

TECHNICAL PROCUREMENT SPECIFICATION

#### FACT UDYOGAMANDAL COMPLEX

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20:20:0:13 UCTS/TPS/2024-05 R0

PAGE 1 of 6

## TECHNICAL PROCUREMENT SPECIFICATION (TPS)

FOR

### OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

**FOR** 

PACKING BHARAT NPK 20:20:0:13

#### FACT UDYOGAMANDAL COMPLEX

KOCHI, INDIA

TPS No. UCTS/TPS/2024-05 R0

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0	29/08/24	ENQUIRY	NAGENDRA	SYAMJITH	JAISON XAVIER
REV. NO.	DATE	STATUS	PREPARED	CHECKED	APPROVED



UCTS/TPS/2024-05 R0

TECHNICAL
PROCUREMENT 
SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20:20:0:13

PAGE 2 of 6

No	Description	Details			
1.0	INSIDE DIMENSIONS	915 MM X 610 MM			
1.1	TOLERANCE	+ 30 MM, -0.00 (-NIL ON BOTH WIDTH AND LENGTH.) 50 KGS.			
2.0	CAPACITY	50 KGS.			
3.0	BAG WEIGHT	405 OMO TOLEDANOE + 20V			
3.1	WEIGHT OF INDIVIDUAL BAG	135 GMS. TOLERANCE ± 3%			
3.2	WEIGHT OF A BALE (350 BAGS)	47.25 KGS. (NET WT.)  TOLERANCE +3%/- 0.00% (No negative tolerance)			
4.0	BREAKING STRENGTH	TESTING OF BREAKING STRENGTH SHALL BE DONE USING RAVELLED STRIP METHOD (CONSTANT RATE OF TRAVERSE) AND THE RATE OF TRAVERSE SHALL BE 300 MM/MINUTE.			
4.1	i) WIDTHWISE ii) WIDTHWISE (Lamination Joint)	91.8 KGF 91.8 KGF			
4.2	LENGTHWISE	91.8 KGF			
4.3	BOTTOM SEAM	40.8 KGF			
5.0	DROP TEST	THE DROP TEST SHALL BE CARRIED OUT FOR EACH LOT SUPPLIED BY THE BAG SUPPLIER. FOR THIS TEST 4 nos. BAGS SHALL BE RANDOMLY SELECTED FROM EACH LOT. ALL BAGS SHALL BE SUBJECTED TO DROP TEST FROM A HEIGHT OF 3 MTRS FROM BOTH SIDES (4 DROP PER BAG). BAGS DURING DROP TEST WILL DROPPED ON THE STOMACH. NO BAGS SHOULD RUPTURE WHEN SUBJECTED TO MINIMUM 04 NOS. DROPS.			
6.0	FABRIC	BAGS MADE OUT OF SINGLE PIECE OF LAMINATED PP FABE WOVEN ON CIRCULAR LOOM AS PER IS 9755:2021. ANY MIDD SEWN OR JOINTED BAGS WILL NOT BE ACCEPTABLE. T FABRIC USED SHALL BE FREE FROM ALL MAJOR WEAVII DEFECTS LIKE GAPS, PICK POINTS, MISSING TAPES ETC. GRANULE FOR FABRIC & UV MASTER BATCH- Grade H030SG OF			

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		HOLES, PATCHES, BLISTERS, TEARS ETC. THE LAMINATION SHOULD COVER THE ENTIRE OUTSIDE AREA OF THE FABRUSED. COLOR OF LAMINATION OF BAGS SHALL TRANSPARENT
7.0	LAMINATION	FABRIC SHALL BE LAMINATED OUTSIDE WITH PP GRANULI (GRADE H350EG/H350FG OR EQUIVALENT) 2 GMS/M2(CORRESPONDING TO 100 GUAGE NOMINAL) WITH A OVERLAP/OVERHANG OF 5 - 15MM. VIRGIN PP GRANULES SHA BE USED AND THE LAMINATION SHALL BE FREE FROM F
6.5.3	TOLERANCE	RANGE: 15 to 25 % ON BOTH WIDTHWISE & LENGTHWISE.
6.5.2	WIDTHWISE	20%
6.5.1	LENGTHWISE	20%
6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
6.4	PICKS PER DM	40. TOLERANCE ± 2
6.3	ENDS PER DM	40. TOLERANCE ± 2
6.2	MESH	10 x 10 PER SQ. INCH.
6.1	TAPE	MONOAXIALLY ORIENTED PP TAPES HAVING 1000 DENIER AND MINIMUM WIDTH OF 2.5MM. THE FABRIC SHALL BE WOVEN FROM PP TAPES CONFORMING TO IS:11197. THE ELONGATION OF TAPES WHILE TESTING BREAKING STRENGTH SHALL BE IN THE RANGE OF 15 to 25%. TOLERANCE FOR DENIER: ±10% DENIER.
		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF BAG SHALL BE MADE OUT OF UN STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PERMETHOD GIVEN IN ANNEXURE-F OF IS 9755:2021. FABRIC COLOUR-LIGHT BLUE (HEX CODE: ADD8E6).

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9.0	BRANDING/PRINTING	MULTI COLOUR, SINGLE SIDE AS PER MONOGRAM SPECIFIED BY FACT. THE FOLLOWING INK (FERTILISER GRADE) SHALL BE USED: HINDUSTAN INK BY HINDUSTAN INKS AND RESINS LTD., DAMAN.OR VARSHA INK OF VARSHA PRINTING INK MFG. CO., NAGPUR. SHADE OF THE BRANDING SHALL BE UNIFORM AND MATCHING FACT'S REQUIREMENTS.		
	THE INK USED SHOULD HAVE SCRATCH RESISTANT AIDS, GLOSSY, HIGH TECH/POLYAMIDE QUALITY, ALKALI RESISTANT, SMUDGE FREE, BRIGHT IN COLOR, SHOULD NOT SMEAR IN CONTACT WITH WATER AND SHOULD NOT AFFECT THE FABRIC. ART WORK WILL BE PROVIDED BY FACT. PRINTING QUALITY SHALL BE CORONA TREATED SCUFF RESISTANT/VERY SHARP PRINT, NAIL PROOF/TAPE PROOF & EVEN COLORS THROUGHOUT THE LOT(PREFERABLY POLYAMIDE) ON ROLL TO ROLL PRINTING MACHINE. 3 SAMPLES OF THE BAGS OF THE REQUIRED COLOUR AS PER FACT REQUIREMENT SHALL BE SUBMITTED BEFORE STARTING BULK MANUFACTURING OF BAGS.ALL THE SAMPLES WILL BE SIGNED AND APPROVED SAMPLE WILL BE RETURNED WITH SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF FACT. ANY LOT SUPPLIED, IF FOUND DEVIATING IN COLOUR AS COMPARED TO APPROVED COLOUR WILL NOT BE ACCEPTED.			
	LOGO AND RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2021, CLEARLY VISIBLE AT THE BOTTOM OF THE BAG.  THE ENTIRE LOT OF PP BAGS SHALL BE LIABLE FOR REJECTION IN CASE THE TES SAMPLES FAIL TO PASS THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASIO RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264 98(RE APPROVED 2004)			
10.0	STITCHING	DOUBLE FOLD, DOUBLE STITCH WITH UV STABILISED THREAD/ MULTIFILAMENT YARN OF 1200 DENIER. STITCHING SHALL BE DONE AS PRESCRIBED IN IS 9755:2021. FOLD SHOULD OCCUR ON THE OPPOSITE SIDE OF THE PRINTING MADE ON THE BAG.		
11.0	PACKING	350 BAGS IN A BALE. BALES SHALL BE WRAPPED WITH HDPE/PP FABRIC OR HESSIAN CLOTH AND STITCHED PROPERLY TO WITHSTAND HAZARDS OF TRANSPORTATION. EACH BALE SHALL BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BAG,		

