



CENTRAL MARKS DEPARTMENT – 3

Our Ref: CMD-3/16:694

Date : 25/09/2012

**Implementation of IS 694 : 2010 'Polyvinyl Chloride Insulated Unsheathed and Sheathed Cables/Cords with Rigid and Flexible Conductor for Rated Voltages up to and including 450/750 V ( Fourth Revision) alongwith Amendment No. 1 September 2012'**

1. IS 694:2010 'Polyvinyl Chloride Insulated Unsheathed and Sheathed Cables/Cords with Rigid and Flexible Conductor for Rated Voltages up to and including 450/750 V ( Fourth Revision) was published sometime back, but could not be implemented due to certain discrepancies. Now Amendment No.1 September 2012 upon these discrepancies has been brought out. ETD has indicated for the implementation of the IS along with the Amendment.
2. The publication of above IS has already been communicated to ROs/BOs vide CMD-3/16:694 dated 18 05 2011 (copy attached). Through this circular comment/ feedback on the proposal for the IS's implementation were solicited from ROs/BOs/CMD-1.
3. The comments received carried opinions from licensees, which were in agreement for implementation of the revised IS, and some sought 6-8 months time for preparation for switchover.
4. The product is under mandatory BIS Certification vide Electrical Wires, Cables, Appliances and Protection Devices and Accessories (Quality Control) Order, 2003.
5. The IS 694:2010 is available online. The Amendment No.1 September 2012 is attached herewith.
6. Draft STI has been prepared and is attached herewith.
7. ROs/ BOs , having the licences in their jurisdiction, may depute an officer to scrutinize the IS/ Amendment/ draft STI. The comments/ views on these may be sent to CMD-3 immediately, but not beyond **10 October 2012**.
8. It is proposed to implement the IS immediately thereafter.

Encls: As above

Sc F & H (CMD-3)

( S M Shahid )  
Sc E/ Director

Circulated to: ROs/BOs/CMD-1/CL/ETD

CMD-1 – for actions for notification as per WTO/TBT requirement

Copy to: ITS – with request to host the circular on INTRANET



Our Ref: CMD III/16: 694 / 704

Date: 18/05/2011

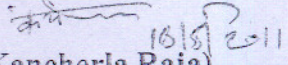
Sub: Proposal for implementation of revised IS 694:2010 (Fourth Revision),  
Superceding IS 694:1990.

CMD-3 vide note dated 26/05/2009 (with a reminder dated 03/09/2009) has circulated F-document of revised IS 694:2009 - Polyvinyl Chloride Insulated Unsheathed and Sheathed Cables/Cords with rigid and flexible conductor for rated voltages upto and including 450/750V. On printing, this revised Standard will supercede the earlier version of IS 694:1990.

ETD has requested CMD-3 to inform the date of implementation of the above revised Standard which is now being finalized as IS 694:2010. Before, CMD-3 decides the date of implementation, ROs/BOs operating the licences as per IS 694 are requested to note the following:

- In the latest revision, Cold bend/Cold Impact test has been indicated as one of the type test for 'insulation' for all types of cables; where as in the earlier revision, the test was applicable only for the cables intended for low-temperature conditions. Also, Cold bend/Cold Impact test is not indicated for type testing of 'sheath'.
- In the latest revision, Thermal Stability test has been added for all types of cables.
- In view of the above all existing licensees are required to upgrade the material for Insulation/Sheath to meet the additional test requirements and also to equip themselves with the additional test equipments.

Feedback from ROs/BOs/CMD-1 (as a large no.of licences are under operation, especially under CRO and WRO) regarding date of implementation may please be sent to CMD-3 immediately, so as to convey the same to ETD.

  
(Kancherla Raja)  
Scientist-E (CMD-3)

Sc.F & Head (CMD-III)

Circulated to all ROs/BOs/CMD-I/CL

Copy to: ETD - for information.

Pl. circulate

**AMENDMENT NO. 1 SEPTEMBER 2012  
TO  
IS 694 : 2010 POLYVINYL CHLORIDE INSULATED  
UNSHEATHED AND SHEATHED CABLES/CORDS WITH  
RIGID AND FLEXIBLE CONDUCTOR FOR RATED  
VOLTAGES UP TO AND INCLUDING 450/750 V**

*(Fourth Revision)*

*(Foreword, para 2, last sentence)* — Delete.

