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उत्पाद मानुयल
B-TWILL JUTE BAGS FOR PACKING FOODGRAINS
IS 2566:1993 के अनुसार

PRODUCT MANUAL For
B-TWILL JUTE BAGS FOR PACKING FOODGRAINS
ACCORDING TO IS 2566:1993

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 2566:1993
	शीर्षक Title	:	TEXTILES- B-TWILL JUTE BAGS FOR PACKING FOODGRAINS-SPECIFICATION
	संशोधन संख्या No. of amendments	:	03
2.	नमूनाकरण दिशा निर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	The bags shall be made from cloth conforming to IS 3667:1993
b)	समूहिकरण दिशा निर्देश Grouping Guidelines	:	NA – Bags of each size to be tested
c)	नमूने का परिमाण Sample Size	:	16 bags + 2 m Fabric + 100 m Single Yarn +100 m 3 Ply Twine
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	:	Constructional requirements (4.2 to 4.4), Freedom from defects (4.5), Dimensions, Ends and Picks, Mass, Moisture Regain, Oil content (5.1)
6.	लाइसेन्स का कार्यक्षेत्र/Scope of the Licence:		
	IS 2566:1993 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 2566:1993 with the following scope:		
	Name of the product	B-TWILL JUTE BAGS FOR PACKING FOODGRAINS	
	Sizes	100 kg / 93 kg / 75 kg	

ANNEX-A
LIST OF TEST EQUIPMENTS

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

S.No.	Test Equipment/Apparatus	Test used in with clause reference
1.	Steel scale and tape, Flat Table	Dimensions, CI 5.1, Table 1 S No (i)
2.	Weighing Balance	Corrected Mass per Bag, CI 5.1, Table 1 S No (ii) Contract Mass of a Bale, CI 5.2, Table 2 S No (iii) Correct Net Mass of a Bale, CI 5.2, Table 2 S No (iv)
3.	Porter Gauge or Traversing thread counter or Forceps and clamps	Ends and Picks , CI 5.1, Table 1 S No (iii) and (iv)
4.	Tensile Testing Machine, Conditioning Chamber	Breaking Load of Cloth, , CI 5.1, Table 1 S No (v)
5.	-do-	Seam Breaking Load, , CI 5.1, Table 1 S No (vi)
6.	Moisture Meter	Moisture Regain, CI 5.2, Table 2 S No (v)
7.	Soxhlet Apparatus, Drying oven (105±3°C)– For Over Dry method, conditioning chamber -for Conditioned Mass Method, Weighing balance (Accurate to 1 mg), Water Bath, Trichloroethylene or light petroleum or n-hexane, other laboratory reagents, equipment and glassware	Oil Content on dry deoiled material basis, CI 5.2, Table 2 S No (vi)

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

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 license shall be incorporated legibly and indelibly on each bale containing jute bags, provided always that the said material to which the mark is thus applied conforms 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 website details i.e.–“For details of BIS certification please visit www.bis.gov.in”
- 4. CONTROL UNIT** – For the purpose of this scheme the entire quantity of jute bags of one size manufactured in a day under similar conditions shall constitute a control unit.
- 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:** Five sample bundles shall be selected every four hours of production, one bag shall be taken from each sample bundle subject to 30 bags in a control unit, and shall be tested as under

S. No.	Characteristics	Sample Size	Frequency	Total
a)	Dimensions	5	Every 4 hours	30
b)	Ends and Picks per dm	-do-	-do-	-do-
c)	Moisture Regain	-do-	-do-	-do-
d)	Breaking load of cloth (Warp, Weft) and seam	One	One sample when control unit starts and then at equal intervals	5
e)	Oil content	One	Every 12 hours	2

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)		(4)
TEST DETAILS					LEVELS OF CONTROL		Remarks
Cl. No.	Requirements	TestMethod		Test equipment requirement R: required (or) S: Sub-contracting permitted	No.of Samples	Frequency	
		Clause	Reference				
4.1	Cloth (Manufacture)		IS 3677:1993	S	One	Each consignment -	Testing is not required if consignment is accompanied with supplier's test certificate indicating conformity or is ISI Marked
4.1	Identification (Manufacture)	4.1	IS 2566:1993	R	Adequate visual inspection		
4.3.	Seam.	4.3.1, 4.3.2	IS 9113:2012	R	5 bags Hourly	Each Control Unit	
4.2	Hemming at mouth.	4.2	IS 9113:2012	R	-do-	-do-	
4.4	Joined Bags		IS 9113:2012	R	-do-	-do-	For strength testing of the joined bags number of samples would corresponds to the number of joined bags.
4.5	Freedom from defects	4.5	IS 2566:1993	R	30 bags	Each Control Unit	

Table 1	Requirements of B-Twill Jute Bags for Foodgrains						
i)	Dimensions	Table 1, cl 5.1	IS 1954:1990 IS 2566:1993	R	30 bags min (5 bags/4 hrs)	-do-	In 30 bundles as selected in 5.2 of SIT subject to maximum of 5 bags taken up for testing at a time.
iii) and iv)	Ends & Picks/dm	Table 1, cl 5.1	IS 1963:1981 IS 2566:1993	R	-do-	-do-	-do-
ii)	Corrected mass per bag.	8.5.2	IS 9113:2012	R	-do-	-do-	-do-
v)	Breaking Load of cloth		IS 1969 (Part 1)	R	5 bags Min (1 bag/4 hrs)	Each control unit	-do-
vi)	Seam Breaking Load		IS 9030		-do-	-do-	-do-
Table 2	Requirements of Packed Bales of B-Twill Jute Bags						
i)	Total Number of Bags per Bale	8.9	IS 9113:2012		Each bale		
ii)	Number of joined bags per bundle of 25 bags	-do-	-do-		30 bundles	Each control unit	
iii)	Contract mass of a bale	5.2	IS 2566:1993	R	Each bale		
iv)	Corrected net mass of a bale	8.1	IS 9113:2012	R	Each bale		
v)	Moisture Regain.	8.2	-do-	R	30 bags (5 bags per 4 hours)	Each control unit	See 5.2 of SIT

vi)	Oil Content.	-	IS 2969:1974	R	2 bags	-do-	In case of any failure, the production shall be declared unfit for marking with BIS Certification
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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.