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		SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT
12.0	ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. ASH CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING ALL IMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOT WILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2021 FOR TESTING ASH CONTENT.
13.0	CRITERIA FOR CONFORMITY	THE LOT SHALL BE CONSIDERED AS CONFORMING TO THE REQUIREMENTS FOR ACCEPTANCE IF ALL THE FOLLOWING CONDITIONS ARE SATISFIED.
	AND DIMENSICE FRACTION TO SERVE THE AVERAGE WIDTHWISE AS SPECIFIED AND THE SPECIFIE SHALL BE FIED FICKS AND MARKET STACKS AND MARKET SPECIFIES SHALL BE FIED	DF DEFECTIVE BAGS IN CASE OF VISUAL INSPECTIONS, ENDS, PICKS ONS IS UP TO 10% OF THE SAMPLE SIZE AFTER ROUNDING OFF THE NEXT HIGHER INTEGER.  HE BAG OR BALE OF 350 BAGS WEIGHS LESS THAN THE OWER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED  E BREAKING STRENGTH OF FABRIC IN BOTH LENGTHWISE, NO WIDTHWISE (LAMINATION JOINT) IS NOT LESS THAN THE VALUE OF THE INDIVIDUAL VALUES IS MORE THAN 10% BELOWED VALUE. THE SAMPLES SELECTED FOR BREAKING STRENGTH TESTS OF THE SAMPLES OF THE SA
iv. THE AVERAGE BREAKING STRENGTH OF THE FABRIC AT BOTTOM SEAR LESS THAN THE VALUE SPECIFIED AND NONE OF THE INDIVIDUAL BAG MORE THAN 10 PERCENT BELOW THE SPECIFIED VALUE. THE SAMPLE S FOR SEAM STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN INSPECTION, DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS.		

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	v. NONE OF THE SAMPLE BAGS SHALL HAVE PERCENTAGE ELONGATION AND ASH CONTENT OUTSIDE THE SPECIFIED RANGE				
	WEATHERING S	NONE OF THE PP BAG SAMPLES AFTER EXPOSING TO UV RADIATION AND WEATHERING SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT OF THE ORIGINAL BREAKING STRENGTH.			
B	vii. NONE OF THE PP BAG SAMPLES SHALL FAIL IN THE DROP TEST				
	viii. NONE OF THE PP BAG TEST SAMPLES SHALL FAIL IN THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004)				
14.0	APPLICABLE STANDARD	APPLICABLE STANDARD SHALL BE IS 9755:2021 FOR PP WOVEN BAGS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2021, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS 9755:2021.			

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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20.5:0:0:23 UCTS/TPS/2024-06 R0

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## TECHNICAL PROCUREMENT SPECIFICATION (TPS)

FOR

## OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

**FOR** 

PACKING BHARAT NPK 20.5:0:0:23

### FACT UDYOGAMANDAL COMPLEX

KOCHI, INDIA

TPS No. UCTS/TPS/2024-06 R0

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0	29/08/24	ENQUIRY	NAGENDRA	SYAMJITH	JAISON XAVIER
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PAGE 2 of 6

No	Description	Details	
1.0	INSIDE DIMENSIONS	889 MM X 533 MM	
1.1	TOLERANCE	+ 30 MM, -0.00 (-NIL ON BOTH WIDTH AND LENGTH.)	
2.0	CAPACITY	50 KGS.	
3.0	BAG WEIGHT		
3.1	WEIGHT OF INDIVIDUAL BAG	115 GMS. TOLERANCE ± 3%	
3.2	WEIGHT OF A BALE (400 BAGS)	46.0 KGS. (NET WT.)  TOLERANCE +3%/- 0.00% (No negative tolerance)	
4.0	BREAKING STRENGTH	TESTING OF BREAKING STRENGTH SHALL BE DONE USING RAVELLED STRIP METHOD (CONSTANT RATE OF TRAVERSE) AND THE RATE OF TRAVERSE SHALL BE 300 MM/MINUTE.	
4.1	i) WIDTHWISE ii) WIDTHWISE (Lamination Joint)	91.8 KGF 91.8 KGF	
4.2	LENGTHWISE	91.8 KGF	
4.3	BOTTOM SEAM	40.8 KGF	
5.0	DROP TEST	THE DROP TEST SHALL BE CARRIED OUT FOR EACH LOT SUPPLIED BY THE BAG SUPPLIER. FOR THIS TEST 4 nos. BAGS SHALL BE RANDOMLY SELECTED FROM EACH LOT. ALL BAGS SHALL BE SUBJECTED TO DROP TEST FROM A HEIGHT OF 3 MTRS FROM BOTH SIDES (4 DROP PER BAG). BAGS DURING DROP TEST WILL DROPPED ON THE STOMACH. NO BAGS SHOULD RUPTURE WHEN SUBJECTED TO MINIMUM 04 NOS DROPS.	
6.0 FABRIC		BAGS MADE OUT OF SINGLE PIECE OF LAMINATED PP FABRIC WOVEN ON CIRCULAR LOOM AS PER IS 9755:2021. ANY MIDDLE SEWN OR JOINTED BAGS WILL NOT BE ACCEPTABLE. THE FABRIC USED SHALL BE FREE FROM ALL MAJOR WEAVING DEFECTS LIKE GAPS, PICK POINTS, MISSING TAPES ETC. PER GRANULE FOR FABRIC & UV MASTER BATCH- Grade H030SG OR	

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0	29/08/24	ENQUIRY	NAGENDRA	<i>t</i> SYAMJITH	JAISON XAVIER
REV. NO.	DATE	STATUS	PREPARED	CHECKED	APPROVED