*(Foreword, para 2)* — Insert the following after para 2:

‘The third revision was brought out in 1990 in which the terms used for the type of cables for use under special conditions had been rationalized, single core flexible cables and five core flexible cords had been added, overall dimensions had been stipulated and reference to the Indian Standards on conductor, insulation, sheath and methods of tests had been added. Also for single core sheathed cables, the process of single extrusion of insulation and sheath had been deleted. The fourth revision of this standard has been brought out to take into account the experience gained since then to align with the international practices, to the extent considered appropriate.’

*[Foreword, para 3 (d)]* — Substitute the following for existing:

‘d) Thermal stability test included for both insulation and sheath.’

*[Foreword, para 3 (e)]* — Delete the word ‘expanded’.

*(Page 1, clause 1.1, line 11)* — Delete the word ‘category’.

*(Page 1, clause 1.1, Note 3, last line)* — Substitute ‘1 125 V’ for ‘1 500 V’.

**Price Group 2**

**Amendment No. 1 to IS 694 : 2010**

(Page 1, clause 1.1, Note 9, Section 2) — Insert 'Non-sheathed' before 'Single core'.

(Page 2, clause 3.6, para 2) — Substitute 'expressed' for 'expresses'.

(Page 2, clause 4.1) — Substitute the following for existing clause:

**4.1 Material**

The conductor shall be composed of annealed, bare or tinned high conductivity copper wires complying with IS 8130.

The conductor shall be composed of aluminum wires complying with IS 8130.

A separator tape made of suitable material may be applied over conductor at the discretion of the manufacturer.'

[Page 3, clause 5.1 (c)] — Substitute the following for the existing:

'c) Type D – Flexible cords'

(Page 6, clause 13, Informal table) — Insert 'Earth continuity conductor ECC and suitable for low temperature SZ' after PVC sheath.

(Page 6, clause 15.2(d), line 2) — Insert 'and halogen' after smoke.

[Page 7, Table 1, Sl No. (ii), (e), col 2] — Insert 'and sheath' after insulation.

[Page 7, Table 1, Sl No. (ii), (f), col 2] — Insert 'and sheath' after insulation.

[Page 7, Table 1, Sl No. (ii), (f), col 4] — Substitute 'IS 5831' for 'IS 8130'.

[Page 7, Table 1, Sl No. (ii), (g), col 4] — Substitute 'IS 5831' for 'IS 8130'.

Amendment No. 1 to IS 694 : 2010

[Page 7, Table 1, Sl No. (iii), (c) (8), col 3] — Substitute '02' for '01,02,FR and FR-LSH'.

[Page 7, Table 1, Sl No. (iii), (c) (9), col 3] — Substitute '02, FR and FR-LSH' for '01,02,FR and FR-LSH'.

[Page 7, Table 1, Sl No. (iii), (d) (11), col 2] — Insert the following after 11):

'12) Cold bend test	02	IS 5831	20
13) Cold impact test	02	IS 5831	21'

[Page 7, Table 1, Sl No. (iii), (e) (2), col 2] — Delete and renumber the subsequent numbers.

(Page 9, Section 2) — Insert 'NON-SHEATHED' before SINGLE CORE CABLES in the title.

(Page 9, clause 16) — Substitute the following for the existing title:

'SINGLE CORE NON-SHEATHED CABLES WITH RIGID CONDUCTOR (CLASS 1 OR CLASS 2) FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C)'

(Page 9, clause 17) — Substitute the following for the existing title:

'SINGLE CORE NON-SHEATHED CABLES WITH FLEXIBLE CONDUCTOR FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C)'

(Page 10, clause 18) — Substitute the following for the existing title:

'SINGLE AND MULTICORE CIRCULAR PVC INSULATED AND SHEATHED CABLES WITH RIGID CONDUCTOR (CLASS 1 OR CLASS 2) FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C)'

**Amendment No. 1 to IS 694 : 2010**

(Page 11, clause 18.2) — Substitute the following for the existing clause:

**'18.2 Tests**

The compliance with the requirement of 18.1 shall be checked by inspection and by tests given in Table 1.'

