



उत्पाद मानुयल
आटा
IS 1155: 2022 के अनुसार

PRODUCT MANUAL FOR
ATTA
ACCORDING TO IS 1155: 2022

भारतीय मानक ब्यूरो (अनुरूपता मूल्यांकन) विनियम 2018 की स्कीम-I के तहत यह उत्पाद मानुयल प्रमाणीकरणके प्रचलन में रीति और पारदर्शिता के सुसंगत सुनिश्चित करने के लिए सभी क्षेत्रीय/शाखा कार्यालयों एवं लाइसेन्स धारियों द्वारा संदर्भ सामग्री के रूप में उपयोग किया जाएगा। बीआईएस लाइसेन्स/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, 2018 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification licence/certificate.

1.	उत्पाद Product	:	IS 1155: 2022
	शीर्षक Title	:	आटा Atta
	संशोधन संख्या No. of Amendments	:	Nil
2.	नमूनाकरण दिशा निर्देश Sampling Guidelines:		
a)	कच्चा माल Raw material	:	कोई विशेष आवश्यकता नहीं No specific requirement
b)	समूहिकरण दिशा निर्देश Grouping guidelines	:	कृपया Annex-ए देखें Please see Annex – A
c)	नमूनेका परिमाण Sample Size	:	1000 gms
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	कृपया Annex-B देखें Please see Annex – B

4.	निरीक्षण व परीक्षण स्कीम Scheme of Inspection and Testing	:	कृपया Annex-C देखें Please see Annex – C
5.	एक दिन में संभावित परीक्षण Possible tests in a day :		
	i. Description ii. Microscopic appearance iii. Moisture iv. Total Ash v. Acid Insoluble Ash vi. Gluten vii. Crude fibre (on dry basis) viii. Alcoholic acidity (as H ₂ SO ₄) in 90 percent alcohol ix. Granularity ix. Uric Acid		
6.	लाइसेन्स का कार्यक्षेत्र / Scope of the Licence:		
	IS 1155: 2022 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 1155: 2022 with the following scope:		
	उत्पाद का नाम Name of the product	आटा Atta	
	Grade	Special and/or Standard	

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New Delhi – 110002

ANNEX – A
TO PRODUCT MANUAL FOR
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GROUPING GUIDELINES

1. There are two Grades of Atta (ref. Cl. 3 of IS 1155:2022):

i.	Special
ii.	Standard

2. The manufacturer shall declare the grade, which they intend to cover in the scope of licence. The sample of each grade to be drawn and shall be subjected to testing for considering grant of licence/inclusion of that grade.

3. It shall be ensured that the firm is having all the necessary manufacturing and testing facilities for the types to be included in the licence.

4. During the operation of licence, BO shall ensure that all the types of the product are covered in the license, are drawn for independent testing on rotation over a period of time

ANNEX – B
TO THE PRODUCT MANUAL FOR
ATTA ACCORDING TO IS 1155: 2022
List of test equipment

Sr. No.	Tests used in with Clause Reference	Test equipment
1.	Moisture Cl 4.4, Table 1 and Sl. No. (i)	Analytical balance (0-200 g, LC-0.01 mg), Aluminium or Porcelain or Silica or Platinum dish, Electric oven, Desiccator
2.	Total Ash Cl 4.4, Table 1 and Sl. No. (ii)	Porcelain or Silica or platinum dish, Analytical Balance, Burner, Muffle Furnace, Desiccator
3.	Acid Insoluble Ash Cl 4.4, Table 1 and Sl. No. (iii)	Porcelain or Silica or platinum dish, Weighing Balance, Water Bath, Watch glass, Filter paper(Whatman no.42 or its equivalent), Electric Air oven, Desiccator, Hydrochloric acid, Muffle furnace.
4.	Gluten Cl 4.4, Table 1 and Sl. No. (iv)	Weighing Balance, Beaker, Hot Air oven, Desiccator, Porcelain dish, Bolting silk cloth with an aperture of 0.16mm or 150 micron IS sieve, Iodine solution, Spatula
5.	Crude fibre Cl 4.4, Table 1 and Sl. No. (v)	Dilute Sulphuric Acid, Sodium Hydroxide solution, Ethyl Alcohol, Analytical balance, flask, Beaker, Reflux condenser, Heating mantle, Petroleum ether, Flat round bottom flask, Fat extraction flask fine linen (about 18 threads to the centimeter), funnel, litmus paper, Gooch crucible, ignited asbestos, Hot air oven –capable of operating at 105 + 2°C, Muffle furnace-capable of operating at 600+20°C, Desiccator.
6.	Alcoholic acidity (as H ₂ SO ₄) in 90 percent alcohol Cl 4.4, Table 1 and Sl. No. (vi)	Neutral Ethyl Alcohol, Standard Sodium Hydroxide solution, Phenolphthalein indicator solution, Analytical balance (0-200 g, LC-0.01 mg), conical stoppered flask, Filter paper, Burette.
7.	Granularity Cl 4.4, Table 1 and Sl. No. (vii)	Analytical balance (0-200 g, LC-0.01 mg), 600 micron IS sieve, brush.
8.	Uric Acid Cl 4.4, Table 1 and Sl. No. (viii)	Photo-Electric Colorimeter, Volumetric Flask (50 ml capacity), Burette, Nessler's Tubes, Sodium Tungstate Solution, Sulphuric Acid, Benedict's Uric Acid Reagent, Sodium Cyanide Solution
9.	Microscopic appearance Cl. 4.2	Microscope

