



**PRODUCT MANUAL
FOR TEXTILES – A - TWILL JUTE BAGS
ACCORDING TO IS 1943:1995**

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.	Product	:	IS 1943:1995
	Title	:	Textiles – A - Twill Jute Bags - Specification
	No. of Amendments	:	05
2.	Sampling Guidelines:		
a)	Raw material	:	Sacking material shall conform to Cl 4.1 of IS 1943:1995
b)	Grouping guidelines	:	NA (No varieties of the product are specified in the Indian Standard)
c)	Sample Size	:	16 bags (Ref: LPPD Circular dated 18.08.2015)
3.	List of Test Equipment	:	Please refer ANNEX –A
4.	Scheme of Inspection and Testing	:	Please refer ANNEX –B
5.	Possible tests in a day :		
	All except average breaking load of sacking and seam		
6.	Scope of the Licence :		
	Licence is granted to use Standard Mark as per IS 1943:1995 with the following scope:		
	Name of the product	A-Twill Jute Bags	

ANNEX A

List of Test Equipment

Major test equipment required to test as per the Indian Standard

S. No.	Test Equipment	Test used in with clause reference
1.	Steel scale and tape, Flat Table	Dimensions of Bag – Cl 5.1
2.	Weighing Balance (accurate to 5 g)	Corrected Mass per bag – Cl 5.1
3.	Porter Gauge or Traversing thread counter or Forceps and clamps	Ends and Picks per dm – Cl 5.1
4.	Tensile Testing Machine	Average Breaking Load of sacking and seam (Revelled Strip Method) – Cl 5.1
5.	Weighing Balance	Mass of Bale – Cl 5.2
6.	Moisture Meter	Moisture Regain of Bale – Cl 5.2 and Contract Moisture Regain – CL 5.3
7.	Soxhlet Apparatus, Drying oven ($105\pm 3^{\circ}\text{C}$) – 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 of bale on dry deoiled material basis – Cl 5.2

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 Schedule of the license shall be stencilled with indelible ink, on each bale containing jute bags provided that the bags in the bale to which this mark is thus applied conforms to all requirements of specification

3.1 Packing and Marking shall be done as per the provisions of the Indian Standard. In addition, details of BIS licence no. CM/L- and BIS website shall be marked on each bale or a label attached to it as follows: "For details of BIS certification please visit www.bis.gov.in"

4. CONTROL UNIT: For the purpose of this scheme, all the bags of one size, dimensions, type of stitching and quality manufactured in a day 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 be tested, if same fabric is used.)

5. LEVELS OF CONTROL - The tests, as indicated in 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 SAMPLING FOR FLOOR INSPECTION: One bag shall be drawn every hour of production and tested for freedom from defects, dimensions, mass, moisture regain, ends and picks 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 All production which conforms to the Indian Standard and covered in the licence should be marked with Standard Mark.

6. 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. Any rejected material which is potentially re-salable be sheared or cut or deformed in such a manner that it cannot be used for any other purpose. A separate record shall be maintained giving information on quantity and batch number/control unit number, as applicable, relating to all such rejections/defective/sub-standard material of the production not conforming to the requirements of the Specification and the method of its disposal. Such material shall in no case be stored together with that conforming to the Specification. The Standard Mark (if already applied) on rejected material should be defaced.

SCHEME OF INSPECTION AND TESTING
TABLE 1: LEVELS OF CONTROL

(1)				(2)	(3)		(4)
Test Details				Test equipment requirement R:required (or) S: Sub- contracting permitted	Levels of Control		Remarks
Clause	Requirements	Test Method			No. of Samples	Frequency	
		Clause	Reference				
4.1	Sacking material	4.1	IS 1943	S	5 Bags	Each control Unit	See Note 3
4.2	Seam		IS 9113	R	-do-	-do-	
4.3	Safety Stitch		-do-	R	-do-	-do-	
4.4	Hemming at the mouth		-do-	R	-do-	-do-	
4.5	Joined Bag		-do-	R	-do-	-do-	
4.6	Freedom From Defects	4.6	IS 1943	R	30 bags	-do-	See 4.1 of SIT
5.1 & Table 1	Particulars of Bags				-do-	-do-	-do-
i)	Dimensions Outside length Outside width	8.3.2	IS 9113	R	-do-	-do-	-do-
ii)	Corrected Mass per Bag	8.5.2	-do-	R	-do-	-do-	-do-
iii)	Ends and Picks per dm		IS 1963	R	-do-	-do-	-do-
iv)	Average breaking load of sacking		IS 1969	R	-do-	-do-	-do-
v)	Average breaking load		IS 9030	R	-do-	-do-	-do-

	of seam						
5.2 and Table 2	Requirements of Packed Bales						
i)	Total number of bags per bale	8.9	IS 9113	R	-	Each Bale	
ii)	Number of joined bags per bundle of 25 bags	-do-	-do-	R	2 bundles	Per Bale	
iii)	Contract Mass of a bale			R		Each bale	
iv)	Corrected Net mass of a bale	8.1	IS 9113	R		-do-	
v)	Moisture regain	8.2	-do-	R	10 bags	Per bale	
vi)	Oil content on dry de-oiled material basis		IS 2969	R	2 bags	-do-	
5.3	Contract Moisture Regain	5.3	IS 1943	R	-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 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 to BO Head.

Note-3: No testing is required if material is accompanied with supplier/manufacturer's test certificate, or test report issued by BIS recognized/empaneled labs indicating conformity to the requirements of the specification.