PRODUCT MANUAL
FOR
SQUARE TINS – 15 kg/litre FOR GHEE, VANASPATI, EDIBLE OILS AND BAKERY SHORTENINGS ACCORDING TO IS 10325: 2000

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 10325: 2000
	Title	:	Square Tins – 15 kg/litre For Ghee, Vanaspati, Edible Oils and Bakery Shortenings
	No. of Amendments	:	NIL
2.	**Sampling Guidelines:**		
a)	**Raw material**	:	As per cl. 4.2 of IS 10325
b)	**Grouping guidelines**	:	Not Applicable
c)	**Sample Size**	:	3 Square Tins
3.	**List of Test Equipment**	:	Please refer **ANNEX – B**
4.	**Scheme of Inspection and Testing**	:	Please refer **ANNEX – C**
5.	**Possible tests in a day**	**:**	All Tests
6.	**Scope of the Licence:**		
	"Licence is granted to use Standard Mark as per IS 10325:2000 with the following scope:		
	Name of the Product		Square Tins – 15 kg/15 litres for Ghee, Vanaspati, Edible Oils and Bakery Shortenings

ANNEX A

List of Test Equipment

Major test equipment required to test as per the Indian Standard

Sl. No.	Tests used in with Clause Reference	Test Equipment
1	Dimensions and Tolerances (Clause 4.1)	(i) Measuring Scale (ii) Micrometer (iii) Thickness Gauge (iv) Vernier Caliper
2	Air Pressure Test (Clause 5.1)	(i) Air Pressure Testing Equipment (ii) Pressure gauge (iii) Stop watch
3	Handle Pull Test (Clause 5.2)	(i) Handle Pull Testing Equipment (ii) Pressure Gauge (iii) Spring Balance (iv) Stop Watch
4	Hydraulic Pressure Test (Clause 5.3)	(i) Hydraulic Pressure Testing Equipment (ii) Pressure Gauge (iii) Stop watch

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

ANNEX C

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 equipments.

2. TEST RECORDS – The manufacturer shall maintain test records for the tests carried out to establish conformity.

3. LABELLING AND MARKING – As per IS 10325: 2000.

4. CONTROL UNIT – All the tins of the same type manufactured from the same material under similar condition of production in one shift (eight hours production) 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. REJECTIONS – 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

(1) Test Details				(2)	(3) Levels of Control		
Cl.	Requirement	Test Method		Test equipment requirement R: required (or) S: Sub-contracting permitted	No. of Sample	Frequency	Remarks
		Clause	Reference				
4.2	**Material**						
	a) Thickness of tin plates	4.2.1	IS 10325	S	3	Each Consignment	No further testing is required if the consignment is received with test certificate or ISI marked.
	b) Coating of tin plate	4.2.1.1	IS 10325	S	1	Each Consignment	
	c) Handle	4.2.2	IS 10325	S	3	Each Consignment	
	d) Solder	4.2.3. 4.2.3.1	IS 10325	S	1	Each Consignment	
	e) Sealing Compound	4.2.4	IS 10325	S	1	Each Consignment	
4.1	**Dimensions and tolerances**						
	a) Tin	4.1 & Fig 1	IS 10325	R	1	Each Control Unit	
	b) Handle	4.3.5 & Fig 6	IS 10325	R	1	Each Control Unit	
	c) Closure	4.3.4 & Fig 4 & 5	IS 10325	R	The sampling plan for initial acceptance of the lot of closures is given at Annex 1		
4.3	Manufacture	4.3.1, 4.3.2, 4.3.3, 4.3.4	IS 10325	R	Every Tin		
4.3.7, 4.3.8	Internal and Outside Finish	4.3.7, 4.3.8	IS 10325	R	Every Tin	Visual Inspection	
5.1	Air-Pressure Test	5.1	IS 10325	R	Every Tin		In case of failure, defective tins shall be rejected
5.2	Handle Pull Test	5.2	IS 10325	R	1	Every continuous two hours production.	In case of failure, all the tins shall be tested those found defective shall be rejected
5.3	Hydraulic Pressure Test	5.3	IS 10325	R	1	Every continuous four hours production.	

Note-1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empanelled by the Bureau.

Note-2: The control unit and levels of control as decided by the Bureau are obligatory, to which the licensee shall comply with.

Annexure I

Sampling Plan for Closures for Tins as per IS 10325: 2000

1. Lot – All the closures of the same type manufactured from the same material under similar conditions of production shall be grouped together to constitute a lot.

2. Sampling Size – The number of the closures to be selected from the lot at random depends upon the size of the lot and shall be in accordance with Table A.

TABLE A

LOT SIZE	SAMPLE SIZE	ACCEPTANCE NUMBER
Upto 3000	50	2
3001 to 10,000	80	3
10,001 to 35,000	125	5
35,001 and above	200	-

3. CRITERIA FOR CONFORMITY

3.1 Each of the closure selected shall be tested for the requirements given in IS 10325. A closure failing to meet these requirements shall be termed as defective. The lot shall be considered as conforming to the requirements if the number of defectives is less than or equal to the corresponding acceptance number given in Table 1.