

SRI LANKA STANDARD 536 : 1993

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SPECIFICATION FOR
CANNED MANGOES
(First Revision)

SRI LANKA STANDARDS INSTITUTION

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(FIRST REVISION)

SLS 536 : 1993

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This standard does not purport to include all the necessary provisions of a contract.

SRI LANKA STANDARD
SPECIFICATION FOR CANNED MANGOES
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FOREWORD

This standard was finalized by the Sectoral Committee on Fruits and Vegetable Products and was authorized for adoption and publication as a Sri Lanka Standard by the Council of the Sri Lanka Standards Institution on 1993-11-17.

This standard was first published in 1981. A revision was considered necessary to update the standard to be in line with the revised codex standard. Microbiological limits have been deleted.

Guidelines for the determination of compliance of a lot with the requirements of this standard based on statistical sampling and inspection are given in Appendix A.

During the formulation of this specification due consideration has been given to the relevant provisions made under the Sri Lanka Food Act, No. 26 of 1980. Specific requirements given in this specification, wherever applicable, are in accordance with the relevant regulations. However, general provisions made under the Sri Lanka Food Act have not been included in this specification and therefore, the attention of the user of this specification is drawn to these general provisions.

For the purpose of deciding whether a particular requirement of this specification is complied with, the final value, observed or calculated, expressing the result of a test or an analysis, shall be rounded off in accordance with SLS 102. The number of significant places retained in the rounded off value shall be the same as that of the specified value in this specification.

In revising this specification, the assistance derived from the following publication is gratefully acknowledged :

CODEX STAN 159 - 1987 Canned mangoes

1 SCOPE

This specification prescribes the requirements and methods of test for canned mangoes *Mangifera indica* (L).

2 REFERENCES

- | | |
|---------|---|
| SLS 102 | Presentation of numerical values. |
| SLS 191 | White sugar. |
| SLS 209 | Code of practice for manufacture of fruit and vegetable products. |
| SLS 311 | Determination of lead. |
| SLS 315 | Determination of tin. |
| SLS 428 | Random sampling methods. |
| SLS 467 | Labelling of prepackaged goods. |
| SLS 614 | Potable water. |
| SLS 816 | Net contents of prepackaged goods. |

3 DEFINITIONS

For the purpose of this specification, the following definitions shall apply :

- 3.1 **canned mango** : Product prepared from stemmed, peeled, fresh sound and clean mature fruits of Mangifera indica L. with or without a liquid packing medium and heat processed in an appropriate manner before or after being sealed in a container.
- 3.2 **halves** : Two approximately equal parts cut along the stone from stem to apex and the flesh separated from the skin.
- 3.3 **slice** : Long slender pieces cut lengthwise or crosswise.
- 3.4 **piece** : Pitted and comprising irregular shapes and sizes.
- 3.5 **unit** : Individual piece of different styles.
- 3.6 **diced** : Cube-like parts of dimension at least 12 mm on the longest side.
- 3.7 **blemishes** : Surface discolouration and spots that definitely contrast with the overall colour, arising from physical, pathological, insect or other agents. Blemishes may penetrate into the flesh, for example: bruises, scab, dark discolouration.
- 3.8 **crushed or mashed** : Unit which has been crushed to the extent that it has lost the normal shape or has been severed into definite parts.
Partially disintegrated halves are not considered as broken. All crushed portions collectively equal to the size of a full unit are considered as one unit in applying the allowance (7.2.10).
- 3.9 **rind** : Tough outer layer or skin on mangoes found loose in the container.
- 3.10 **harmless extraneous material** : Any vegetable substance that is harmless but which tends to detract from the appearance of the product, for example: portion of a leaf, portion of a stem.
- 3.11 **trim** : Serious gouges due to peeling or other means, on the surface of the units which definitely detract from the appearance. This is considered as a defect only in halved and sliced canned mangoes in regular packs.
- 3.12 **cut-out strength** : Brix value of the cut-out syrup, that is, the syrup obtained by draining the product after the cans have been stored for not less than 14 days from the date of manufacture.
- 3.13 **head space** : Vertical distance from the top of the double seam to the level of the surface of contents.

4 TYPES OF PACK

The product shall be in any of the following types of pack :

4.1 **Regular pack** : With liquid packing medium.

