



**उत्पाद मैनुअल
पृष्ठावारित सजावटी प्लाईवुड
आई एस 1328:2025**

**PRODUCT MANUAL
VENEERED DECORATIVE PLYWOOD
ACCORDING TO IS 1328:2025**

विभिन्न उत्पादों के लिए भारतीय मानक ब्यूरो) अनुरूपता मूल्यांकन (विनियम, 2018 की योजना -I 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। दस्तावेज़ का 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.	मानक संख्या IS No.	:	IS 1328:2025
	शीर्षक Title	:	Veneered Decorative Plywood
	संशोधनों की संख्या No. of amendments	:	Nil
2.	नमूना दिशानिर्देश Sampling Guidelines		
a)	कच्चा माल Raw material	:	Please refer to Annex-A Note: This section indicates the requirements for raw material (if specified in the IS) for which compliance is to be established during Grant of Licence/Change in Scope of Licence/ Factory Surveillance
b)	समूहीकरण दिशानिर्देश Grouping Guidelines	:	Please refer to Annex-B

c)	नमूने का परिमाण Sample Quantity	:	1 sheet Note: This section indicates the quantity of the sample of the product and/or the raw material (if applicable), required to be sent to the laboratory for testing, for the purpose of Grant of Licence/Change in Scope of Licence/ Factory Surveillance (incase of market surveillance, effort may be made to procure therequired quantity of product sample, as far as possible since raw material sample may not be available in market)
d)	परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर Parameters to be Declared in Test Request	-	Same as the scope of licence
3.	परीक्षण उपकरणों की सूची List of Test Equipment	:	Please refer to Annex-C
4.	निरीक्षण और परीक्षण की स्कीम Scheme of Inspection and Testing	:	Please refer to Annex-D
5.	एक दिन में संभावित परीक्षण Possible tests in a day		
	(i) Manufacture (Cl 6), (ii) Surface requirements (Cl 7), (iii) Dimensions and tolerances (Cl 8), (iv) workmanship and finish (Cl 9).		
6.	लाइसेंस का दायरा /Scope of the Licence:		
	Licence is granted to use Standard Mark as per IS 1328:2025 with the following scope:		
	Name of the product	Veneered Decorative Plywood	
	Grade	MR/ BWR/ BWP	
	Type	Type 1/ Type 2/ Type 3/ Type 4	
	Formaldehyde Class	E1 / E2	
	Thickness	Thickness upto and including – mm	
	Steady-State Formaldehyde Emission test (optional test) (Cl 11.6)	With/ without	

भारतीय मानक ब्यूरो
 BUREAU OF INDIAN STANDARDS
 मानक भवन, ९, बहादुर शाह ज़फ़र मार्ग
 Manak Bhawan, 9, Bahadur Shah Zafar Marg
 नई दिल्ली- ११०००२
 New Delhi – 110002

ANNEX- A

Details of Raw Materials

Raw Material	Indian Standard
Adhesive (Clause 5.2)	Adhesive shall conform to IS 848
Plywood (Clause 5.3)	Plywood used as a base in the manufacture of veneered decorative plywood, shall conform to Clause 5.3 of IS 1328:2025

ANNEX B

Grouping Guidelines

1. Veneered decorative Plywood are classified based on the parameters as given below:
 - a) Type: Type 1, Type 2, Type 3, Type 4

(Requirements of Type 1 is stringent than Type 2. Type 3 surface plywood uses the plurality of veneers for decorative faces. Type 4 surface is as agreed between the manufacturer and purchaser.)
 - b) Grade: MR, BWR, BWP
 - c) Thickness: 3,4,5,6,9,12,15,19,22 and 25
Any other thickness as agreed to between the manufacturer and the purchaser may also be used.
 - d) Formaldehyde Class : E_1 / E_2
 - e) Steady-State Formaldehyde Emission test (optional test) (Cl 11.6) : with/ without
2. Considering the above following grouping guidelines for GoL/CSoL have been developed:
 - a) One sample of each Type, Grade & Formaldehyde Class shall be tested for all requirements in order to cover that particular Type, Grade & Formaldehyde Class.
 - b) Highest thickness of plywood shall be tested for all requirements to cover plywood of all thicknesses upto and including the thickness tested.
 - c) One sample of plywood shall be tested for the optional test, i.e. Steady-State Formaldehyde Emission test (Cl 9.12) to cover the same in the scope of licence.
 - d) If veneered decorative plywood of Type 1 is tested, then plywood of Type 2 may also be covered.
3. The Firm shall declare the varieties (i.e. Type, Grade, Thickness, Formaldehyde Class and Claim for Steady-State Formaldehyde Emission) of veneered decorative plywood they intend to cover in the Licence. The Scope of Licence may be restricted based on the Manufacturing capability and Testing facilities of the Manufacturer.
4. During the operation of the Licence, BO shall ensure that all the Varieties covered in the Licence are tested in rotation to the extent possible.