(Page 11, clause 19) — Substitute the following for the existing title:

**'SINGLE AND MULTICORE CIRCULAR PVC INSULATED AND SHEATHED CABLES/CORDS WITH FLEXIBLE CONDUCTOR (CLASS 5) FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C).'**

(Page 12, clause 19.1.5, para 1, line 1) — Substitute the following for the existing line

'The sheath shall be PVC compound type ST3 in'.

(Page 12, clause 19.1.5, para 4) — Substitute the following for the existing para:

'The thickness of PVC sheath determined by taking average of number of measurements shall not be less than nominal value ( $t_s$ ) specified in Table 5 for fixed installation and Table 6 for flexible PVC insulated and sheathed cables and Table 7 for flexible insulated and sheathed cords and flexible twin twisted and twin parallel cable by more than  $0.1 \text{ mm} + 0.15 t_s$ .'

(Page 12, clause 20) — Substitute the following for the existing title:

**'MULTICORE CIRCULAR PVC INSULATED AND SHEATHED CABLES WITH FLEXIBLE CONDUCTOR (CLASS 5) FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C).'**

(Page 12, clause 20.1.3, para 1, line 3) — Substitute 'Lay-up of cores' for 'lay of cores'.

Amendment No. 1 to IS 694 : 2010

(Page 12, clause 20.1.4, line 1) — Delete 'For sheathed cable'.

(Page 13, Table 6, col 4 to col 8) — Substitute the following for the existing heading:  
'Nominal Thickness of sheath,  $t_s$ '.

(Page 13, Table 7) — Substitute the following for the existing table heading:

'Flexible PVC Insulated and Sheathed Cords (Circular) and Flexible Twisted Twin and Parallel Twin Cable'

(Page 13, Table 7, col 4 to col 8) — Substitute the following for the existing heading:

'Nominal Thickness of Sheath,  $t_s$ '.

(Page 14, clause 21) — Substitute the following for the existing clause:

'PARALLEL TWIN AND TWISTED TWIN FLEXIBLE PVC INSULATED  
NON-SHEATHED CORDS WITH FLEXIBLE CONDUCTOR (CLASS 5)  
FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C)'

(Page 12, clause 21.1.2, line 5) — Substitute 'Table 7' for 'Table 10'.

(Page 12, clause 21.1.3, last sentence) — Substitute the following for the last line:

'The dimension shall be as per Table 7 and the lay up of cores shall be as per Table 8.'

(Page 12, clause 20.1.4, last para) — Delete 'The sheath shall be absent in case of unsheathed cable'.

(Page 14, clause 22) — Substitute the following for the existing clause:

**Amendment No. 1 to IS 694 : 2010**

**'TWO AND THREE CORE FLAT CABLES WITH PVC INSULATION AND SHEATH HAVING STRANDED OR FLEXIBLE CONDUCTOR (CLASS 2 OR CLASS 5) FOR GENERAL PURPOSE (70°C) OR HEAT RESISTANT (85°C)'**

(ETD 09)

Reprography Unit, BIS, New Delhi, India

**SCHEME OF TESTING AND INSPECTION  
FOR CERTIFICATION OF  
POLYVINYL CHLORIDE INSULATED UNSHEATHED AND SHEATHED  
CABLES/CORDS WITH RIGID AND FLEXIBLE CONDUCTOR FOR  
RATED VOLTAGES UP TO AND INCLUDING 450/750 V  
ACCORDING TO IS 694:2010**