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PAGE 3 of 6

		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF BAG SHALL BE MADE OUT OF UV STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PER METHOD GIVEN IN ANNEXURE-F OF IS 9755:2021. FABRIC COLOUR- LIGHT BLUE (HEX CODE: ADD8E6).
6.1	TAPE	MONOAXIALLY ORIENTED PP TAPES HAVING 1000 DENIER AND MINIMUM WIDTH OF 2.5MM. THE FABRIC SHALL BE WOVEN FROM PP TAPES CONFORMING TO IS:11197. THE ELONGATION OF TAPES WHILE TESTING BREAKING STRENGTH SHALL BE IN THE RANGE OF 15 to 25%. TOLERANCE FOR DENIER: ±10% DENIER.
6.2	MESH	10 x 10 PER SQ. INCH.
6.3	ENDS PER DM	40. TOLERANCE ± 2
6.4	PICKS PER DM	40. TOLERANCE ± 2
6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
6.5.1	LENGTHWISE	20%
6.5.2	WIDTHWISE	20%
6.5.3	TOLERANCE	RANGE: 15 to 25 % ON BOTH WIDTHWISE & LENGTHWISE.
7.0	LAMINATION	FABRIC SHALL BE LAMINATED OUTSIDE WITH PP GRANULES (GRADE H350EG/H350FG OR EQUIVALENT) 23 GMS/M2(CORRESPONDING TO 100 GUAGE NOMINAL) WITH AN OVERLAP/OVERHANG OF 5 - 15MM. VIRGIN PP GRANULES SHALL BE USED AND THE LAMINATION SHALL BE FREE FROM PIN HOLES, PATCHES, BLISTERS, TEARS ETC. THE LAMINATION SHOULD COVER THE ENTIRE OUTSIDE AREA OF THE FABRICALISED. COLOR OF LAMINATION OF BAGS SHALL BI
		TRANSPARENT
8.0	BAG MOUTH	NEATLY SCISSOR CUT. EDGES SHOULD NOT BE ROUGH

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0	29/08/24	ENQUIRY	NAGENDRA	SYAMJITH	JAISON XAVIER
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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20.5:0:0:23

PAGE 4 of 6

9.0	BRANDING/PRINTING  MULTI COLOUR, SINGLE SIDE AS PER MONOGRAM SPECIFIED FACT. THE FOLLOWING INK (FERTILISER GRADE) SHALL BE USE HINDUSTAN INK BY HINDUSTAN INKS AND RESINS LTD., DAMAN. VARSHA INK OF VARSHA PRINTING INK MFG. CO., NAGPU SHADE OF THE BRANDING SHALL BE UNIFORM AND MATCHI FACT'S REQUIREMENTS.			
	POLYAMIDE QUALITY, AL SMEAR IN CONTACT WIT BE PROVIDED BY FA RESISTANT/VERY SHARI THE LOT(PREFERABLY IN THE BAGS OF THE SUBMITTED BEFORE ST BE SIGNED AND APPR AUTHORIZED REPRESE	THE INK USED SHOULD HAVE SCRATCH RESISTANT AIDS, GLOSSY, HIGH TECH/POLYAMIDE QUALITY, ALKALI RESISTANT, SMUDGE FREE, BRIGHT IN COLOR, SHOULD NOT SMEAR IN CONTACT WITH WATER AND SHOULD NOT AFFECT THE FABRIC. ART WORK WILL BE PROVIDED BY FACT. PRINTING QUALITY SHALL BE CORONA TREATED SCUFF RESISTANT/VERY SHARP PRINT, NAIL PROOF/TAPE PROOF & EVEN COLORS THROUGHOUT THE LOT(PREFERABLY POLYAMIDE) ON ROLL TO ROLL PRINTING MACHINE. 3 SAMPLES OF THE BAGS OF THE REQUIRED COLOUR AS PER FACT REQUIREMENT SHALL BE SUBMITTED BEFORE STARTING BULK MANUFACTURING OF BAGS.ALL THE SAMPLES WILL BE SIGNED AND APPROVED SAMPLE WILL BE RETURNED WITH SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF FACT. ANY LOT SUPPLIED, IF FOUND DEVIATING IN COLOUR AS COMPARED TO APPROVED COLOUR WILL NOT BE ACCEPTED.		
	EACH BAG SHALL BE COMPULSORILY MARKED WITH BIS STANDARD MARK, SWATCH BHARAT LOGO AND RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2021, CLEARLY VISIBLE AT THE BOTTOM OF THE BAG.  THE ENTIRE LOT OF PP BAGS SHALL BE LIABLE FOR REJECTION IN CASE THE TEST SAMPLES FAIL TO PASS THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98(RE APPROVED 2004)			
10.0	DOUBLE FOLD, DOUBLE STITCH WITH UV STABILISED THREA MULTIFILAMENT YARN OF 1200 DENIER. STITCHING SHALL BE DONE AS PRESCRIBED IN IS 9755:2021. FOLD SHOULD OC ON THE OPPOSITE SIDE OF THE PRINTING MADE ON THE BAG			
11.0	PACKING	400 BAGS IN A BALE. BALES SHALL BE WRAPPED WITH HDPE/PP FABRIC OR HESSIAN CLOTH AND STITCHED PROPERLY TO WITHSTAND HAZARDS OF TRANSPORTATION. EACH BALE SHALL		

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0	29/08/24	ENQUIRY	NAGENDRA	SYAMJITH	JAISON XAVIER
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BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BAG,



# TECHNICAL PROCUREMENT SPECIFICATION

#### FACT UDYOGAMANDAL COMPLEX

UCTS/TPS/2024-06 R0

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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20.5:0:0:23

		SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT
12.0	ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. ASH CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING ALL IMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOT WILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2021 FOR TESTING ASH CONTENT.
- 13.0	CRITERIA FOR CONFORMITY	THE LOT SHALL BE CONSIDERED AS CONFORMING TO THE REQUIREMENTS FOR ACCEPTANCE IF ALL THE FOLLOWING CONDITIONS ARE SATISFIED.

- i. THE NUMBER OF DEFECTIVE BAGS IN CASE OF VISUAL INSPECTIONS, ENDS, PICKS AND DIMENSIONS IS UP TO 10% OF THE SAMPLE SIZE AFTER ROUNDING OFF THE FRACTION TO NEXT HIGHER INTEGER.
- ii. NONE OF THE BAG OR BALE OF 400 BAGS WEIGHS LESS THAN THE RESPECTIVE LOWER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED
- iii. THE AVERAGE BREAKING STRENGTH OF FABRIC IN BOTH LENGTHWISE, WIDTHWISE AND WIDTHWISE (LAMINATION JOINT) IS NOT LESS THAN THE VALUE SPECIFIED AND NONE OF THE INDIVIDUAL VALUES IS MORE THAN 10% BELOW THE SPECIFIED VALUE. THE SAMPLES SELECTED FOR BREAKING STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS.
- iv. THE AVERAGE BREAKING STRENGTH OF THE FABRIC AT BOTTOM SEAM IS NOT LESS THAN THE VALUE SPECIFIED AND NONE OF THE INDIVIDUAL BAG VALUE IS MORE THAN 10 PERCENT BELOW THE SPECIFIED VALUE. THE SAMPLE SELECTED FOR SEAM STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS.