4.2 **Solid pack** : Without a liquid packing medium; a dry nutritive sweetener may be used .

5 STYLES

The product shall be presented in any of the following styles :

5.1 Halves

5.2 Slices

5.3 Pieces

5.4 Diced

5.5 Other styles are permitted provided that the product conforms to the other requirements and is properly labelled to avoid misleading or confusing the consumer.

6 INGREDIENTS AND ADDITIVES

6.1 **Mangoes**, clean, fresh, ripe fruits of one variety harvested at the correct stage of maturity and free from infestations and/or diseases.

6.2 Packing media

6.2.1 *Potable water*, conforming to SLS 614 as the sole packing medium.

6.2.2 *Fruit juice*, mango juice/other compatible fruit juice as the sole packing medium.

6.2.3 *Mixed fruit juices*, two or more compatible fruit juices which may include mango juice.

6.2.4 *Water and fruit juice (s)*, water and mango juice, water and any other single fruit juice, water and two or more fruit juices.

6.3 **Nutritive sweeteners**, sucrose, invert sugar syrup, dextrose, dried glucose syrup, glucose syrup, fructose, fructose syrup, honey.

6.4 **Dry nutritive sweeteners**, sucrose, invert sugar, dextrose, dried glucose syrup.

6.5 Beta-carotene, up to 100 mg/kg.

6.6 Ascorbic acid, up to 200 mg/kg.

6.7 Calcium chloride, up to 350 mg/kg, calculated as calcium in the finished product.

6.8 Citric acid, at the lowest level necessary to achieve the desired effect.

6.9 Pectins, at the lowest level necessary to achieve the desired effect.

7 REQUIREMENTS

7.1 Hygiene

The product shall be processed, packed, transported and stored under hygienic conditions described in SLS 209.

7.2 Product requirements

7.2.1 Colour

The colour shall be characteristic of the variety of mango used. It shall be free from discolourations.

7.2.2 Flavour

The flavour shall be characteristic of the variety of mango used. Canned mangoes with special ingredients shall have a characteristic flavour of mangoes and other ingredients used. It shall be free from foreign flavours.

7.2.3 Texture

The mangoes shall be reasonably fleshy and have little fibre. Mangoes in regular packs shall not be mushy or excessively firm. Mangoes in solid packs shall not be excessively firm.

7.2.4 Uniformity of sizes

In the case of halves, 90 per cent by count of units shall be reasonably uniform in size.

When a unit has broken within the container, the combined broken pieces are considered as a single unit.

7.2.5 Symmetry

Not more than 20 per cent by count of units shall be sliced in a direction other than parallel to the crease and of these not more than half may have been sliced horizontally.

7.2.6 Vacuum of can

Vacuum of the can shall be not less than 125 mm of mercury when tested as in Appendix B.

7.2.7 Head space of can

Head space of the can shall be not more than 12 mm when tested as in Appendix C.

7.2.8 Fill of container

The product shall occupy not less than 90 per cent of the water capacity of the container when tested as in Appendix D.

Water capacity of a container is the volume of distilled water which the sealed container will hold when completely filled.

7.2.9 Drained mass

The average drained mass of the containers examined shall be not less than the declared drain mass, subject to a minimum of 55 per cent. The drain mass of individual cans shall be not less than the declared drain mass minus the tolerable negative error (TNE). The drained mass shall be determined as given in Appendix E. TNE shall be calculated as given in Clause 4.2.2 of SLS 816 : 1988.

7.2.10 Defects

Defects shall not exceed the limits given in Table 1. The mass of the product referred to is the drained mass determined as in Appendix E.

TABLE 1 - Allowances for defects

Sl No. (1)	Defect (2)	Maximum limit	
		regular packs (3)	solid packs (4)
i	Blemishes and trim	30 per cent by count	3 units per 500 g
ii	Crushed or mashed	5 per cent by mass	not applicable
iii	Rind	6 cm ² aggregate area per 500 g	12 cm ² aggregate area per 500 g
iv	Average pit or pit material	1/8 stone or equivalent per 500 g	1/8 stone or equivalent per 500 g
v	Harmless extraneous material	2 pieces per 500 g	3 pieces per 500 g

7.2.11 *Requirements for packing media*

7.2.11.1 When nutritive sweeteners are added to fruit juice, the packing medium shall have not less than 11 ° Brix and shall be classified based on the cut-out strength as follows :

Lightly sweetened fruit juice - 11 °Brix, minimum.