1. **LABORATORY** – A laboratory shall be maintained which shall be suitably equipped and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.
  - 1.1 All testing apparatus shall be periodically checked and calibrated. Records of such checks/calibration shall be maintained.
2. **TEST RECORDS** - All records of tests and inspection shall be kept in suitable forms approved by the Bureau.
  - 2.1 Copies of any records and other connected papers that may be required by the Bureau shall be made available at any time on request.
3. **QUALITY CONTROL** – It is recommended that, as far as possible, Statistical Quality Control (SQC.) methods may be used for controlling the quality of the product during production as envisaged in this Scheme [See IS 397(Part 1) to IS 397 (Part 4)].
  - 3.1 In addition, effort should be made to gradually to introduce Quality Management System in accordance with IS/ISO 9001
4. **STANDARD MARK** – The Standard Mark, as given in Column (1) of the First Schedule of the licence, shall be either stenciled on the reel/drum on which cable is wound or contained in a label attached to the packed coil, provided always that the cable to which the Mark is thus applied conforms to every requirement of the specification . In addition to this, ISI mark & CM/L No. shall be printed or embossed on the cable insulation/sheath on every metre. In case of smaller size of cable IS 694 may be embossed or printed on one side of logo instead of on the top.
  - 4.1 The Standard Mark shall be applied in such a manner that, as far as possible, the empty reels do not retain the Standard Mark intact, as otherwise these might be fraudulently used by any person so as to deceive that this product coiled on the reels carries the Standard Mark and thus conforms to the specification.
  - 4.2 **IDENTIFICATION** - The manufacturer shall be identified throughout the length of the cable by manufacturers' name or trademark being printed, indented or embossed on the cable. In case none of these methods can be employed, or if the purchaser so desires, colour identification threads in accordance with the scheme to be approved by Bureau of Indian Standards shall be employed. The distance between any two consecutive printing, indentation or embossing shall not be more than one metre

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4.3 **OTHER MARKINGS** - In addition, the following shall be either stenciled on reel/drum, packages of individual or contained in the label attached to the coil.

- a) Reference to this Indian Standard IS 694;
- b) Manufacturer's name, brand name or trade-mark;
- c) Type of cable and voltage grade;
- d) In cases of flame retardant PVC the word "FR" and in case of flame retardant low smoke and halogen type the word "FR-LSH" to be used;
- e) Number of cores;
- f) Nominal cross-sectional area of conductor;
- g) In case of tinned copper conductor the word "ATC" to be used;
- h) Cable code;
- i) Colour of core (in case of single core cables);
- j) Length of cable on the reel, drum or coil;
- k) Number of lengths on the reel, drum or coil (if more than one);
- l) Direction of rotation of drum (by means of arrow) in case packed in wooden drums;
- m) Approximate gross mass;
- n) Country of manufacture;
- o) Year of manufacture;
- p) The word "suitable for outdoor use" wherever applicable; and
- q) ***Identification in code or otherwise to enable the date and control unit of manufacture to be traced back to factory records***

5. **LEVELS OF CONTROL** - The tests, as indicated in Table 1 attached and at the levels of control specified therein, shall be carried out on the whole production of the factory which is covered by this scheme and appropriate records and charts maintained in accordance with paragraph 2 above. All the production which conforms to the Indian Standards and covered by the licence shall be marked with certification mark of the Bureau.

5.1 On the basis of tests and inspection, the decision regarding conformity or otherwise of the control unit to a given requirement shall be made.

5.2 **CONTROL UNIT** - For the purpose of this scheme, the cable of continuous length manufactured/ extruded under similar conditions of production for one nominal cross sectional area and class of conductor shall constitute a control unit.

5.3 All the samples taken for test shall satisfy the requirements of the specification for acceptance of the control unit.

5.4 In respect of all other clauses of the specification the factory shall maintain appropriate control and checks to ensure that their product conforms to the various requirements of the specification.

6 **REJECTIONS** – A separate record shall be maintained giving information relating to the rejection of the production not conforming to the requirements of the specification and the method of its disposal. Such material shall in no circumstances be stored together with that conforming to the specification.

7 **SAMPLES** – The licensee shall supply, free of charge, the samples required in accordance with the Bureau of Indian Standards (Certification) Regulations, 1988, as subsequently amended, from the factory or godowns. The Bureau shall pay for the samples taken by it from the open market.

8 **REPLACEMENT** – Whenever a complaint is received soon after the goods with Standard Marks have been purchased and used, and if there is adequate evidence that the goods have not been misused, defective goods are replaced by the licensee free of cost in case the complaint is proved to be genuine and the warranty period (where applicable) has not expired. The final authority to judge the conformity of the product to the Indian Standard shall be with the Bureau. The firm shall have own complaint investigation system as per IS/ISO 10002.

8.1 In the event of any damages caused by the goods bearing the Standard Mark, or claim being filed by the consumers against BIS Standard Mark and not “conforming to” the relevant Indian Standard, entire liability arising out of such non conforming product shall be of licensee and BIS shall not in any way be responsible in such cases.