ANNEX C

List of Test Equipment

(INDICATIVE LIST, FOR GUIDANCE ONLY)

Sl. No.	Tests used in with Clause Reference	Test Equipment
1	Adhesive (Clause 5.2)	Moisture Meter Hydrometer Thermometer IS Sieve Electronic Balance pH Meter, Enamelled Tray
2	Dimensions (Clause 8), Manufacture (Clause 6) Surface requirements (Clause 7)	Measuring Tape Steel Scale Micro Meter Vernier Caliper Squareness Gauge Straight Edge Feeler Gauge
3	Moisture content (Clause 11.3)	Hot Air Oven with fan & Temperature control Electronic Balance
4	Water Resistance test (Clause 11.4)	Saw Cutter Vernier caliper Knife as per IS 1734 (Part 5) Stout Table Water Bath with temp control & pump
5	Formaldehyde content test (perforator method) (Clause 11.5)	Toluene, Iodine standard solution, Sulphuric acid, Sodium thiosulphate Sodium hydroxide Starch Acetylacetone Ammonium Acetate Weighing balance Drying oven Extraction Apparatus as per fig.1 of IS 13745

ANNEX D

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 veneered decorative plywood of the same Type, Grade, Thickness, Formaldehyde Class, Claim for Steady-State Formaldehyde Emission and similar construction, manufactured under similar conditions on the same day in one press from same mix of adhesives shall constitute a control unit. (Panels in which the arrangement of veneers is similar as regards thickness and species of timber for face plies, shall be considered to be of similar construction)

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 them on the 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 subcontracted as “S”. Subcontracting is permitted to BIS recognized/empanelled 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. (Under Conformity Assessment>Product Certification Process). Even for subcontracted 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 subcontracted to BIS recognized/empanelled 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 indelibly and legibly marked or stamped, provided always that the product so marked conforms to each requirement of the Standard.

3.1 Marking shall be done as per Clause 12 of IS 1328:2025.

3.2 Additional Marking requirements: Each decorative plywood, shall also be marked with the following additional requirement:

“For BIS certification details, please visit 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 R: required (or) S: Sub-contracting permitted	Levels of Control		
Cl.	Requirement	Test Methods			No. of Sample	Frequency	Remarks
		Clause	Reference				
5.1	Timber	5.1	IS 1328	-	One	Each lot received	Record of each lot of timber received shall be maintained
5.2	Adhesive	5.2	IS 1328 IS 848	R	One	Each lot manufactured/ received	No further testing is required, if material received with test certificate or ISI Marked.
5.3	Plywood	5.3	IS 1328 IS 303	R	One	Each consignment	
6	Manufacture	6.1 to 6.4	IS 1328	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		
	Treatment	6.5	IS 1328	R			
7	Surface Requirements	7.1 to 7.4	IS 1328	R			
8	Dimensions and Tolerances	8.1 to 8.3	IS 1328	R			
9	Workmanship & Finish	9	IS 1328	R			
11.3	Moisture Content	11.3	IS 1328 IS:1734 (Pt 1)	R	One	Each control unit	
11.4	Water Resistance Test	11.4	IS 1328 IS 1734 (Pt 5)	R	One	Each control unit	
11.5	Formaldehyde content, F_c , - perforator method	11.5	IS 710 IS 13745	S	One	Once in a month	Each Formaldehyde Class produced during the period shall be tested
11.6	Steady-state Formaldehyde emission, F_c mg/m ³ (optional test)	11.6	IS 14587 IS/ISO 12460-1	S	One	Once in a year	Each Formaldehyde Class produced during the period shall be tested