Heavily sweetened fruit juice - 15 °Brix, minimum.

7.2.11.2 When nutritive sweeteners are added to water or water and fruit juice(s), the packing media shall be classified as follows based on the cut-out strength.

Type of syrup	Brix value		
Extra light syrup	10	to	13
Light syrup	14	to	17
Heavy syrup	18	to	23
Extra heavy syrup	24	to	35

7.2.11.3 When nutritive sweeteners are added to water and fruit juice(s) and the minimum fruit juice(s) content of the packing medium is not less than 40 per cent by mass, the packing medium may be classified as a nectar provided the cut-out strength is not less than 20 °Brix.

7.2.11.4 The cut-out strength shall be determined as given in Appendix F.

7.2.12 *Limits for heavy metals*

Canned mangoes shall not exceed the limits for heavy metals given in Table 2 when tested as given in Column 4 of the table.

TABLE 2 - Limits for heavy metals

Sl No. (1)	Heavy metal (2)	Limit (3)	Method of test (4)
i	Lead, mg/kg, max.	01	SLS 311
ii	Tin, mg/kg, max.	250	SLS 315

8 PACKAGING

The product shall be packed in clean containers under hygienic conditions and hermetically sealed.

9 MARKING

9.1 Each container shall be marked or labelled legibly and indelibly with the following :

- a) Name of the product as 'MANGOES';
- b) A description of the packing medium in close proximity to the name of the product (see Appendix G);
- c) Style of presentation (see 5);
- d) Brand/trade name;
- e) Net mass, in grams or in kilo grams;
- f) Name and address of the manufacturer/distributor/importer (including the country of origin);
- g) Batch/code number;
- h) Date of expiry;
- j) Minimum drained mass;
- k) List of ingredients in descending order of proportion; and
- m) Storage instructions.

9.2 Marking and labelling shall also be in accordance with SLS 467.

NOTE

Attention is drawn to certification facilities offered by the Sri Lanka Standards Institution. See the inside back cover of this standard.

10 METHODS OF TEST

Tests shall be carried out as prescribed in SLS 311, SLS 315 and Appendices B to F of this specification.

APPENDIX A COMPLIANCE OF A LOT

The sampling scheme given in this Appendix should be applied where compliance of a lot to the requirements of this standard is to be assessed based on statistical sampling and inspection.

Where compliance with this standard is to be assured based on manufacturer's control systems coupled with type testing and check tests or any other procedure, appropriate schemes of sampling and inspection should be adopted.

A.1 LOT

In any consignment all cans of mangoes of the same type and style belonging to one batch of supply or manufacture shall constitute a lot.

A.2 SCALE OF SAMPLING

A.2.1 The number of cans to be selected from a lot shall be in accordance with Table 3.

TABLE 3 - Scale of sampling

Number of cans in the lot (1)	Number of cans to be selected (2)	Size of sub sample (3)
Up to 280	7	4
281 to 500	8	5
501 to 1200	9	5
1201 to 3200	11	6
3201 and above	13	8

A.2.2 The cans shall be selected at random. In order to ensure randomness of selection random numbers as given in SLS 428 shall be used.

A.3 NUMBER OF TESTS

A.3.1 Each can selected as in A.2.1 shall be inspected for packaging and marking requirements.

A.3.2 A sub sample as given in Column 3 of Table 3 shall be selected and shall be tested for the requirements given in 7.2.1 to 7.2.10.

A.3.3 A composite sample shall be prepared using the remaining contents of the cans tested as in A.3.2. The composite sample shall be tested for the requirements given in 7.2.11 and 7.2.12.

A.4 CRITERIA FOR CONFORMITY

A lot should be declared as conforming to the requirements of this specification if the following conditions are satisfied :

A.4.1 Each can inspected as in A.3.1 satisfies the relevant requirements.

A.4.2 Each can tested as in A.3.2 satisfies the relevant requirements.

A.4.3 The composite sample when tested as in A.3.3 satisfies the relevant requirements.

APPENDIX B DETERMINATION OF THE VACUUM OF CAN

B.1 APPARATUS

B.1.1 *Vacuum gauge*, indicating vacuum and pressure.

