



उत्पाद मैनुअल

**TEXTILES — JUTE BAGS FOR PACKING 50 kg SUGAR**

**IS 15138: 2024 के अनुसार**

**PRODUCT MANUAL  
FOR TEXTILES — JUTE BAGS FOR PACKING 50 kg SUGAR  
ACCORDING TO IS 15138: 2024**

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम, 2018 की योजना के तहत प्रमाणन के संचालन में एकरूपता और पारदर्शिता के लिए इस उत्पाद मैनुअल का उपयोग सभी क्षेत्रीय/शाखा कार्यालयों और लाइसेंसधारियों द्वारा संदर्भ सामग्री के रूप में किया जाएगा। इस दस्तावेज़ के उपयोग बीआईएस प्रमाणन 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 uniformity 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.*

|    |                                            |   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
|----|--------------------------------------------|---|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1. | मानकसंख्या<br>IS No.                       | : | IS 15138: 2024                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
|    | शीर्षक<br>Title                            | : | TEXTILES — JUTE BAGS FOR PACKING 50 kg SUGAR                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
|    | संशोधनोंकीसंख्या<br>No. of amendments      | : | Nil                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| 2. | नमूनादिशानिर्देश<br>Sampling Guidelines    |   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
| a) | कच्चा माल<br>Raw material                  | : | The fabric and hessian cloth used to make the bags shall conform to Cl 4.1 of IS 11538:2024<br><br>Liner used in Type C and Type E bags shall be provided with minimum 25 micrometer thick loose liner be made of food grade virgin HMHDPE conforming to IS 10146<br><br>Conformity of raw material shall be established through raw material suppliers test certificate or test report from BIS recognized/empaneled lab or other accredited lab or in house testing or combination thereof |
| b) | समूहीकरणदिशानिर्देश<br>Grouping Guidelines | : | NA – Samples of each type of bag shall be tested                                                                                                                                                                                                                                                                                                                                                                                                                                             |

|    |                                                                                                            |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|----|------------------------------------------------------------------------------------------------------------|-------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| c) | <b>नमूनेकापरिमाण</b><br><b>Sample Quantity</b>                                                             | :                                   | Following sample shall be drawn for considering grant of licence for IT or inclusion of additional type in the licence :<br>i) No. of Bags as per table 3 of IS 15138:2024<br>ii) Basic fabric from which the bags are made = 2 meters for determination of fabric weight as per clause 4. 1 of IS 15138.<br>iii) Jute Yarn, single ply = 100 m for determination of count of yarn as per 5.1.2 of IS 9113 when read in conjunction with clause 4.3 of IS 15138 and<br>iv) Jute Yarn , three ply = 100 m for determination of count of yarn as per 5.1.2 of IS 9113 when read in conjunction with clause 4.2 of IS 15138.<br>v) Liner (For Type C <b>and Type E</b> ) |
| d) | <b>परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर</b><br><b>Parameters to be Declared in Test Request</b> | :                                   | i) Name of the product<br>ii) Variety: Type A/Type B/Type C/Type D/Type E,<br>iii) Bag Dimensions: Outside length and width<br><br>Note: Apart from the above, any other requirements/parameters may also be declared as per the standard, as applicable.                                                                                                                                                                                                                                                                                                                                                                                                             |
| 3. | <b>परीक्षण उपकरणों की सूची</b><br><b>List of Test Equipment</b>                                            | :                                   | Please refer to Annex-A                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
| 4. | <b>निरीक्षण और परीक्षण की स्कीम</b><br><b>Scheme of Inspection and Testing</b>                             | :                                   | Please refer to Annex-B                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
| 5. | <b>एक दिन में संभावित परीक्षण</b><br><b>Possible tests in a day</b>                                        |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|    | Complete tests can be carried out in a day as per Cl.5 excluding Avg. Breaking Load of Sacking and Seam.   |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 6. | <b>लाइसेंसकादायरा/Scope of the Licence:</b>                                                                |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|    | “Licence is granted to use Standard Mark as per IS 15138: 2010 with the following scope:                   |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|    | Name of the product                                                                                        | JUTE BAGS FOR PACKING 50 KG SUGAR   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|    | Type                                                                                                       | Type A/Type B/Type C /Type C/Type D |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |