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v. NONE OF THE SAMPLE BAGS SHALL HAVE PERCENTAGE ELONGATION AND A CONTENT OUTSIDE THE SPECIFIED RANGE					
WEATHERING	NONE OF THE PP BAG SAMPLES AFTER EXPOSING TO UV RADIATION AND WEATHERING SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT OF THE ORIGINAL BREAKING STRENGTH.				
vii. NONE OF THE F	NONE OF THE PP BAG SAMPLES SHALL FAIL IN THE DROP TEST				
viii. NONE OF THE PP BAG TEST SAMPLES SHALL FAIL IN THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004)					
APPLICABLE STANDARD	APPLICABLE STANDARD SHALL BE IS 9755:2021 FOR PP WOVEN BAGS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2021, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS 9755:2021.				
	vi. NONE OF TH WEATHERING THE ORIGINAL vii. NONE OF THE I viii. NONE OF THE TEST AND STA BY SUTHERLAN				

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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT MOP UCTS/TPS/2024-03 R0

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## TECHNICAL PROCUREMENT SPECIFICATION (TPS)

**FOR** 

## **OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS**

**FOR** 

PACKING BHARAT MOP

#### FACT UDYOGAMANDAL COMPLEX

KOCHI, INDIA

TPS No. UCTS/TPS/2024-03 R0

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#### OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT MOP

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No	Description	Details	
1.0	INSIDE DIMENSIONS	788 MM X 559 MM	
1.1	TOLERANCE	+ 30 MM, -0.00 (-NIL ON BOTH WIDTH AND LENGTH.)	
2.0	CAPACITY	50 KGS.	
3.0	BAG WEIGHT		
3.1	WEIGHT OF INDIVIDUAL BAG	108 GMS. TOLERANCE ± 3%	
3.2	43.2 KGS. (NET WT.)  TOLERANCE +3%/- 0.00% (No negative tolerance)		
4.0	BREAKING STRENGTH  TESTING OF BREAKING STRENGTH SHALL BE DONE RAVELLED STRIP METHOD (CONSTANT RATE OF TRAVER THE RATE OF TRAVERSE SHALL BE 300 MM/MINUTE.		
4.1	i) WIDTHWISE 91.8 KGF ii) WIDTHWISE 91.8 KGF (Lamination Joint)		
4.2	LENGTHWISE	91.8 KGF	
4.3	BOTTOM SEAM	40.8 KGF	
5.0 DROP TEST  S S S M D S		THE DROP TEST SHALL BE CARRIED OUT FOR EACH LOT SUPPLIED BY THE BAG SUPPLIER. FOR THIS TEST 4 nos. BAGS SHALL BE RANDOMLY SELECTED FROM EACH LOT. ALL BAGS SHALL BE SUBJECTED TO DROP TEST FROM A HEIGHT OF 3 MTRS FROM BOTH SIDES (4 DROP PER BAG). BAGS DURING DROP TEST WILL DROPPED ON THE STOMACH. NO BAGS SHOULD RUPTURE WHEN SUBJECTED TO MINIMUM 04 NOS. DROPS.	
6.0 FABRIC		BAGS MADE OUT OF SINGLE PIECE OF LAMINATED PP FABRIC WOVEN ON CIRCULAR LOOM AS PER IS 9755:2021. ANY MIDDLE SEWN OR JOINTED BAGS WILL NOT BE ACCEPTABLE. THE FABRIC USED SHALL BE FREE FROM ALL MAJOR WEAVING DEFECTS LIKE GAPS, PICK POINTS, MISSING TAPES ETC. PP GRANULE FOR FABRIC & UV MASTER BATCH- Grade H030SG OR	

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT MOP

PAGE 3 of 6

			EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF BAG SHALL BE MADE OUT OF UV STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PER METHOD GIVEN IN ANNEXURE-F OF IS 9755:2021. FABRIC COLOUR- HEX CODE: FCD4D2.
	6.1	TAPE	MONOAXIALLY ORIENTED PP TAPES HAVING 1000 DENIER AND MINIMUM WIDTH OF 2.5MM. THE FABRIC SHALL BE WOVEN FROM PP TAPES CONFORMING TO IS:11197. THE ELONGATION OF TAPES WHILE TESTING BREAKING STRENGTH SHALL BE IN THE RANGE OF 15 to 25%. TOLERANCE FOR DENIER: ±10% DENIER.
	6.2	MESH	10 x 10 PER SQ. INCH.
	6.3	ENDS PER DM	40. TOLERANCE ± 2
	6.4	PICKS PER DM	40. TOLERANCE ± 2
	6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
	6.5.1	LENGTHWISE	20%
	6.5.2	WIDTHWISE	20%
	6.5.3	TOLERANCE	RANGE: 15 to 25 % ON BOTH WIDTHWISE & LENGTHWISE.
	7.0	LAMINATION	FABRIC SHALL BE LAMINATED OUTSIDE WITH PP GRANULES (GRADE H350EG/H350FG OR EQUIVALENT) 23 GMS/M2 (CORRESPONDING TO 100 GUAGE NOMINAL) WITH AN OVERLAP/OVERHANG OF 5 - 15MM. VIRGIN PP GRANULES SHALL BE USED AND THE LAMINATION SHALL BE FREE FROM PIN HOLES, PATCHES, BLISTERS, TEARS ETC. THE LAMINATION SHOULD COVER THE ENTIRE OUTSIDE AREA OF THE FABRIC USED. COLOR OF LAMINATION OF BAGS SHALL BE TRANSPARENT
	8.0	BAG MOUTH	NEATLY SCISSOR CUT. EDGES SHOULD NOT BE ROUGH
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TECHNICAL PROCUREMENT SPECIFICATION

# OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT MOP

PAGE 4 of 6

9.0	BRANDING/PRINTING	MULTI COLOUR, SINGLE SIDE AS PER MONOGRAM SPECIFIED BY FACT. THE FOLLOWING INK (FERTILISER GRADE) SHALL BE USED: HINDUSTAN INK BY HINDUSTAN INKS AND RESINS LTD., DAMAN.OR VARSHA INK OF VARSHA PRINTING INK MFG. CO., NAGPUR. SHADE OF THE BRANDING SHALL BE UNIFORM AND MATCHING FACT'S REQUIREMENTS.			
	POLYAMIDE QUALITY, AL SMEAR IN CONTACT WIT BE PROVIDED BY FA RESISTANT/VERY SHARI THE LOT(PREFERABLY FOR THE BAGS OF THE SUBMITTED BEFORE STORY BE SIGNED AND APPRAUTHORIZED REPRESE COLOUR AS COMPARED EACH BAG SHALL BE CO	THE INK USED SHOULD HAVE SCRATCH RESISTANT AIDS, GLOSSY, HIGH TECH/POLYAMIDE QUALITY, ALKALI RESISTANT, SMUDGE FREE, BRIGHT IN COLOR, SHOULD NOT SMEAR IN CONTACT WITH WATER AND SHOULD NOT AFFECT THE FABRIC. ART WORK WILL BE PROVIDED BY FACT. PRINTING QUALITY SHALL BE CORONA TREATED SCUFF RESISTANT/VERY SHARP PRINT, NAIL PROOF/TAPE PROOF & EVEN COLORS THROUGHOUT THE LOT(PREFERABLY POLYAMIDE) ON ROLL TO ROLL PRINTING MACHINE. 3 SAMPLES OF THE BAGS OF THE REQUIRED COLOUR AS PER FACT REQUIREMENT SHALL BE SUBMITTED BEFORE STARTING BULK MANUFACTURING OF BAGS. ALL THE SAMPLES WILL BE SIGNED AND APPROVED SAMPLE WILL BE RETURNED WITH SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF FACT. ANY LOT SUPPLIED, IF FOUND DEVIATING IN COLOUR AS COMPARED TO APPROVED COLOUR WILL NOT BE ACCEPTED.  EACH BAG SHALL BE COMPULSORILY MARKED WITH BIS STANDARD MARK, SWATCH BHARAT LOGO AND RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2021, CLEARLY VISIBLE AT THE BOTTOM OF THE BAG.			
	SAMPLES FAIL TO PASS	THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION ED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-			
10.0	STITCHING  DOUBLE FOLD, DOUBLE STITCH WITH UV STABILISED THRE MULTIFILAMENT YARN OF 1200 DENIER. STITCHING SHALL DONE AS PRESCRIBED IN IS 9755. FOLD SHOULD OCCUR THE OPPOSITE SIDE OF THE PRINTING MADE ON THE BAG.				
11.0	PACKING  400 BAGS IN A BALE. BALES SHALL BE WRAPPED WITH HD FABRIC OR HESSIAN CLOTH AND STITCHED PROPERL WITHSTAND HAZARDS OF TRANSPORTATION. EACH BALE BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BA				

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TECHNICAL PROCUREMENT SPECIFICATION

# OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT MOP

PAGE 5 of 6

	SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT
ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. ASH CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING ALL IMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOT WILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2021 FOR TESTING ASH CONTENT.
CRITERIA FOR CONFORMITY	THE LOT SHALL BE CONSIDERED AS CONFORMING TO THE REQUIREMENTS FOR ACCEPTANCE IF ALL THE FOLLOWING CONDITIONS ARE SATISFIED.
ii. NONE OF THE RESPECTIVE LO	E DEFECTIVE BAGS IN CASE OF VISUAL INSPECTIONS, ENDS, PICKS IS UP TO 10% OF THE SAMPLE SIZE AFTER ROUNDING OFF THE EXT HIGHER INTEGER.  E BAG OR BALE OF 400 BAGS WEIGHS LESS THAN THE OWER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED  BREAKING STRENGTH OF FABRIC IN BOTH LENGTHWISE, D WIDTHWISE (LAMINATION JOINT) IS NOT LESS THAN THE VALUE ON NONE OF THE INDIVIDUAL VALUES IS MORE THAN 10% BELOW VALUE. THE SAMPLES SELECTED FOR BREAKING STRENGTH TESTS SEE FROM DEFECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, AS REQUIREMENTS.
LESS THAN TH MORE THAN 10 FOR SEAM S	BREAKING STRENGTH OF THE FABRIC AT BOTTOM SEAM IS NOT E VALUE SPECIFIED AND NONE OF THE INDIVIDUAL BAG VALUE IS PERCENT BELOW THE SPECIFIED VALUE. THE SAMPLE SELECTED TRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL IMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS.
	CRITERIA FOR CONFORMITY  i. THE NUMBER OF AND DIMENSION FRACTION TO N  ii. NONE OF THE RESPECTIVE LO  iii. THE AVERAGE WIDTHWISE AN SPECIFIED AND THE SPECIFIED SHALL BE FREDERICKS AND MASS  iv. THE AVERAGE LESS THAN THE MORE THAN 100 FOR SEAM ST

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT MOP

PAGE 6 of 6

	HE SAMPLE BAGS SHALL HAVE PERCENTAGE ELONGATION AND AS STRINGE THE SPECIFIED RANGE			
WEATHERING	THE PP BAG SAMPLES AFTER EXPOSING TO UV RADIATION AS SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT AL BREAKING STRENGTH.			
vii. NONE OF THE PP BAG SAMPLES SHALL FAIL IN THE DROP TEST				
TEST AND ST	HE PP BAG TEST SAMPLES SHALL FAIL IN THE TAPE TEST, ALKALI TANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIA AND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004)			
	APPLICABLE STANDARD SHALL BE IS 9755:2021 FOR PP WOVEN BAGS FOR PACKING FERTILISERS. HOWEVER, IN CASES			

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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

TECHNICAL PROCUREMENT SPECIFICATION (TPS)

FOR

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

FOR

PACKING BHARAT NPK 16:16:16

FACT UDYOGAMANDAL COMPLEX

KOCHI, INDIA

TPS No. UCTS/TPS/2024-07 R0

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

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No	Description	Details		
1.0	INSIDE DIMENSIONS	890 MM X 570 MM		
1.1	TOLERANCE	+ 30 MM, -0.00 ( -NIL ON BOTH WIDTH AND LENGTH.)		
2.0	CAPACITY	50 KGS.		
3.0	BAG WEIGHT			
3.1	WEIGHT OF INDIVIDUAL BAG	177 GMS. TOLERANCE ± 3%		
3.2	WEIGHT OF A BALE (250 BAGS)	44.25 KGS. (NET WT.)  TOLERANCE +3%/- 0.00% (No negative tolerance)		
4.0	BREAKING STRENGTH	TESTING OF BREAKING STRENGTH SHALL BE DONE US RAVELLED STRIP METHOD (CONSTANT RATE OF TRAVERSE). THE RATE OF TRAVERSE SHALL BE 300 MM/MINUTE.		
4.1	i) WIDTHWISE ii) WIDTHWISE (Lamination Joint)	91.8 KGF 91.8 KGF		
4.2	LENGTHWISE	91.8 KGF		
4.3	BOTTOM SEAM	40.8 KGF		
5.0	DROP TEST	THE DROP TEST SHALL BE CARRIED OUT FOR EACH LOT SUPPLIED BY THE BAG SUPPLIER. FOR THIS TEST 4 nos. BAGS SHALL BE RANDOMLY SELECTED FROM EACH LOT. ALL BAGS SHALL BE SUBJECTED TO DROP TEST FROM A HEIGHT OF 3 MTRS FROM BOTH SIDES (4 DROP PER BAG). BAGS DURING DROP TEST WILL DROPPED ON THE STOMACH. NO BAGS SHOULD RUPTURE WHEN SUBJECTED TO MINIMUM 04 NOS. DROPS.		
6.0	FABRIC	BAGS MADE OUT OF SINGLE PIECE OF LAMINATED PP FABRIC WOVEN ON CIRCULAR LGOM AS PER IS 9755,2021. ANY MIDDLE SEVEN OR JOINTED BAGS WILL NOT BE ACCEPTABLE. THE FABRIC USED SHALL BE FREE FROM ALL MAJOR WEAVING DEFECTS LIKE GAPS, PICK POINTS, MISSING TAPES ETC. PIGRANULE FOR FABRIC & UV MASTER BATCH- Grade H030SG OR		