B.2 PROCEDURE

The vacuum is preferably measured using an electric recording type machine without opening the can. Where such a machine is not available, the piercing type may be used. In this case, pierce the hollow pointed edge of the gauge near the edge of the lid so that the rubber gasket makes a gas-tight seal and prevents the loss of vacuum. Do not press too hard as this will alter the head space. Do not use swollen cans. The readings should be taken when the can is at room temperature. Record the vacuum in millimeters of mercury. Necessary corrections for altitude may be made.

APPENDIX C DETERMINATION OF THE HEAD SPACE

C.1 APPARATUS

C.1.1 *Rotary cutter*

C.1.2 *Ruler*, with millimetre divisions or *headspace gauge*.

C.2 PROCEDURE

Cut out the lid on the edge of the end plate with the rotary cutter, and lift the cut portion carefully so that the shape of the end plate is not altered. Measure the headspace using a headspace gauge or a ruler. When a ruler is used, take measurements from the top of the double seam to the surface of the liquid. Take the average of four measurements taken at different points. Obtain the net headspace by deducting 5 mm from the gross headspace determined as above.

APPENDIX D DETERMINATION OF THE FILL OF CONTAINER

D.1 PROCEDURE

D.1.1 Select a container which is undamaged in all respects. Carefully cut out the lid without removing or altering the height of the seam. Mark the level of the content. Wash, dry and weigh the empty container .

D.1.2 Fill the container with distilled water to 4.8 mm vertical distance below the top level of the container, if the can has a double seam. Fill up to the top of the can for other containers. Weigh the filled container.

D.1.3 Draw off water from the filled container to the level of the contents. Weigh the can with water up to the level of the contents.

D.2 CALCULATION

Fill of the container, per cent =
$$\frac{m_1 - m_0}{m_2 - m_0} \times 100$$

by mass of the water capacity

where,

- m_1 is the mass, in g, of the container with water upto the level of contents(D.1.3);
- m_2 is the mass, in g, of the container filled with water (D.1.2); and
- m_0 is the mass, in g, of the empty container(D.1.1).

APPENDIX E
DETERMINATION OF THE DRAINED MASS

E.1 APPARATUS

Circular sieves, having a size designation of 2.8 mm and of diameter 200 mm (to be used when the net contents is less than 1.5 kg) or 300 mm (to be used when the net contents is 1.5 kg or more).

E.2 PROCEDURE

E.2.1 Weigh the full can. Open, and pour entire contents on a weighed clean and dry sieve (E.1). Without shifting the product, incline the sieve so as to facilitate drainage. Drain for 2 minutes. Weigh the drained solids. Weigh the dry empty can.

E.2.2 Fill the container with distilled water at 20 °C to 4.8 mm vertical distance below the top level of the container, if the can has a double seam. Fill up to the top of the can for other containers. Weigh the filled container.

E.3 CALCULATION

Drained mass, per cent by mass =
$$\frac{m_1}{m_2 - m_0} \times 100$$
 of the water capacity

where;

m_1 is the mass, in g, of the drained solids (E.2.1);
 m_2 is the mass, in g, of the container filled with water (E.2.2); and
 m_0 is the mass, in g, of the empty can.

APPENDIX F
DETERMINATION OF CUT-OUT STRENGTH (SOLUBLE SOLIDS CONTENT)

F.1 APPARATUS

F.1.1 *Refractometer indicating the refractive index*, by means of a scale graduated in 0.001, in order to allow readings to be estimated to 0.000 2.

This refractometer should be adjusted so that at 20 °C it registers for distilled water a refractive index of 1.333 0.

F.1.2 *Refractometer indicating the percentage by mass of sucrose*, by means of a scale graduated in 0.5 per cent, in order to allow readings to be estimated to 0.25 per cent. This refractometer should be adjusted so that at 20 °C it registers for distilled water a soluble solids (sucrose) content of zero.

F.1.3 *Means for circulating water*, to maintain the temperature of the prisms of the refractometer constant to within ± 0.5 °C, in the neighbourhood of 20 °C, which is the reference temperature.

F.2 PROCEDURE

Thoroughly mix the packing medium and use it directly for the determination.