9 **STOP MARKING** – The marking of the product shall be stopped under intimation to the Bureau if, at any time, there is some difficulty in maintaining the conformity of their product to the specification, or the testing equipment goes out of order. The marking may be resumed as soon as the defects are removed under intimation to Bureau.

9.1 The marking of the product shall be stopped immediately if directed to do so by Bureau for any reason. The marking may then be resumed only after permission by the Bureau. The information regarding resumption of markings shall also be sent to the Bureau.

10 **PRODUCTION DATA** – The licensee shall send to BIS as per the enclosed Proforma-1 to be authenticated by a Chartered Accountant, a statement of quantity produced, marked and exported by him and the trade value thereof at the end of each operative year of the licence.

Table 1.....

**IS 694:2010**  
**POLYVINYL CHLORIDE INSULATED UNSHEATHED AND SHEATHED**  
**CABLES/CORDS WITH RIGID AND FLEXIBLE CONDUCTOR FOR**  
**RATED VOLTAGES UP TO AND INCLUDING 450/750 V**

**TABLE 1 LEVELS OF CONTROL**  
**(Para 5 of the Scheme of Testing and Inspection)**

TEST DETAILS					LEVELS OF CONTROL		
Cl.	Requirement	Clause	Reference	Test Methods Part Reference	No. of Samples	Frequency	Remarks
5.1.1	Conductor						
	a) Resistance	6.3	IS 8130	5 IS 10810	one	Each Coil/bobbin of finished wire drawn or received	
	b) Tensile strength	6.2.1	IS 8130	2 IS 10810			
	c) Annealing	6.1.2	IS 8130	1 IS 10810			
	d) Wrapping	6.2.2	IS 8130	2 IS 10810			
	e) Diameter	6.1.2.1	IS 8130				
f) Purity test (for copper)	Table 4	IS 191		one	Once in three months	See Note-1	
9	a) Conductor resistance	6.3	IS 8130	5 IS 10810	Each coil	Entire length of core after extrusion of insulation	If so desired these routine test may be conducted on the entire length of the control unit before cutting in individual coils.
	b) High voltage at room temp.	5.4.8	IS 694	45 IS 10810	-do-		
	c) Spark Test (as applicable)	5.4.9	IS 694	44 IS 10810	-do-		
3.4, 5.1, 5.2.1, 5.2.2, 5.3, 5.4.1, 5.4.2	a) Material b) Construction c) Identification d) Assembly of cores	Sec 2 & 3	IS 694		Each control unit		Visual Examination
5.2.3	a) Thickness of insulation	Sec 2&3	IS 694		2	Each control unit of 10000 m or less	
5.4.3	b) Thickness of sheath	Sec 3	IS 694	6 IS 10810			
5.4.5	c) Overall dimension	Sec 2&3	IS 694				
12.4 13.4 14.4 16.4	Ovality	Sec 3	IS 694		2		

**IS 694:2010**  
**POLYVINYL CHLORIDE INSULATED UNSHEATHED AND SHEATHED**  
**CABLES/CORDS WITH RIGID AND FLEXIBLE CONDUCTOR FOR**  
**RATED VOLTAGES UP TO AND INCLUDING 450/750 V**

**TABLE 1 LEVELS OF CONTROL**

**(Para 5 of the Scheme of Testing and Inspection)**

TEST DETAILS					LEVELS OF CONTROL			
Cl.	Requirement	Clause	Reference	Test Methods Part Reference	No. of Samples	Frequency	Remarks	
5.1.1	Conductor	6.1.2	IS 8130	1	IS 10810	Two	Each control unit of 10000 metre or less	
	a) Annealing test before stranding			2				
	b) Tensile strength			3				
5.4.16	c) Wrapping	6.2.2	IS 8130	4	IS 10810	One	Once in a month	For tinned copper only
9	Persulphate test	6.1.1	IS 8130	4	IS 10810	One	Once in a month	For tinned copper only
	Insulation	Table 1	IS 5831	7	IS 10810	One	Cable/Cord of each size and type manufactured in a month from one consignment of PVC compound	See Note-2
a) Tensile Strength								
9	b) Elongation at break	Table 2	IS 5831	7	IS 10810	One	Cable/Cord of each size and type manufactured in a month from one consignment of PVC compound	See Note-2
	Sheath							
9	a) Tensile Strength	Table 1	IS 5831	43	IS 10810	One	-do-	Either IR Constant or VR only to be recorded See Note-2
	b) Elongation at break							
9	Insulation Resistance	Table 1&2	IS 5831	14	IS 10810	-do-	See Note-2	
	Insulation and Sheath			15				
	a) Heat Shock			10				
	b) Hot Deformation			11				
	c) Loss of Mass			60				
	d) Ageing in Air Oven			12				
e) Thermal Stability								
f) Shrinkage								