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

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		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF BAG SHALL BE MADE OUT OF UV STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PER METHOD GIVEN IN ANNEXURE-F OF IS 9755:2021. FABRIC COLOURLIGHT BLUE (HEX CODE: ADD8E6).
6.1	TAPE	MONOAXIALLY ORIENTED PP TAPES HAVING 1000 DENIER AND MINIMUM WIDTH OF 2.5MM. THE FABRIC SHALL BE WOVEN FROM PP TAPES CONFORMING TO IS:11197. THE ELONGATION OF TAPES WHILE TESTING BREAKING STRENGTH SHALL BE IN THE RANGE OF 15 to 25%. TOLERANCE FOR DENIER: ±10% DENIER.
6.2	MESH	10 x 10 PER SQ. INCH.
6.3	ENDS PER DM	40. TOLERANCE ± 2
6.4	PICKS PER DM	40. TOLERANCE ± 2
6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
6.5.1	LENGTHWISE	20%
6.5.2	WIDTHWISE	20%
6.5.3	TOLERANCE	RANGE: 15 to 25 % ON BOTH WIDTHWISE & LENGTHWISE.
7.0	LAMINATION	FABRIC SHALL BE LAMINATED OUTSIDE WITH PP GRANULES (GRADE H350EG/H350FG OR EQUIVALENT) 23 GMS/M2 (CORRESPONDING TO 100 GUAGE NOMINAL) WITH AN OVERLAP/OVERHANG OF 5 - 15MM. VIRGIN PP GRANULES SHALL BE USED AND THE LAMINATION SHALL BE FREE FROM PIN HOLES, PATCHES, BLISTERS, TEARS ETC. THE LAMINATION SHOULD COVER THE ENTIRE OUTSIDE AREA OF THE FABRIC USED. COLOR OF LAMINATION OF BAGS SHALL BE TRANSPARENT
8.0	LINER	i. COLOUR : WHITE ii. HMHDPE WITH THICKNESS 50 MICRONS ±10% TOLERANCE

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

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		iii. LENGTH-915 MM X WIDTH-590 MM
		iv. HMHDPE GRADE-F55HM0003 or EQUIVALENT
		(LINER AND FABRIC SHOULD BE STICHED TOGETHER AT THE
		MOUTH AND AT BOTTOM. REF. CLAUSES 9.0 & 11.0)
and the second s		LINER AND FABRIC SHOULD BE STITCHED TOGETHER AT MOUTH
		BY MAKING SINGLE FOLD OF 25MM( LINER WITH FABRIC) FROM
		OUTER EDGE TOWARDS THE INSIDE OF THE BAG AND SINGLE
9.0	BAG MOUTH	ROW CHAIN STITCH AT 12MM FROM FOLD EDGE WITHOUT ANY
		LOOSE ENDS OR KNOTS BETWEEN THE STITCHES . THE
		STARTING AND CLOSING OF THE STITCH SHOULD NOT BE ON
		THE PRINTING SIDE
the state of the s		MULTI COLOUR, SINGLE SIDE AS PER MONOGRAM SPECIFIED BY
		FACT. THE FOLLOWING INK (FERTILISER GRADE) SHALL BE
		USED: HINDUSTAN INK BY HINDUSTAN INKS AND RESINS LTD.,
10.0	BRANDING/PRINTING	DAMAN.OR VARSHA INK OF VARSHA PRINTING INK MFG. CO.,
5 5		NAGPUR. SHADE OF THE BRANDING SHALL BE UNIFORM AND
		MATCHING FACT'S REQUIREMENTS.
	THE INK HEED CHOIL	ID HAVE SCRATCH RESISTANT AIRS GLOSSY HIGH TECH

THE INK USED SHOULD HAVE SCRATCH RESISTANT AIDS, GLOSSY, HIGH TECH/POLYAMIDE QUALITY, ALKALI RESISTANT, SMUDGE FREE, BRIGHT IN COLOR, SHOULD NOT SMEAR IN CONTACT WITH WATER AND SHOULD NOT AFFECT THE FABRIC. ART WORK WILL BE PROVIDED BY FACT. PRINTING QUALITY SHALL BE CORONA TREATED SCUFF RESISTANT/VERY SHARP PRINT, NAIL PROOF/TAPE PROOF & EVEN COLORS THROUGHOUT THE LOT(PREFERABLY POLYAMIDE) ON ROLL TO ROLL PRINTING MACHINE. 3 SAMPLES OF THE BAGS OF THE REQUIRED COLOUR AS PER FACT REQUIREMENT SHALL BE SUBMITTED BEFORE STARTING BULK MANUFACTURING OF BAGS.ALL THE SAMPLES WILL BE SIGNED AND APPROVED SAMPLE WILL BÉ RETURNED WITH SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF FACT. ANY LOT SUPPLIED, IF FOUND DEVIATING IN COLOUR AS COMPARED TO APPROVED COLOUR WILL NOT BE ACCEPTED.

EACH BAG SHALL BE COMPULSORILY MARKED WITH BIS STANDARD MARK, SWATCH BHARAT LOGO AND RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2021, CLEARLY VISIBLE AT THE BOTTOM OF THE BAG.

THE ENTIRE LOT OF PP BAGS SHALL BE LIABLE FOR REJECTION IN CASE THE TEST SAMPLES FAIL TO PASS THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

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	RESISTANCE OF PRINTED 98 (RE APPROVED 2004)	D MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264
11.0	STITCHING	SINGLE FOLD, SINGLE STITCH AT MOUTH AND DOUBLE FOLD DOUBLE STITCH AT BOTTOM WITH UV STABILISED THREAD MULTIFILAMENT YARN OF 1200 DENIER. STITCHING SHALL BE DONE AS PRESCRIBED IN IS 9755:2021. FOLD SHOULD OCCUR ON THE OPPOSITE SIDE OF THE PRINTING MADE ON THE BAG.
12.0	PACKING	250 BAGS IN A BALE. BALES SHALL BE WRAPPED WITH HDPE/PFABRIC OR HESSIAN CLOTH AND STITCHED PROPERLY TO WITHSTAND HAZARDS OF TRANSPORTATION. EACH BALE SHALL BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BACK SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALL WEIGHT
13.0	ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. AS CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING ALIMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOWILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2021 FOR TESTING ASH CONTENT
14.0	CRITERIA FOR CONFORMITY	THE LOT SHALL BE CONSIDERED AS CONFORMING TO THE REQUIREMENTS FOR ACCEPTANCE IF ALL THE FOLLOWING CONDITIONS ARE SATISFIED.
	AND DIMENSION FRACTION TO NE  ii. NONE OF THE RESPECTIVE LO	DEFECTIVE BAGS IN CASE OF VISUAL INSPECTIONS, ENDS, PICKS IS UP TO 10% OF THE SAMPLE SIZE AFTER ROUNDING OFF THEXT HIGHER INTEGER.  BAG OR BALE OF 250 BAGS WEIGHS LESS THAN THE WER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED  BREAKING STRENGTH OF FABRIC IN BOTH LENGTHWIS