Adjust the water circulation (F.1.3) to operate at the required temperature (between 15 °C and 25 °C) and allow it to flow to bring the prisms of the refractometer (F.1.1 or F.1.2) to the same temperature, which shall remain constant to within ± 0.5 °C during the determination.

Bring the test solution to the measuring temperature. Put 2 drops or 3 drops of test solution on the fixed prism of the refractometer and immediately adjust the movable prism. Suitably illuminate the field of view. The use of a sodium vapour lamp allows more precise results to be obtained.

Bring the line dividing the light and dark parts of the surface in the field of view to the crossing of the threads and read the value of the refractive index or the percentage by mass of sucrose, according to the instrument used.

Carryout the determination in duplicate.

F.3 CALCULATION

F.3.1 If the determination has been carried out at a temperature other than 20 ± 0.5 °C, the following corrections are required :

a) For the scale indicating the refractive index (F.1.1), apply the formula;

$$n^{20} = n^t + 0.00013(t-20)$$

where t is the temperature of measurement in degrees Celsius;

b) For the scale indicating the percentage by mass of sucrose (F.1.2) correct the result according to Table 4.

TABLE 4 - Correction of readings of the refractometer with scale indicating sucrose for a temperature different from 20 ± 0.5 °C

Temperature °C	Scale reading for soluble solids content, % (m/m)									
	5	10	15	20	25	30	40	50	60	70
	Corrections to be subtracted									
15	0.29	0.31	0.33	0.34	0.34	0.35	0.37	0.38	0.39	0.40
16	0.24	0.25	0.26	0.27	0.28	0.28	0.30	0.30	0.31	0.32
17	0.18	0.19	0.20	0.21	0.21	0.21	0.22	0.23	0.23	0.24
18	0.13	0.13	0.14	0.14	0.14	0.14	0.15	0.15	0.16	0.16
19	0.06	0.06	0.07	0.07	0.07	0.07	0.08	0.08	0.08	0.08
	Corrections to be added									
21	0.07	0.07	0.07	0.07	0.08	0.08	0.08	0.08	0.08	0.08
22	0.13	0.14	0.14	0.15	0.15	0.15	0.15	0.16	0.16	0.16
23	0.20	0.21	0.22	0.22	0.23	0.23	0.23	0.24	0.24	0.24
24	0.27	0.28	0.29	0.30	0.30	0.31	0.31	0.31	0.32	0.32
25	0.35	0.36	0.37	0.38	0.38	0.39	0.40	0.40	0.40	0.40

F.3.2 For refractometer with refractive index scale, read from Table 5, the percentage by mass of sucrose corresponding to the value read, corrected if necessary in accordance with F.3.1. (a).

F.3.3 For refractometer with sucrose scale, the soluble solids content, percentage by mass of sucrose, is equal to the value read corrected if necessary in accordance with F.3.1 (b).

TABLE 5 - Refractive index and corresponding percentage by mass of soluble solids (sucrose)

Refractive index n^{20}	Soluble solids (sucrose) content %(m/m)	Refractive index n^{20}	Soluble solids (sucrose) content %(m/m)	Refractive index n^{20}	Soluble solids (sucrose) content %(m/m)	Refractive index n^{20}	Soluble solids (sucrose) content %(m/m)
1.333 0	0	1.367 2	22	1.407 6	44	1.455 8	66
1.334 4	1	1.368 9	23	1.409 6	45	1.458 2	67
1.335 9	2	1.370 6	24			1.460 6	68
1.337 3	3	1.372 3	25	1.411 7	46	1.463 0	69
1.338 8	4			1.413 7	47	1.465 4	70
1.340 3	5	1.374 0	26	1.415 8	48		
		1.375 8	27	1.417 9	49		
1.341 8	6	1.377 5	28	1.420 1	50	1.467 9	71
1.343 3	7	1.379 3	29			1.470 3	72
1.344 8	8	1.381 1	30			1.472 8	73
1.346 3	9			1.422 2	51	1.475 3	74
1.347 8	10	1.382 9	31	1.424 3	52	1.477 8	75
		1.384 7	32	1.426 5	53		
1.349 4	11	1.386 5	33	1.428 6	54	1.480 3	76
1.350 9	12	1.388 3	34	1.430 8	55	1.482 9	77
1.352 5	13	1.390 2	35			1.485 4	78
1.354 1	14			1.433 0	56	1.488 0	79
1.355 7	15	1.392 0	36	1.435 2	57	1.490 6	80
		1.393 9	37	1.437 4	58		
1.357 3	16	1.395 8	38	1.439 7	59	1.493 3	81
1.358 9	17	1.397 8	39	1.441 9	60	1.495 9	82
1.360 5	18	1.399 7	40			1.498 5	83
1.362 2	19			1.444 2	61	1.501 2	84
1.363 8	20	1.401 6	41	1.446 5	62	1.503 9	85
		1.403 6	42	1.448 8	63		
1.365 5	21	1.405 6	43	1.451 1	64		
				1.453 5	65		

