



उत्पाद मैनुअल  
वस्त्रादी – ए - ट्विल पटसन के बोरे — विशिष्टि  
IS 1943:2026 के अनुसार

PRODUCT MANUAL FOR  
Textiles – A - Twill Jute Bags - Specification  
ACCORDING TO IS 1943 :2026

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<br>IS No.                                                                        | : | IS 1943: 2026                                            |
|    | शीर्षक<br>Title                                                                              | : | Textiles – A - Twill Jute Bags - Specification           |
|    | संशोधनों की संख्या<br>No. of amendments                                                      | : | Nil                                                      |
| 2. | नमूना दिशानिर्देश<br>Sampling Guidelines                                                     |   |                                                          |
| a) | कच्चा माल<br>Raw material                                                                    | : | Sacking material shall conform to CI 4.1 of IS 1943:2026 |
| b) | समूहीकरण दिशानिर्देश<br>Grouping Guidelines                                                  | : | Not Applicable                                           |
| c) | नमूने का परिमाण<br>Sample Quantity                                                           | : | 16 bags (Ref: LPPD Circular dated 18.08.2015)            |
| d) | परीक्षण अनुरोध में घोषित किए जाने वाले पैरामीटर<br>Parameters to be Declared in Test Request | : | Textile - A-Twill Jute Bags                              |
| 3. | परीक्षण उपकरणों की सूची<br>List of Test Equipment                                            | : | Please refer Annexure - A                                |
| 4. | निरीक्षण और परीक्षण की स्कीम<br>Scheme of Inspection and Testing                             | : | Please refer Annexure - B                                |

|                     |                                                                                                                                                                                                                                                                                                                                                                                     |                     |                             |
|---------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------|-----------------------------|
| 5.                  | एक दिन में संभावित परीक्षण<br><b>Possible tests in a day</b>                                                                                                                                                                                                                                                                                                                        |                     |                             |
|                     | <p>All tests except average breaking load of sacking and seam</p> <p>Note: This section is for the guidance of BIS Certification Officers/Technical Auditors of BIS Authorized Outside Surveillance Agencies (OSAs) during factory inspection to provide readyreference regarding the tests which can be witnessed during the inspection in the factory by the officer/auditor.</p> |                     |                             |
| 6.                  | <b>लाइसेंस का दायरा /Scope of the Licence:</b>                                                                                                                                                                                                                                                                                                                                      |                     |                             |
|                     | Licence is granted to use Standard Mark as per 1943: 2026 with the following scope:                                                                                                                                                                                                                                                                                                 |                     |                             |
|                     | <table> <tr> <td>Name of the product</td><td>Textiles- A-Twill Jute Bags</td></tr> </table>                                                                                                                                                                                                                                                                                         | Name of the product | Textiles- A-Twill Jute Bags |
| Name of the product | Textiles- A-Twill Jute Bags                                                                                                                                                                                                                                                                                                                                                         |                     |                             |

**BUREAU OF INDIAN STANDARDS**  
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**Annexure A**

**LIST OF TEST EQUIPMENTS**

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

| <b>SI No.</b> | <b>Test Used in with Clause Reference</b>                                  | <b>Test Equipment/ Chemical</b>                                                                                                                                                                                                                                                               |
|---------------|----------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1.            | Dimensions of Bag – CI 5.1                                                 | Steel scale and tape, Flat Table                                                                                                                                                                                                                                                              |
| 2.            | Corrected Mass per bag – CI 5.1                                            | Weighing Balance (accurate to 5 g)                                                                                                                                                                                                                                                            |
| 3.            | Ends and Picks per dm – CI 5.1                                             | Porter Gauge or Traversing thread counter or Forceps and clamps                                                                                                                                                                                                                               |
| 4.            | Average Breaking Load of sacking and seam (Revelled Strip Method) – CI 5.1 | Tensile Testing Machine                                                                                                                                                                                                                                                                       |
| 5.            | Mass of Bale – CI 5.2                                                      | Weighing Balance                                                                                                                                                                                                                                                                              |
| 6.            | Moisture Regain – CI 5.1<br>Contract Moisture Regain – CI 5.3              | Moisture Meter                                                                                                                                                                                                                                                                                |
| 7.            | Oil content of bale on dry deoiled material basis – CI 5.1                 | Soxhlet Apparatus, Drying oven ( $105\pm3^{\circ}\text{C}$ ) – 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 |

## Annexure B

### SCHEME OF INSPECTION AND TESTING

#### 1. QUALITY ASSURANCE PLAN

1.1 It is expected that during operation of BIS licence, manufacturers will implement a Quality Assurance Plan (QAP) 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 (QAP) defining the control unit (i.e. lot/batch etc.), the levels of control (i.e. the frequency and number of samples for conducting the different tests as per the Indian Standard) and declare the arrangement for testing i.e. whether in-house or subcontracting/sharing for each applicable test and submit the same to BIS Branch Office for information. The manufacturer shall comply with the QAP and maintain test records in accordance with para 2.1.

#### 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 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.).

1.3.2 For the guidance of manufacturers in preparing the Quality Assurance Plan, recommended levels of control are given in **Table 1**. Manufacturer has the discretion of declaring their own levels of control or accept the levels of control given in this document.