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

**ANNEX– A**

**LIST OF TEST EQUIPMENT**

**(INDICATIVE LIST, FOR GUIDANCE ONLY)**

| Sr. No. | Tests used in with Clause Reference                  | TestEquipment                                                                                                                                                                                                                           |
|---------|------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1       | Dimensions, CI5.1                                    | Steel Tape, Scale, Porter Gauge, Table                                                                                                                                                                                                  |
| 2       | Ends and Picks, CI5.1                                | Method A of IS1963:<br>Thread counter equipped with low power microscope<br>Or Ordinary counting glass with aperture satisfying 5.2 of IS1963<br>OR<br>Method B of IS1963:<br>Clamps of Type A, B or C as per 6.1 of IS1963 and forceps |
| 3       | Mass, CI5.1                                          | Table, Steel Scale, Weighing balance accurate to 0.005g, Drying oven                                                                                                                                                                    |
| 4       | Average breaking strength of sacking and seam, CI5.1 | Constant-rate-of-extension (CRE) Tensile testing machine capable of constant rates of extension of 20mm/min and 100 mm/min, with an accuracy of $\pm 10\%$ , equipment for cutting samples                                              |
| 5       | Moisture regain, CI5.1                               | 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 1mg 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                                                                                                   |

## ANNEX B

### SCHEME OF INSPECTION AND TESTING

#### 1. QUALITY ASSURANCE PLAN

1.1 It is expected that manufacturers(licensees/applicants) will implement a Quality Assurance Plan i.e. a plan of regular testing and in-process controls, designed to ensure that the product bearing the Standard Mark conforms to all requirements of the Indian Standard.

1.2 The manufacturers shall define a Quality Assurance Plan defining the control unit (i.e. lot/batch etc.) and the levels of control (i.e. the frequency and number of samples for conducting the different tests as per the Indian Standard) and submit the same to BIS Branch Office for information. The manufacturer shall comply with the same and maintain test records in accordance with para 2.4.

#### 1.3 RECOMMENDED LEVELS OF CONTROL/CONTROL UNIT:

1.3.1 For the guidance of manufacturers, the recommended definition of control unit is : all the bags of the same type manufactured in a day or part thereof.

1.3.2 For the guidance of manufacturers in preparing the Quality Assurance Plan, recommended levels of control are given in Table 1.

1.3.3 The manufacturer shall ensure inspection and testing as per the Quality Assurance Plan submitted by the month e whole production of the factory which is covered by this plan. Alternatively, the manufacturer has the option of adherence to the quality plan as per levels of control recommended in column 3 of Table 1.

1.4 However, all manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard.

**2. ENSURING COMPLIANCE THROUGH TESTING-** It is expected that manufacturers(licensees/applicants) will establish a suitably equipped and staffed in house laboratory (In house testing facility) for testing at least those parameters of the Indian Standard which require routine testing for ensuring quality of the product. This includes in-process controls as may be defined and put in place by the manufacturer and testing parameters/requirements which can only be performed in the factory.

2.1 For the guidance of manufacturers, Table 1 giving the recommended levels of control is given below. Column 2 of Table 1 indicates routine tests where test equipment is required in house as "R" or other tests which can be sub contracted as "S". Sub-contracting is permitted to BIS recognized/empaneled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025.

**2.2 For MSME manufacturers, the requirement of maintaining a laboratory/in-house testing facility for routine tests (indicated as "R" in Column 2 of Table 1) is also optional.**

2.2.1 MSME manufacturers may utilize common cluster based facilities as per guidelines for the utilization of cluster based test facilities by MSMEs or the provisions of Sharing of testing facilities or get testing done from BIS recognized/empaneled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025.

**2.3 Large Scale manufacturers shall maintain an in-house laboratory equipped at least with test facilities for routine tests (indicated as “R” in Column 2 of Table 1),** where different tests given in the specification shall be carried out in accordance with the method given in the specification. They shall also implement a calibration plan for the in-house test equipment.

2.3.1 Alternatively, in lieu of an in-house laboratory, large scale manufacturers can also utilize the provisions of Sharing of testing facilities as per the Guidelines for Grant of Licence available on BIS website [www.bis.gov.in](http://www.bis.gov.in). (Under Conformity Assessment>Product Certification Process). Even for sub contracted tests, provisions for sharing of testing facilities can be utilized.

**2.4 TEST RECORDS**-The manufacturers maintaining an in-house laboratory or utilizing common cluster based facilities or shared test facilities shall maintain test records for the tests carried out to establish conformity. For the tests being sub-contracted to BIS recognized/empaneled laboratory or any other laboratory having valid NABL accreditation as per IS/ISO/IEC 17025, test reports issued by the laboratories shall be available for inspection by BIS.