APPENDIX G
LABELLING OF PACKING MEDIA

- G.1 When the packing medium is composed of water, the packing medium shall be declared as :
"In water" or "Packed in water"
- G.2 When the packing medium is composed of a single fruit juice, the packing medium shall be declared as :
"In juice" or "In mango juice" where mango juice has been used; or
"In (name of fruit) juice" for all other fruit juices.
- G.3 When the packing medium is composed of two or more fruit juices, which may include mango juice, it shall be declared as :
"In (name of fruits) juice"; or
"In fruit juices"; or
"In mixed fruit juices".
- G.4 When nutritive sweeteners are added to mango juice, the packing medium shall be declared as :
"Lightly sweetened juice"; or
"Lightly sweetened mango juice"; or
"Heavily sweetened juice"; or
"Heavily sweetened mango juice" as appropriate.
- G.5 When nutritive sweeteners are added to a single fruit juice (not including mango juice) or mixtures of two or more fruit juices (which may include mango juice), the packing medium shall be declared as :
"Lightly sweetened (name of fruit) juice"; or
"Lightly sweetened (name of fruits) juices"; or
"Lightly sweetened fruit juices"; or
"Lightly sweetened mixed fruit juices" as appropriate,
or the same for "Heavily sweetened" juices.
- G.6 When nutritive sweeteners are added to water, or water and a single fruit juice (including mango juice) or water and two or more fruit juices, the packing medium shall be declared as :
"Slightly sweetened water"
"Water slightly sweetened"
"Extra light syrup"
"Light syrup"
"Heavy syrup"
"Extra heavy syrup"
- G.7 When nutritive sweeteners, water and fruit juice(s) are combined to form a nectar, the packing medium shall be declared as :
"In nectar" or "In mango nectar" where the juice component is solely mango; or
"In (name of fruit) nectar"
"In (name of fruits) nectar"
"In fruit nectars" or
"In mixed fruit nectars" for all other cases as appropriate.

G.8 When the packing medium contains water and mango juice or water and one or more fruit juice(s), the packing medium shall be designated to indicate the preponderance of water or such fruit juice as may be the case, for example:

"Mango juice and water"

"Water and (mango) juice"

"(name of fruit(s) juice(s) and water"; or

"Water and (name of fruit(s) juices)".

G.9 The fruit juice component of any packing medium should not be declared in the name of the food if it comprises less than 10 per cent by mass of the total packing medium but it shall be declared in the list of ingredients.

G.10 When the name of the fruits in a mixed fruit juice or mixed fruit nectar is listed individually in the packing medium, they shall be declared in descending order of proportion.

G.11 When the packing medium contains no added sweetening agents, the term "no added sugar" or other words of similar import may be used in association with, or in close proximity to the name of the food.

SLS CERTIFICATION MARK

The Sri Lanka Standards Institution is the owner of the registered certification mark shown below. Beneath the mark, the number of the Sri Lanka Standard relevant to the product is indicated. This mark may be used only by those who have obtained permits under the SLS certification marks scheme. The presence of this mark on or in relation to a product conveys the assurance that they have been produced to comply with the requirements of the relevant Sri Lanka Standard under a well designed system of quality control inspection and testing operated by the manufacturer and supervised by the SLSI which includes surveillance inspection of the factory, testing of both factory and market samples.

Further particulars of the terms and conditions of the permit may be obtained from the Sri Lanka Standards Institution, 17, Victoria Place, Elvitigala Mawatha, Colombo 08.



SRI LANKA STANDARDS INSTITUTION

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