



उत्पाद मैनुअल
Textiles- High Density Polyethylene (HDPE) Woven Fabrics
IS 6899:1997 के अनुसार

PRODUCT MANUAL
FOR Textiles- High Density Polyethylene (HDPE) Woven Fabrics
ACCORDING TO IS 6899:1997

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 6899:1997
	शीर्षक Title	:	Textiles- High Density Polyethylene (HDPE) Woven Fabrics
	संशोधनों की संख्या No. of amendments	:	01
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	HDPE Tapes used to make the fabric shall conform to the requirements of Cl. 3 of IS 6899. Conformity of the material may be established through material supplier's test certificate, test report of BIS recognized/empaneled lab or NABL accredited lab or in house testing. No testing is required if material is ISI Marked.
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Please refer Annex-A
c)	नमूने का आकार Sample Size	:	Full width x 2 metre

3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer Annex-B
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer Annex-C
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	(i) Mass of Fabric (ii) Breaking Load (iii) Width		
6.	लाइसेंस का दायरा /Scope of the Licence:		
	“Licence is granted to use Standard Mark as per IS 6899:1997 with the following scope:		
	Name of the product	High Density Polyethylene (HDPE) Woven Fabrics	
	Variety	Variety No 1/2/3/4/5	
	Others	Laminated or Unlaminated	

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ANNEX A

GROUPING GUIDELINES

IS 6899 classifies HDPE fabric into 5 numbered varieties : Variety No 1/2/3/4/5 based on the minimum mass of the un laminated fabric. Sample of any size of the higher variety number i.e. variety with higher minimum mass to be drawn and tested to additionally cover the lower variety numbers in the scope of licence for grant of licence or change in scope of licence.

If sample of laminated fabric is tested, the recommendation for grant of licence or change in scope of licence may include un laminated fabrics too.

Scope shall be restricted based on the manufacturing and testing capabilities. During operation of licence, samples of all varieties covered in the scope of licence shall be drawn in rotation, to the extent possible.

ANNEX B
List of Test Equipment

Major test equipment required to test as per the Indian Standard

Sl. No.	Tests used in with Clause Reference	Test Equipment
1	Mass of fabric (cl 4.1 and table 1)	Weighing Balance, Drying Oven
2	Breaking load (cl 4.1 and table 1)	Constant rate of extension (CRE) Tensile testing machine, conditioning chamber, Steel Rule
3	Width (cl 4.1 and table 1)	Calibrated Steel Rule, Table

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

ANNEX C

Scheme of Inspection And Testing

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

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

2. **TEST RECORDS** –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 marked on each roll of fabric always that the fabric marked conforms to all the requirements of the Indian Standard.

3.1 Packing and Marking of the material shall be done as per the provisions of the Indian Standard. Packaging of the fabric may also be marked with details of BIS website i.e. for details of BIS certification please visit www.bis.gov.in

4. **CONTROL UNIT** –For the purpose of this scheme, all the rolls of fabric of the same variety number manufactured from the same consignment of HDPE tapes shall constitute a control unit.

5. **LEVELS OF CONTROL** – The test as indicated in column 1 of Table 1 and the levels of control in column 3 of table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with paragraph 2 above.

5.1 All the production which conforms to the Indian Standards and covered by the licence should be marked with Standard Mark

6. **REJECTIONS** - 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

TABLE 1
Levels of control

(1)				(2)	(3)		
Test Details				Test equipment requirement R: required (or) S: Sub- contracting permitted	Levels of Control		
Cl.	Requirement	Test Method	Reference		No. of Sample	Frequency	Remarks
3.1	HDPE tape (Manufacture/raw material)		IS 6192	S	one	From each lot	Conformity of the material may be established through material supplier's test certificate, test report of BIS recognized/empaneled lab or NABL accredited lab or in house testing. No testing is required if material is ISI Marked.
3.2	Visual Inspection		IS 6899	R	All rolls	-	Complete length
4	Requirement						
4.1	Mass of Unlaminated / laminated fabric		IS 1964	R	Every four hours	Each control unit	
4.1	Breaking Load i) Warpway ii) Weftway		IS 1969 (Part 1)	R	one	Each Control Unit	
4.1	Width and length		IS 1954	R	one	Each Control Unit	

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 empaneled 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.