

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/2022-12 R0

 FACT	FACT UDYOGAMANDAL COMPLEX	UCTS/TPS/2022-12 R0
TECHNICAL PROCUREMENT SPECIFICATION	OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 20:20:0:13	PAGE 1 of 5


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.)
2.0	CAPACITY	50 KGS.
3.0	BAG WEIGHT	
3.1	WEIGHT OF INDIVIDUAL BAG	130 GMS. TOLERANCE \pm 3%
3.2	WEIGHT OF A BALE (350 BAGS)	45.5 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. 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

0	24/11/22	ENQUIRY	SUJITH	NIBU	JAISON
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		FOR FABRIC & UV MASTER BATCH- Grade H030SG OR EQUIVALENT . MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF SACK 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-D OF IS 9755 /2016. 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: $\pm 10\%$ 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/M ² (CORRESPONDING TO 100 GAUGE 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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9.0	BRANDING/PRINTING	<p>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.</p>
		<p>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.</p> <p>EACH SACK SHALL BE COMPULSORILY MARKED WITH VISIBLE RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2016, IN THE BOTTOM OF THE BAG.</p> <p>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)</p>
10.0	STITCHING	<p>SINGLE FOLD, DOUBLE STITCH 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.</p>
11.0	PACKING	<p>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, SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT</p>

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PACKING BHARAT NPK 20:20:0:13****PAGE 4 of 5**

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 9755:2016 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 SACKS 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 SACK OR BALE OF 350 SACKS 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. v. NONE OF THE SAMPLE SACKS SHALL HAVE PERCENTAGE ELONGATION AND ASH CONTENT OUTSIDE THE SPECIFIED RANGE vi. NONE OF THE PP SACK 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 PP SACK SAMPLES SHALL FAIL IN THE DROP TEST			
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	viii. NONE OF THE PP SACK 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: 2016 FOR PP WOVEN SACKS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2016, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS 9755:2016.

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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 $\pm 3\%$
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.
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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: $\pm 10\%$ DENIER.
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6.3	ENDS PER DM	40. TOLERANCE ± 2
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6.5	ELONGATION AT BREAK OF FABRIC	(5.0 CM X 20 CM STRIP METHOD)
6.5.1	LENGTHWISE	20%
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8.0	BAG MOUTH	NEATLY SCISSOR CUT. EDGES SHOULD NOT BE ROUGH

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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.
		<p>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.</p> <p>EACH SACK SHALL BE COMPULSORILY MARKED WITH VISIBLE RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2016, IN THE BOTTOM OF THE BAG.</p> <p>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)</p>
10.0	STITCHING	SINGLE FOLD, DOUBLE STITCH 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.
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 BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BAG, SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT

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	viii. NONE OF THE PP SACK 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)	
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FOR

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

FOR

PACKING BHARAT MOP

FACT UDYOGAMANDAL COMPLEX

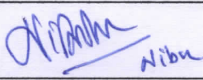
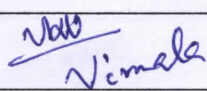
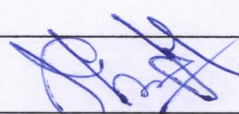
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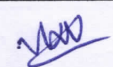
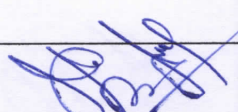
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No	Description	Details
1.0	INSIDE DIMENSIONS	788 MM X 559 MM
1.1	TOLERANCE	+ 30 MM, -0.00 (-NIL ON BOTH WIDTH AND LENGTH.)
2.0	CAPACITY	50 KGS.
3.0	BAG WEIGHT	
3.1	WEIGHT OF INDIVIDUAL BAG	108 GMS. TOLERANCE \pm 3%
3.2	WEIGHT OF A BALE (400 BAGS)	43.2 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. 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

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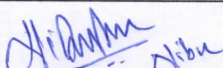
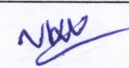

**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-03
R0****TECHNICAL
PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT MOP****PAGE 2 of 5**

		FOR FABRIC & UV MASTER BATCH- Grade H030SG OR EQUIVALENT . MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF SACK 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-D OF IS 9755 /2016. 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: $\pm 10\%$ 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/M ² (CORRESPONDING TO 100 GAUGE 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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R0****TECHNICAL
PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT MOP****PAGE 3 of 5**

