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उत्पाद मानुयल
TEXTILES – JUTE BAGS FOR PACKING 50 KG
FOODGRAINS
IS 12650:2018 के अनुसार

PRODUCT MANUAL For
TEXTILES – JUTE BAGS FOR PACKING 50 KG
FOODGRAINS
ACCORDING TO IS 12650:2018

भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम की स्कीम-I के तहत यह उत्पाद मानुयल प्रमाणीकरण के प्रचलन में रीति और पारदर्शिता के सुसंगत सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों एवं लाइसेंस धारियों द्वारा संदर्भ सामग्री के रूप में उपयोग किया जाएगा। बीआईएस लाइसेंस/प्रमाण पत्र प्राप्त करने के इच्छुक भावी आवेदकों द्वारा भी इस दस्तावेज़ का उपयोग 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, 2008 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification licence/certificate.

1.	उत्पाद Product	:	IS 12650:2018
	शीर्षक Title	:	TEXTILES – JUTE BAGS FOR PACKING 50 KG FOODGRAINS
	संशोधन संख्या No. of amendments	:	00
2.	नमूनाकरण दिशा निर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	The bags shall be made from single piece of twill weave jute sacking of uniform construction having nominal mass of 579 g/m ² .
b)	समूहिकरण दिशा निर्देश Grouping Guidelines	:	NA – Each type of bag to be tested

c)	नमूने का परिमाण Sample Size	:	30 jute bags
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer Annex –A
4.	निरीक्षण व परीक्षण 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
6.	लाइसेन्स का कार्यक्षेत्र/Scope of the Licence:		
IS 12650:2018 के अनुसार मानक मुहर का उपयोग करने के लिए लाइसेन्स निम्नलिखित कार्यक्षेत्र के लिए प्रदान किया जाता है Licence is granted to use Standard Mark as per IS 12650:2018 with the following scope:			
	Name of the product	JUTE BAGS FOR PACKING 50 KG FOODGRAINS	
	Type	Type A or B	
	Additional requirements	With or Without Eco Mark	

ANNEX-A
LIST OF TEST EQUIPMENTS

Major test equipment required to test the requirements of the Indian Standard.

Sl. No.	Tests used in with Clause Reference	Test Equipment
1	Dimensions, Cl 4.1 and 5.1	Steel Tape, Porter Gauge, Table
2	Ends and Picks, Cl 4.1 and 5.1	Method A of IS 1963: 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
3	Mass, Cl 4.1 and 5.1	Table, Steel Scale, Weighing balance accurate to 0.005 g, Drying oven
4	Average breaking strength of sacking and Average seam strength, Cl 4.1 and 5.1	Constant-rate-of-extension (CRE) Tensile testing machine capable of constant rates of extension of 20 mm/min and 100 mm/min, with an accuracy of $\pm 10\%$, equipment for cutting samples
5	Moisture regain, Cl 4.1 and 5.1	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 above list is indicative only and may not be treated as exhaustive.

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ANNEX – B**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 a calibration plan for the test equipment.

- 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 document shall be stenciled with indelible ink on each bale provided always that all the bags packed in the bale on which this mark is applied conform to every requirement of the specification.

- 3.1** Marking and packing shall be done as per the provisions of the Indian Standard. In addition, the following information shall be given on each bale or the label attached to it:

a) Control Unit (or Batch) Number.

b) BIS Licence Number (CM/L-...)

c) BIS website details i.e.–“For details of BIS certification please visit www.bis.gov.in”

- 4. CONTROL UNIT** – For the purpose of this scheme, all the bags manufactured in a day or part thereof shall constitute a control unit.

NOTE: One of the sizes shall be tested for all the characteristics of the specification. For other sizes of bags, only length, width, mass of bag and stitching to the tested, if same fabric is used.

- 5. LEVELS OF CONTROL** - The tests 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 Standard and covered by the licence should be marked with Standard Mark.

5.2 SAMPLING FOR FLOOR INSPECTION

- 5.2.1** One bag shall be drawn every hour of production and tested for freedom from defects, dimensions, mass, moisture regain, ends and picks per dm and stich per dm. If the sample fails in any of the criteria, double the sample shall be tested and in case of any failure in second sample production of that duration shall be rejected. Suitable corrective action shall be taken to avoid recurrence of the failure and its records shall be kept. Five bags and two bags shall be drawn at an equal interval and tested and breaking strength and oil content respectively and in case of any failure the entire control unit shall be

declared unfit for marking with BIS certification Marks. Moreover, cloth at each loom shall be checked for ends and Picks per dm and width at least twice daily. Bags from each stitching machine shall also be checked for stitch at least twice daily. Continuous checking for fabric defects shall be done at calendaring machine.

5.2.2 In respect of all other clauses of the specification and all stages of manufacture, the factory will maintain appropriate controls and checks to ensure that their product conforms to the various requirements of the specification including contract mass of the bale, total number of bags in a bale, number of bags per bundle and corrected net mass of bale.

5.2.3 It is recommended that routine analysis of each consignment of raw material received in the factory shall be carried out and records maintained.

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			No. of Sample	Frequency	Remarks
		Clause	Reference				
4.1	Construction and Nominal mass of Jute Sacking	4.1	IS 12650	R	One	Each consignment of jute sacking	If the sample fails, two samples shall be tested. In case of any failure, the production shall be declared unfit for marking with BIS Certification Mark
4.1	Manufacture	4.1	IS 12650	R	One	Each control unit	
4.2	Seam		IS 9113	R	One per hour	-do-	
4.3	Safety Stitch		IS 9113	R	One per hour	-do-	
4.4	Hemming at the mouth		IS 9113	R	One per hour	-do-	
4.5	Freedom From Defects	Annex A	IS 12650	R	One per hour	-do-	
5.1 Table 1	i) Dimensions	8.3.2	IS 9113	R	One per hour	-do-	
	ii) Ends/dm iii) Picks/dm	8.4.2	IS 9113	R	One per hour	-do-	
	iv) Corrected mass per bag	8.5.2	IS 9113	R	One per hour	-do-	
	v) Avg breaking strength of sacking	8.6.2	IS 9113	R	5 bags	-do-	
	vi) Avg side seam strength	8.7	IS 9113	R	5 bags	-do-	
	vii) Moisture regain	8.2	IS 9113	R	One	-do-	
	viii) Oil content on de-oiled material	8.8	IS 9113	R	2 bags	-do-	

5.3	Contract moisture regain	8.2	IS 9113	R	One	-do-	
5.2 Table 2	i) Total no of bags per bale	8.9	IS 9113	R	Each bale		
	ii) No of bags per bundle	-	-	R	Each bundle		
	iii) Contract mass of a bale	-	-	R	Each bale		
	iv) Corrected net mass of a bale	8.1	IS 9113	R	Each bale		
	v) No of joined bags per bundle of 25 bags	Visual	-	R	Each bundle		
5.4.2 Table 3	i) Non halogenated hydrocarbons	See Notes under Table 3 of IS 12650		S	As agreed between purchaser and supplier		Only applicable for bags with ECO Mark
	ii) a) Pesticides (Sum parameter) b) Banned Pesticides	-do-		S	-do-		-do-
	iii) pH of aqueous extract	-do-		S	-do-		-do-
	iv) Coupled amines from azo-dyes (Sum parameters)	-do-		S	-do-		-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 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.