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

ANNEX C
TO THE PRODUCT MANUAL FOR
ATTA
ACCORDING TO IS 1155: 2022
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 stencilled/printed on each bag or container of Atta or printed on the labels applied to the bag or container, as the case may be, provided always that the material in each container to which this mark is thus applied conforms to every requirement of the specification.

3.1 Packing –The product shall be packed in quantities as per provisions of Clause 5.1.1 of IS 1155:2022. The product shall be packed in DW-flour bags or HDPE woven sacks as per provisions of Clause 5.1.2 of IS 1155:2022.

3.2 Marking – The bags or containers of the product shall bear legibly and indelibly the information as mentioned under clause 5.2.1 of IS 1155:2022. In addition, the following details shall be mentioned on each bag or container:

a) BIS Licence No. CM/L _____

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 quantity of Atta manufactured continuously in a day from the same consignment of raw materials 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 Standards and covered by the licence should be marked with Standard Mark.

6. HYGIENIC CONDITIONS – The product shall be manufactured, packed and stored under hygienic conditions as per provisions of IS 2491, cross-referenced in clause 4.3 of IS 1155:2022.

7. REJECTIONS – Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of the provisions of BIS Act, 2016.

TABLE 1 (Levels of Control)
(Para 5 of Scheme of Inspection and Testing)

(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	Description: a) Colour, Taste and flavour b) Freedom from rancidity, insect, rodent or fungus infestation c) Freedom from fermented, musty or other objectionable odour d) Freedom from adulterants and any other extraneous matter, such as rodent hair or excreta	4.1	IS 1155	R	Firm to have adequate in-process controls to check compliance of this parameter as per the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity		
4.2	Microscopic appearance	4.2	IS 1155	R	Firm to have adequate in-process controls to check compliance of this parameter as per the tolerances given in the Indian Standard. However, appropriate records shall be maintained by the manufacturer for evidence of conformity		
Cl 4.4, Table 1, Sl.No. (i)	Moisture	Annex A	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(ii)	Total Ash	Annex B	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(iii)	Acid insoluble ash	Annex C	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(iv)	Gluten (on dry basis)	Annex D	IS 1155	R	One	Each Control unit	See Note 4 below

Cl 4.4, Table 1, Sl.No. (v)	Crude Fibre (on dry basis)	Annex E	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(vi)	Alcoholic acidity (as H ₂ SO ₄) in 90 percent alcohol	Annex F	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(vii)	Granularity	Annex G	IS 1155	R	One	Each Control unit	See Note 4 below
Cl 4.4, Table 1, Sl.No.(viii)	Uric Acid	---	IS 4333 (Part-5)	S	One	Once in a month	See Note 5 below

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.

Note 3: A sample shall be taken at the packing/repacking stage after every half an hour which shall be examined visually for colour, from rancidity, insect, rodent or fungus infestation and any other extraneous matter, such as rodent hair or excreta. It shall be examined by organoleptic methods for taste and flavor. It shall be free from rancidity and fermented, musty or other objectionable odour. If the sample does not conform to the specification in any one or more of these requirements, the material manufactured during the half an hour prior to drawal of sample shall be rejected for its conformity to these requirements of the specification

Note 4: One sample from every control unit shall be tested for the requirements of Moisture, Total Ash, Acid insoluble ash, Gluten (on dry basis), Crude Fibre (on dry basis), Alcoholic acidity (as H₂SO₄) in 90 percent alcohol and Granularity as laid down in the Indian Standard. If any one of these samples fail to conform to any one or more of these requirements as laid down in the Indian Standard, the entire control unit shall either be rejected or reprocessed for its conformity to these requirements.

Note-5: A sample shall be tested every month for Uric Acid. In case of failure of the sample, the root cause of failure shall be investigated, Corrective actions/Preventive be taken and dispatch to be kept on hold. Thereafter, the samples from two consecutive control units shall be tested for the parameter(s) where failure has occurred and once the same has been found to be conforming, original frequency of testing be restored and dispatch resumed.