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.
		<p>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.</p> <p>EACH SACK SHALL BE COMPULSORILY MARKED WITH VISIBLE RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2016, IN THE BOTTOM OF THE BAG.</p> <p>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)</p>
10.0	STITCHING	SINGLE FOLD, DOUBLE STITCH 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.
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 BE MARKED WITH NAME OF SUPPLIER, TYPE AND SIZE OF BAG, SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT

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**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-03
R0****TECHNICAL
PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT MOP****PAGE 4 of 5**

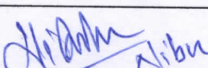
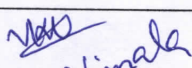
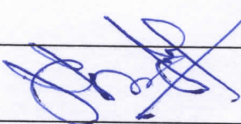
12.0	ASH CONTENT	ALL THE LOTS SUPPLIED SHALL BE TESTED FOR ASH CONTENT WHICH INCLUDES MAINLY CALCIUM CARBONATE CONTENT. ASH CONTENT IN BAGS SHALL BE 2.2% MAX (INCLUDING ALL IMPURITIES). IN CASE ASH CONTENT IS ABOVE 2.2% THE LOT WILL BE REJECTED. SAMPLES SHALL BE TAKEN OUT FROM THE LOT AS SPECIFIED IN IS 9755:2016 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.
	<ul style="list-style-type: none">i. THE NUMBER OF DEFECTIVE SACKS 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 SACK OR BALE OF 400 SACKS WEIGHS LESS THAN THE RESPECTIVE LOWER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTEDiii. 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% 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.v. NONE OF THE SAMPLE SACKS SHALL HAVE PERCENTAGE ELONGATION AND ASH CONTENT OUTSIDE THE SPECIFIED RANGEvi. NONE OF THE PP SACK 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 PP SACK SAMPLES SHALL FAIL IN THE DROP TEST	

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BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT MOP****PAGE 5 of 5**

	viii.	NONE OF THE PP SACK 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: 2016 FOR PP WOVEN SACKS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2016, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS 9755:2016.

(Ref.-TPS No. UCTS/TPS/2020-03 R1 DT.01/08/2020)

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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/2023-02 R0


**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-02
R0****TECHNICAL
PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT NPK 16:16:16****PAGE 1 of 5**

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	167 GMS. TOLERANCE $\pm 3\%$
3.2	WEIGHT OF A BALE (250 BAGS)	41.75 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	91.8 KGF
	ii) WIDTHWISE (Lamination Joint)	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 3M 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. 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


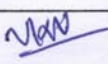
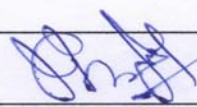
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**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-02
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PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT NPK 16:16:16****PAGE 2 of 5**

		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF SACK 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-D OF IS 9755 : 2016. 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: $\pm 10\%$ 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 (PP GRADE LAMINATION- H350EG/H350FG OR EQUIVALENT) 23 GMS/M ² (CORRESPONDING TO 100 GAUGE 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 40 MICRONS $\pm 10\%$ tolerance iii. LENGTH-915 MM X WIDTH-590 MM iv. HMHDPE GRADE-F55HM0003 or EQUIVALENT			
0	11/03/23	FIRST ISSUE			
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 FACT	FACT UDYOGAMANDAL COMPLEX	UCTS/TPS/2023-02 R0
TECHNICAL PROCUREMENT SPECIFICATION	OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 16:16:16	PAGE 3 of 5

		(Liner and fabric should be stitched together at the mouth and at bottom. Ref: clauses 9.0 & 11.0).
9.0	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 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
10.0	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.
		<p>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.</p> <p>EACH SACK SHALL BE COMPULSORILY MARKED WITH VISIBLE RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2016, IN THE BOTTOM OF THE BAG.</p> <p>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)</p>
11.0	STITCHING	SINGLE FOLD, SINGLE STITCH AT MOUTH AND SINGLE FOLD,

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**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-02
R0****TECHNICAL
PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT NPK 16:16:16****PAGE 4 of 5**

		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/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, SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT
13.0	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 9755:2016 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.
	<p>i. THE NUMBER OF DEFECTIVE SACKS 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.</p> <p>ii. NONE OF THE SACK OR BALE OF 250 SACKS WEIGHS LESS THAN THE RESPECTIVE LOWER SPECIFIED LIMIT. HIGHER WEIGHT CAN BE ACCEPTED</p> <p>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.</p> <p>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</p>	