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**IS 694:2010**

**POLYVINYL CHLORIDE INSULATED UNSHEATHED AND SHEATHED  
CABLES/CORDS WITH RIGID AND FLEXIBLE CONDUCTOR FOR  
RATED VOLTAGES UP TO AND INCLUDING 450/750 V**

**TABLE 1 LEVELS OF CONTROL**

**(Para 5 of the Scheme of Testing and Inspection)**

TEST DETAILS					LEVELS OF CONTROL			
Cl.	Requirement	Clause	Reference	Test Methods Part Reference	No. of Samples	Frequency	Remarks	
9	High Voltage Test (Water Immersion test)	5.4.7	IS 694	45 IS 10810	One	Cable/Cord of each size and type manufactured in a month from one consignment of PVC compound	See Note-2	
9	Flammability Test	5.4.6	IS 694	53 IS 10810	One	-do-	See Note-2	
9	Cold Bend	Table 1&2	IS 5831	20 IS 10810	One	-do-	For insulation and sheath See Note-2	
	Cold Impact			21 IS 10810				
9	Additional Ageing Test	5.4.14	IS 694	5.4.14 IS 694	One	-do-	Wherever applicable	
9	Oxygen Index	5.4.10	IS 694	58 IS 10810	One	-do-	For FR and FR-LSH	For insulation and sheath
	Temp. Index	5.4.12	IS 694	64 IS 10810			-do-	
	Halogen Acid Gas Evolution	5.4.11	IS 694	59 IS 10810			For FR-LSH	

Note-1: In case of non-availability of in-house test facilities, Test Certificate from NABL/BIS approved lab may be obtained. If the consignment of Copper (either rod or drawn wire) is received along with the TC from original supplier whose lab is NABL approved, further testing of Copper is not required, however, necessary records to be maintained.

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Note-2: In case of failure, marking of that type and size shall be stopped and reasons for failure shall be investigated. Marking shall be done only if the sample from the control unit of improved quality meets the specified requirements. The original frequency shall be restored only after five consecutive samples have passed the requirements.

Note-3: Wherever testing of two samples have been stipulated; samples shall be taken from the beginning and the end of the control unit.

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**PERFORMA - 1**

**PROFORMA FOR OBTAINING PRODUCTION DETAILS**

Period covered

Name of Licensee

CM/L No.

Name of Articles (s)

IS No.

Grade/Type/Size/Variety/Class/Rating

1.1 Brand/Trade/Name(s) of BIS Certification Marked Products

2.0 Total production of the articles(s) licensed for certification marking

2.1 Total production of the article(s) conforming to Indian Standard

3.0 Production covered with BIS Certification Mark and its value

a) Quantity

b) Value (Rs.)

3.1 Brand Name used on production covered under BIS Certification Mark

3.2 Calculation of marking fee on unit-rate basis; Marking Fee per unit

a) Unit

b) Quantity covered with BIS Certification Mark

c) Marking fee rounded off in whole rupees as obtained by applying unit rates given in (a) on quantity given in (b)

Note: In case a clause is not applicable, suitable remarks may be given against it.

4.0 Quantity not covered with BIS Certification Mark. If any, and the reasons for such non-coverage

4.1 Brand Name under with non certified goods were sold

5.0 Quantity Exported with BIS Standard Mark and its value

5.1 Brand Name under which BIS Certified goods are exported

6.0 Authentication by Chartered Accountant

**Signature of Authorised Signatory**

**Name**

**Date**