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.

**2. ENSURING COMPLIANCE THROUGH TESTING-** manufacturers shall ensure compliance of their products to all the requirements of the Indian Standard for which they may have in-house test facilities. However, there is no obligation to maintain in-house laboratory. Licensee may use alternative arrangements for tests of the production as per the declared QAP. Various alternatives are available for operation of BIS certification as given below and the relevant guidelines for availing such relaxations by the manufacturers, as amended from time to time, are to be referred:

- i) Shared testing resources like common facility,
- ii) Cluster based testing facility,
- iii) Sub-contracting to outside laboratories which may either be:
  - a) BIS recognised/empanelled laboratories, or
  - b) Any accredited laboratory as per ISO/IEC 17025

**2.1 TEST RECORDS-** The manufacturers shall maintain test records for the tests carried out (either in-house or at a sub-contracted or at shared test facility) to establish conformity of the product to the Standard for operation of licence. For the tests being subcontracted or conducted at a shared test facility, test results issued by the laboratories or test facilities, shall be made available for inspection by BIS.

**3. PACKING AND MARKING** - The Standard Mark as given in the Schedule of the licence shall be stenciled with indelible ink, on each bale containing jute bags provided always that the bags in the bale to which this mark is thus applied conforms to each requirement of the specification.

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

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

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

**4. REJECTION -** 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.

**TABLE 1: LEVELS OF CONTROL**  
**(Recommended Levels of Control by BIS- For Guidance Only)**

| (1)             |                                            |             |                 | (2)                                                                                                                                                                                                                                  |                   | (3)                                                                                |
|-----------------|--------------------------------------------|-------------|-----------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|------------------------------------------------------------------------------------|
| Test Details    |                                            |             |                 | Levels of Control                                                                                                                                                                                                                    |                   | Remarks                                                                            |
| Clause          | Requirements                               | Test Method |                 | No. of Samples                                                                                                                                                                                                                       | Frequency         |                                                                                    |
|                 |                                            | Clause      | Reference       |                                                                                                                                                                                                                                      |                   |                                                                                    |
| 4.1             | Sacking material                           | 4.1         | IS 1943         | One                                                                                                                                                                                                                                  | Each Consignment  | No testing is required if accompanied with supplier/manufacturers test certificate |
| 4.2             | Seam                                       | 4.2         | IS 9113         | 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. |                   |                                                                                    |
| 4.3             | Safety Stitch                              | 4.3         | -do-            |                                                                                                                                                                                                                                      |                   |                                                                                    |
| 4.4             | Hemming at the mouth                       | 4.4         | -do-            |                                                                                                                                                                                                                                      |                   |                                                                                    |
| 4.5             | Joined Bag                                 | 4.5         | -do-            |                                                                                                                                                                                                                                      |                   |                                                                                    |
| 4.6             | Freedom From Defects                       | 4.6         | IS 1943 Annex A |                                                                                                                                                                                                                                      |                   |                                                                                    |
| 5.1 and Table 1 | Particulars of Bags                        |             |                 |                                                                                                                                                                                                                                      |                   |                                                                                    |
| i)              | Dimensions Outside Length Outside width    | 8.3.2       | IS 9113         | 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. |                   |                                                                                    |
| ii)             | Corrected Mass per Bag                     | 8.5.2       | -do-            |                                                                                                                                                                                                                                      |                   |                                                                                    |
| iii) & iv)      | Ends and Picks per dm                      | 8.4.1       | -do-            |                                                                                                                                                                                                                                      |                   |                                                                                    |
| v)              | Average breaking load of sacking           | 8.6.2       | -do-            | One                                                                                                                                                                                                                                  | Each Control Unit | Please refer Note under CI 1.3.1 of SIT                                            |
| vi)             | Average breaking load of seam              | 8.7         | -do-            | -do-                                                                                                                                                                                                                                 | -do-              |                                                                                    |
| vii)            | Moisture regain                            | 8.2         | -do-            | -do-                                                                                                                                                                                                                                 | -do-              |                                                                                    |
| viii)           | Oil content on dry de-oiled material basis | 8.8         | -do-            | -do-                                                                                                                                                                                                                                 | -do-              |                                                                                    |
|                 |                                            |             |                 |                                                                                                                                                                                                                                      |                   |                                                                                    |

|                    |                                                   |     |         |      |           |  |
|--------------------|---------------------------------------------------|-----|---------|------|-----------|--|
|                    |                                                   |     |         |      |           |  |
| 5.2 and<br>Table 2 | Requirements of Packed Bales                      |     |         |      |           |  |
| i)                 | Total number of<br>bags per bale                  | 8.9 | IS 9113 | -    | Each Bale |  |
| ii)                | Number of joined<br>bags per bundle of<br>25 bags |     |         | Two  | Each Bale |  |
| iii)               | Contract Mass of a<br>bale                        |     |         | One  | Each bale |  |
| iv)                | Corrected Net mass<br>of a bale                   | 8.1 | IS 9113 | -do- | -do-      |  |
| 5.3                | Contract Moisture<br>Regain                       | 5.3 | IS 1943 | -do- | -do-      |  |