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TECHNICAL PROCUREMENT SPECIFICATION OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16

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SPECIFIED AND NONE OF THE INDIVIDUAL VALUES IS MORE THAN 10% BELOW THE SPECIFIED VALUE. THE SAMPLES SELECTED FOR BREAKING STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS. THE AVERAGE BREAKING STRENGTH OF THE FABRIC AT BOTTOM SEAM IS NOT LESS THAN THE VALUE SPECIFIED AND NONE OF THE INDIVIDUAL BAG VALUE IS MORE THAN 10% BELOW THE SPECIFIED VALUE. THE SAMPLE SELECTED FOR SEAM STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS. NONE OF THE SAMPLE BAGS SHALL HAVE PERCENTAGE ELONGATION AND ASH ٧. CONTENT OUTSIDE THE SPECIFIED RANGE NONE OF THE PP BAG SAMPLES AFTER EXPOSING TO UV RADIATION AND vi. WEATHERING SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT OF THE ORIGINAL BREAKING STRENGTH. NONE OF THE PP BAG SAMPLES SHALL FAIL IN THE DROP TEST vii. NONE OF THE PP BAG TEST SAMPLES SHALL FAIL IN THE TAPE TEST, ALKALI viii. TEST AND STANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004) APPLICABLE STANDARD SHALL BE IS 9755:2021 FOR PP WOVEN BAGS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM **APPLICABLE** 15.0 THOSE IN IS 9755:2021, REQUIREMENTS IN THIS SPECIFICATION STANDARD SHALL PREVAIL OVER THOSE IN IS 9755:2021.

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OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 15:15:15 PAGE 1 of 6

UCTS/TPS/2024-04

# TECHNICAL PROCUREMENT SPECIFICATION (TPS)

**FOR** 

## OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

**FOR** 

**PACKING BHARAT NPK 15:15:15** 

#### FACT UDYOGAMANDAL COMPLEX

KOCHI, INDIA

TPS No. UCTS/TPS/2024-04 R0

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 15:15:15

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No	Description	Details			
1.0	INSIDE DIMENSIONS	890 MM X 570 MM			
1.1	TOLERANCE	+ 30 MM, -0.00 ( -NIL ON BOTH WIDTH AND LENGTH.)			
2.0	CAPACITY	50 KGS.			
3.0	BAG WEIGHT				
3.1	WEIGHT OF INDIVIDUAL BAG	177 GMS. TOLERANCE ± 3%			
3.2	WEIGHT OF A BALE (250 BAGS)	44.25 KGS. (NET WT.)  TOLERANCE +3%/- 0.00% (No negative tolerance)			
4.0	BREAKING STRENGTH	TESTING OF BREAKING STRENGTH SHALL BE DONE USING RAVELLED STRIP METHOD (CONSTANT RATE OF TRAVERSE) AND THE RATE OF TRAVERSE SHALL BE 300 MM/MINUTE.			
4.1	i) WIDTHWISE ii) WIDTHWISE (Lamination Joint)	91.8 KGF 91.8 KGF			
4.2	LENGTHWISE	91.8 KGF			
4.3	BOTTOM SEAM	40.8 KGF			
5.0	DROP TEST	THE DROP TEST SHALL BE CARRIED OUT FOR EACH LOT SUPPLIED BY THE BAG SUPPLIER. FOR THIS TEST 4 nos. BAGS SHALL BE RANDOMLY SELECTED FROM EACH LOT. ALL BAGS SHALL BE SUBJECTED TO DROP TEST FROM A HEIGHT OF 3 MTRS FROM BOTH SIDES (4 DROP PER BAG). BAGS DURING DROP TEST WILL DROPPED ON THE STOMACH. NO BAGS SHOULD RUPTURE WHEN SUBJECTED TO MINIMUM 04 NOS. DROPS.			
6.0	FABRIC	BAGS MADE OUT OF SINGLE PIECE OF LAMINATED PP FABRIC WOVEN ON CIRCULAR LOOM AS PER IS 9755:2021. ANY MIDDLE SEWN OR JOINTED BAGS WILL NOT BE ACCEPTABLE. THE FABRIC USED SHALL BE FREE FROM ALL MAJOR WEAVING DEFECTS LIKE GAPS, PICK POINTS, MISSING TAPES ETC. PER GRANULE FOR FABRIC & UV MASTER BATCH- Grade H030SG OR			

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TECHNICAL PROCUREMENT SPECIFICATION

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 15:15:15

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		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND
		THE PP WOVEN FABRIC OF BAG SHALL BE MADE OUT OF UV STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PER METHOD GIVEN IN ANNEXURE-F OF IS 9755:2021. FABRIC COLOUR-LIGHT BLUE (HEX CODE: ADD8E6).
6.1	TAPE	MONOAXIALLY ORIENTED PP TAPES HAVING 1000 DENIER AND MINIMUM WIDTH OF 2.5MM. THE FABRIC SHALL BE WOVEN FROM PP TAPES CONFORMING TO IS:11197. THE ELONGATION OF TAPES WHILE TESTING BREAKING STRENGTH SHALL BE IN THE RANGE OF 15 to 25%. TOLERANCE FOR DENIER: ±10% DENIER.
6.2	MESH	10 x 10 PER SQ. INCH.
6.3	ENDS PER DM	40. TOLERANCE ± 2
6.4	PICKS PER DM	40. TOLERANCE ± 2
6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
6.5.1	LENGTHWISE	20%
6.5.2	WIDTHWISE	20%
6.5.3	TOLERANCE	RANGE: 15 to 25 % ON BOTH WIDTHWISE & LENGTHWISE.
7.0	LAMINATION	FABRIC SHALL BE LAMINATED OUTSIDE WITH PP GRANULES (GRADE H350EG/H350FG OR EQUIVALENT) 23 GMS/M2 (CORRESPONDING TO 100 GUAGE NOMINAL) WITH AN OVERLAP/OVERHANG OF 5 - 15MM. VIRGIN PP GRANULES SHALL BE USED AND THE LAMINATION SHALL BE FREE FROM PIN HOLES, PATCHES, BLISTERS, TEARS ETC. THE LAMINATION SHOULD COVER THE ENTIRE OUTSIDE AREA OF THE FABRIC USED. COLOR OF LAMINATION OF BAGS SHALL BE TRANSPARENT
8.0	LINER	i. COLOUR : WHITE ii. HMHDPE WITH THICKNESS/150 MICRONS ±10% TOLERANCE