**3 PACKING AND MARKING** - The Standard Mark as given in the Schedule of the licence shall be incorporated legibly and indelibly on each bale provided always that the material so marked conforms to each requirement of the specification.

3.1 Packing and Marking shall be done as per the Indian Standard.

**3.2 Additional Marking requirements:** The material shall also be marked with the following additional requirement on each bale:

a) “For BIS certification details please visit [www.bis.gov.in](http://www.bis.gov.in)”

**4 REJECTION** - All the production which conforms to the Indian Standard and covered under the scope of this licence shall be marked with the Standard Mark. 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**  
**(ONLY FOR GUIDANCE PURPOSE)**

| (1)              |                                                          |                               |          | (2)                                                                            | (3)                                                                                                                                                                                                              |                   |                                                                       |
|------------------|----------------------------------------------------------|-------------------------------|----------|--------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|-----------------------------------------------------------------------|
| Test Details     |                                                          |                               |          | Test equipment requirement<br>R: required (or)<br>S: Sub-contracting permitted | Levels of Control                                                                                                                                                                                                |                   |                                                                       |
| Cl.              | Requirement                                              | Test Methods Clause Reference |          |                                                                                | No. of Sample                                                                                                                                                                                                    | Frequency         | Remarks                                                               |
| 4.1              | Fabric                                                   | 4.1                           | IS15138  | R                                                                              | One                                                                                                                                                                                                              | Each consignment  | No testing required if accompanied with test certificate of supplier. |
| 4.2              | Seam                                                     | 4.2                           | -do-     | R                                                                              | 5 Bags                                                                                                                                                                                                           | Every 4 hours     |                                                                       |
| 4.3              | Hemming at Mouth                                         | 4.3                           | -do-     | R                                                                              | -do-                                                                                                                                                                                                             | -do-              |                                                                       |
| 4.4              | Freedom from Defects                                     | 4.4                           | -do-     | R                                                                              | Firm to have adequate in-process controls to check compliance of this parameter as given in the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity |                   |                                                                       |
| 4.5              | Liner Material                                           | 4.5                           | IS 10146 | S                                                                              | One                                                                                                                                                                                                              | Each consignment  | For Type C/Type E bags                                                |
| 4.5              | Liner thickness                                          | 4.5                           | IS15138  | R                                                                              | One                                                                                                                                                                                                              | Each control unit | For Type C/Type E bags                                                |
| 5.1<br>(Table-1) | i)Dimension                                              | 8.3.2                         | IS 9113  | R                                                                              | -do-                                                                                                                                                                                                             | Every 4 hours     |                                                                       |
|                  | ii)Ends/dm                                               | 8.4.2                         | -do-     | R                                                                              | -do-                                                                                                                                                                                                             | -do               |                                                                       |
|                  | iii)Picks/dm                                             | 8.4.2                         | -do-     | R                                                                              | -do-                                                                                                                                                                                                             | -do               |                                                                       |
|                  | iv) Corrected Mass per bag                               | 8.5.2                         | -do-     | R                                                                              | -do-                                                                                                                                                                                                             | -do               |                                                                       |
|                  | v) Average breaking load of sacking(warp way & weft way) | 8.6.2                         | -do-     | R                                                                              | 5 bags                                                                                                                                                                                                           | Each control unit |                                                                       |

|              |                                                 |     |          |   |            |                   |                                                                                                                                                                                                |
|--------------|-------------------------------------------------|-----|----------|---|------------|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|              | vi) Average breaking load of seam(warp&weftway) | 8.7 | -do-     | R | -do-       | -do               |                                                                                                                                                                                                |
|              | vii)Moisture regain                             | 8.2 | -do-     | R | 5 Bags     | -do               |                                                                                                                                                                                                |
| 5.3(Table-2) | i) Total number of bags per bale                | 8.9 | -do-     | R |            | Each bale         |                                                                                                                                                                                                |
|              | ii) Number of joined bags per bundle of 25 bags | 5.3 | IS 15138 | R | 30 bundles | Each Control Unit | For strength testing of joined bags number of samples would correspond to number of joined bags in 30 bundles as selected incl.6.2 subject to a maximum of 5 joined bags taken up for testing. |
|              | iii) Contract Mass of a bale                    | 5.3 | IS 15138 | R | --         | Each bale         |                                                                                                                                                                                                |
|              | iv) Corrected net mass of a bale                | 8.1 | IS 9113  | R | --         | Each bale         |                                                                                                                                                                                                |
|              | v) Oil content                                  | 8.8 | IS 9113  | R | 2 bags     | Each Control Unit |                                                                                                                                                                                                |