intended to be covered in the scope If scope of licence is required to cover Eco mark, samples shall also be tested for and manufacturer shall comply with the additional requirements for eco mark (Additional Requirements for Labelling as Environment Friendly Products)

c)	नमूने का आकार Sample Size	:	30 jute bags
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer Annex-A
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer Annex-B
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	All tests except Average Breaking load of Sacking and Average Breaking Load of Seam for which samples are recommended to be conditioned for 24 h.		
6.	लाइसेंस का दायरा /Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 16372:2015 with the following scope:		
	Name of the product	Textiles — Jute Bags for Packing up to 30 kg Foodgrains	
	Type	Type 1 and/or Type 2 and/or Type 3 and/or Type 4 and/or Type 5	
	Eco mark	With or without ECO Mark	

BUREAU OF INDIAN STANDARDS
MANAK BHAVAN,9, BAHADUR SHAH ZAFAR MARG,
NEW DELHI-110002

ANNEX – A

LIST OF TEST EQUIPMENTS

Major test equipment required to test as per the Indian Standard

Sl. No.	Tests Used In With Clause Reference	Test Equipment/Chemical
1.	Capacity and Corrected mass/bag, Cl. 5.1	Weighing balance
2.	Dimensions, Cl. 5.1	Steel Tape, Porter Gauge, Table
3.	Ends and Picks, Cl. 5.1	Method A of IS 1963: Traversing Thread counter equipped with low power microscope Or Ordinary counting glass with aperture satisfying 5.2 of IS 1963 OR Method B of IS 1963 Clamps of Type A, B or C as per 6.1 of IS 1963 and forceps
4.	Average breaking strength of sacking and Average Seam Strength, Cl. 5.1	Constant-rate-of-extension (CRE) Tensile testing machine with equipment for cutting samples (The machine shall be capable of constant rates of extension of 20 mm/min and 100 mm/min, with an accuracy of $\pm 10\%$)
5.	Moisture regain	Moisture meter.
6.	Oil content on dry de-oiled material	Soxhlet Apparatus, Drying Oven — capable of maintaining a temperature of $105 \pm 3^\circ\text{C}$, Weighing Balance — capable of weighing to an accuracy of 1 mg with suitable reagents and laboratory glassware/equipment
7.	Conditioning (Various clauses)	Air Conditioner or Conditioning Chamber to condition samples at $27 \pm 2^\circ\text{C}$ and $65 \pm 2\%$, Hygrometer, Thermometer

The list above is indicative only and may not be considered as exhaustive

ANNEX B**SCHEME OF INSPECTION AND TESTING**

1. **LABORATORY-** A laboratory shall be maintained, which shall be suitably equipped (as given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the method given in the specification.

1.1 The manufacturer shall prepare and implement a calibration plan for the test equipment.

2. **TEST RECORD-** The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. **PACKING AND MARKING** - The Standard Mark as given in the Schedule of the licence shall be shall be stenciled with indelible ink on each bale containing jute bags provided always that the material so marked conforms to each requirement of the specification.

3.1 The bags shall be packed in bales as prescribed in IS 2873 or as specified in the agreement between the buyer and the seller. The bales shall be marked as prescribed in IS 2873. Additional markings shall be made as stipulated by the buyer or required by regulation or law in force. The bale containing jute bags shall also be marked with the following: BIS licence number and "For BIS certification details please visit www.bis.gov.in"

5. **CONTROL UNIT-** For the purpose of this scheme, all bales of jute bags of same size produced under similar conditions of production in a day shall constitute a control unit.

6. **LEVELS OF CONTROL** :- The tests as indicate in Table 1 and at the levels of controls in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and records maintained in accordance with paragraph 2 above.

6.1 All the production which conforms to the Indian Standard and covered under the scope of this licence shall be marked with the Standard Mark.

7. **REJECTION** - Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act,2016.

TABLE1
LEVELS OF CONTROL

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or)S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods Clause Reference			No. of Sample	Frequency	Remarks
4	Manufacture	4	IS 16372:2015				
4.1	Construction	4.1	-do-	R	One	Hourly from Each control unit	See Note 3
4.2	Seam	4.2	-do-	R	One	Hourly from Each control unit	
4.3	Safety Stitch	4.3	-do-	R	One	Hourly from Each control unit	
4.4	Hemming at the Mouth	4.4	-do-	R	One	Hourly from Each control unit	
4.5	Freedom from Defects	Annex A	-do-	R	One	Hourly from Each control unit	

5.1	Requirements for Jute Bags						
i)	Capacity			R	Five	Each control unit	
ii)	Dimensions	8.3.2	IS 9113	R	Five	Each control unit	
iii)	Ends and Picks	8.4.2	-do-	R	Five	Each control unit	
iv)	Corrected Mass per bag	8.5.2	-do-	R	Five	Each control unit	
v)	Average breaking strength of sacking	8.6.2	-do-	R	Five	Each control unit	
vi)	Average seam strength	8.7	-do-	R	Five	Each control unit	
vii)	Moisture regain	8.2	-do-	R	Five	Each control unit	
viii)	Oil content on dry de-oiled material	8.8	-do-	R	Two	Each control unit	
5.2	Requirements for packed bales						
i)	Total number of bags per bale	8.9	IS 9113	R		Each bale	

ii)	Number of bags per bundle			R		Each bale	
iii)	Contract mass of a bale			R		Each Each bale bale	
iv)	Corrected net mass of a bale	8.1	IS 9113	R		Each bale	
5.3	Contract moisture regain			R		Each bale	
5.4	Additional Requirements for Labelling as Environment Friendly Products (optional)						
i)	Non-halogenated hydrocarbons		See Note 1 under Table 3 of IS 16372	S	As agreed between the manufacturer and purchaser		
ii)	Pesticides (Sum parameter) and Banned Pesticides		-do-	S	-do-		
iii)	pH of aqueous extract		-do-	S	-do-		
iv)	Coupled amines from azo-dyes (Sum parameters)		-do-	S	-do-		

Note-1: Whether test equipment is required or sub-contracting is permitted in column 2 shall be decided by the Bureau and shall be mandatory. Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the

Bureau.

Note-2: Levels of control given in column 3 are only recommendatory in nature. The manufacturer may define the control unit/batch/lot and submit his own levels of control in column 3 with proper justification for approval by BO Head.

Note-3: Conformity to the requirement for raw material (plain woven jute hessian) may be established through supplier's test certificate, test report of NABL or third party lab, or in house testing