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		iii. LENGTH-915 MM X WIDTH-590 MM		
	The second of the	iv. HMHDPE GRADE-F55HM0003 or EQUIVALENT		
		(LINER AND FABRIC SHOULD BE STICHED TOGETHER AT THE		
		MOUTH AND AT BOTTOM. REF. CLAUSES 9.0 & 11.0)		
	BAG MOUTH	LINER AND FABRIC SHOULD BE STITCHED TOGETHER AT MOUTH		
		BY MAKING SINGLE FOLD OF 25MM( LINER WITH FABRIC) FROM		
		OUTER EDGE TOWARDS THE INSIDE OF THE BAG AND SINGLE		
9.0		ROW CHAIN STITCH AT 12MM FROM FOLD EDGE WITHOUT ANY		
		LOOSE ENDS OR KNOTS BETWEEN THE STITCHES . THE		
		STARTING AND CLOSING OF THE STITCH SHOULD NOT BE ON		
		THE PRINTING SIDE		
		MULTI COLOUR, SINGLE SIDE AS PER MONOGRAM SPECIFIED BY		
	BRANDING/PRINTING	FACT. THE FOLLOWING INK (FERTILISER GRADE) SHALL BE		
10.0		USED: HINDUSTAN INK BY HINDUSTAN INKS AND RESINS LTD.,		
10.0		DAMAN.OR VARSHA INK OF VARSHA PRINTING INK MFG. CO.,		
		NAGPUR. SHADE OF THE BRANDING SHALL BE UNIFORM AND		
		MATCHING FACT'S REQUIREMENTS.		
	THE INK HEED CHO	HID HAVE SCRATCH DESIGNANT AIDS GLOSSY HIGH TECH		

THE INK USED SHOULD HAVE SCRATCH RESISTANT AIDS, GLOSSY, HIGH TECH/POLYAMIDE QUALITY, ALKALI RESISTANT, SMUDGE FREE, BRIGHT IN COLOR, SHOULD NOT SMEAR IN CONTACT WITH WATER AND SHOULD NOT AFFECT THE FABRIC. ART WORK WILL BE PROVIDED BY FACT. PRINTING QUALITY SHALL BE CORONA TREATED SCUFF RESISTANT/VERY SHARP PRINT, NAIL PROOF/TAPE PROOF & EVEN COLORS THROUGHOUT THE LOT(PREFERABLY POLYAMIDE) ON ROLL TO ROLL PRINTING MACHINE. 3 SAMPLES OF THE BAGS OF THE REQUIRED COLOUR AS PER FACT REQUIREMENT SHALL BE SUBMITTED BEFORE STARTING BULK MANUFACTURING OF BAGS.ALL THE SAMPLES WILL BE SIGNED AND APPROVED SAMPLE WILL BE RETURNED WITH SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF FACT. ANY LOT SUPPLIED, IF FOUND DEVIATING IN COLOUR AS COMPARED TO APPROVED COLOUR WILL NOT BE ACCEPTED.

EACH BAG SHALL BE COMPULSORILY MARKED WITH BIS STANDARD MARK, SWATCH BHARAT LOGO AND RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2021, CLEARLY VISIBLE AT THE BOTTOM OF THE BAG.

THE ENTIRE LOT OF PP BAGS SHALL BE LIABLE FOR REJECTION IN CASE THE TEST SAMPLES FAIL TO PASS THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION

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	RESISTANCE OF PRINTED MATERIALS BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004)			
11.0	STITCHING	SINGLE FOLD, SINGLE STITCH AT MOUTH AND DOUBLE FOLD, DOUBLE STITCH AT BOTTOM WITH UV STABILISED THREAD/MULTIFILAMENT YARN OF 1200 DENIER. STITCHING SHALL BE DONE AS PRESCRIBED IN IS 9755. FOLD SHOULD OCCUR ON THE OPPOSITE SIDE OF THE PRINTING MADE ON THE BAG.		
12.0	PACKING	250 BAGS IN A BALE. BALES SHALL BE WRAPPED WITH HDPE/PI FABRIC OR HESSIAN CLOTH AND STITCHED PROPERLY TO WITHSTAND HAZARDS OF TRANSPORTATION. EACH BALE SHALL BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BAG SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALI WEIGHT		
13.0	ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT. AS WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. AS CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING AI IMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOWILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2021 FOR TESTING ASH CONTENT		
14.0	CRITERIA FOR CONFORMITY	THE LOT SHALL BE CONSIDERED AS CONFORMING TO THE REQUIREMENTS FOR ACCEPTANCE IF ALL THE FOLLOWING CONDITIONS ARE SATISFIED.		
44	AND DIMENSIONS FRACTION TO NE  ii. NONE OF THE RESPECTIVE LOV  iii. THE AVERAGE	DEFECTIVE BAGS IN CASE OF VISUAL INSPECTIONS, ENDS, PICKS IS UP TO 10% OF THE SAMPLE SIZE AFTER ROUNDING OFF THE XT HIGHER INTEGER.  BAG OR BALE OF 250 BAGS WEIGHS LESS THAN THE VER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED  BREAKING STRENGTH OF FABRIC IN BOTH LENGTHWISE, WIDTHWISE (LAMINATION JOINT) IS NOT LESS THAN THE VALUE		

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	SPECIFIED VALUE. THE	THE INDIVIDUAL VALUES IS MORE THAN 10% BELOW TH SAMPLES SELECTED FOR BREAKING STRENGTH TEST FECTS IN VISUAL INSPECTION, DIMENSIONS, ENDS, PICK S.		
	LESS THAN THE VALUE S MORE THAN 10% BELOW SEAM STRENGTH TESTS	<ul> <li>iv. THE AVERAGE BREAKING STRENGTH OF THE FABRIC AT BOTTOM SEAM IS NOT LESS THAN THE VALUE SPECIFIED AND NONE OF THE INDIVIDUAL BAG VALUE IS MORE THAN 10% BELOW THE SPECIFIED VALUE. THE SAMPLE SELECTED FOR SEAM STRENGTH TESTS SHALL BE FREE FROM DEFECTS IN VISUAL INSPECTION DIMENSIONS, ENDS, PICKS AND MASS REQUIREMENTS.</li> <li>v. NONE OF THE SAMPLE BAGS SHALL HAVE PERCENTAGE ELONGATION AND ASK CONTENT OUTSIDE THE SPECIFIED RANGE</li> </ul>		
		S SAMPLES AFTER EXPOSING TO UV RADIATION AN VE BREAKING STRENGTH LESS THAN 50 PERCENT C STRENGTH.		
	vii. NONE OF THE PP BAG SAI	MPLES SHALL FAIL IN THE DROP TEST		
	viii. NONE OF THE PP BAG TEST SAMPLES SHALL FAIL IN THE TAPE TEST, ALKALI TEST AND STANDARD TEST FOR ABRASION RESISTANCE OF PRINTED MATERIAL BY SUTHERLAND RUB TESTER: AS PER ASTM D5264-98 (RE APPROVED 2004)			
15.0	APPLICABLE BAGS WHERE THOSE	ABLE STANDARD SHALL BE IS 9755:2021 FOR PP WOVE FOR PACKING FERTILISERS. HOWEVER, IN CASE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM IN IS 9755:2021, REQUIREMENTS IN THIS SPECIFICATION PREVAIL OVER THOSE IN IS 9755:2021.		

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