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**FACT****FACT UDYOGAMANDAL COMPLEX****UCTS/TPS/2023-02
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PROCUREMENT
SPECIFICATION****OUTSIDE LAMINATED POLYPROPYLENE (PP)
BAGS WOVEN ON CIRCULAR LOOMS FOR
PACKING BHARAT NPK 16:16:16****PAGE 5 of 5**

	<p>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.</p> <p>v. NONE OF THE SAMPLE SACKS SHALL HAVE PERCENTAGE ELONGATION AND ASH CONTENT OUTSIDE THE SPECIFIED RANGE</p> <p>vi. NONE OF THE PP SACK SAMPLES AFTER EXPOSING TO UV RADIATION AND WEATHERING SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT OF THE ORIGINAL BREAKING STRENGTH.</p> <p>vii. NONE OF THE PP SACK SAMPLES SHALL FAIL IN THE DROP TEST</p> <p>viii. NONE OF THE PP SACK 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)</p>	
15.0	APPLICABLE STANDARD	APPLICABLE STANDARD SHALL BE IS 9755: 2016 FOR PP WOVEN SACKS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2016, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS.9755:2016.

(Ref.-TPS No. UCTS/TPS/2020-04 R1 DT.08/03/2021)

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Annexure VE

TECHNICAL PROCUREMENT SPECIFICATION (TPS)

FOR

OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS

FOR

PACKING BHARAT NPK 15:15:15


FACT UDYOGAMANDAL COMPLEX

KOCHI



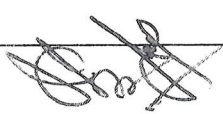
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TPS No. UCTS/TPS/2023-04 R0


37/L




 FACT	FACT UDYOGAMANDAL COMPLEX	UCTS/TPS/2023-04 R0
TECHNICAL PROCUREMENT SPECIFICATION	OUTSIDE LAMINATED POLYPROPYLENE (PP) BAGS WOVEN ON CIRCULAR LOOMS FOR PACKING BHARAT NPK 15:15:15	PAGE 1 of 5


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	167 GMS. TOLERANCE \pm 3%
3.2	WEIGHT OF A BALE (250 BAGS)	41.75 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 3M 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. 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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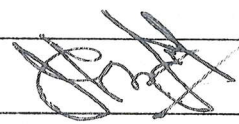
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		EQUIVALENT. MIN 3% of 20% UV MASTER BATCH TO BE USED AND THE PP WOVEN FABRIC OF SACK SHALL BE MADE OUT OF UV STABILISED MATERIAL AND SHALL HAVE AT LEAST 50% OF ORIGINAL BREAKING STRENGTH WHEN TESTED AFTER THE SAME HAS BEEN EXPOSED TO UV RADIATION AND WEATHERING AS PER METHOD GIVEN IN ANNEXURE-D OF IS 9755 : 2016. 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: $\pm 10\%$ 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 (PP GRADE LAMINATION- H350EG/H350FG OR EQUIVALENT) 23 GMS/M ² (CORRESPONDING TO 100 GAUGE 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 40 MICRONS $\pm 10\%$ tolerance iii. LENGTH-915 MM X WIDTH-590 MM iv. HMHDPE GRADE-F55HM0003 or EQUIVALENT			
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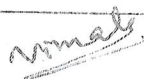
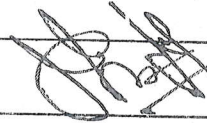
		(Liner and fabric should be stitched together at the mouth and at bottom. Ref: clauses 9.0 & 11.0).
9.0	BAG MOUTH	LINER AND FABRIC SHOULD BE STITCHED TOGETHER AT MOUTH BY MAKING SINGLE FOLD OF 25MM(LINER WITH FABRIC) FROM OUTER EDGE TOWARDS THE INSIDE OF THE BAG AND SINGLE ROW CHAIN STITCH AT 12MM FROM 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
10.0	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.
		<p>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.</p> <p>EACH SACK SHALL BE COMPULSORILY MARKED WITH VISIBLE RECYCLING LOGO (PP) AS SHOWN IN IS 9755:2016, IN THE BOTTOM OF THE BAG.</p> <p>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)</p>
11.0	STITCHING	SINGLE FOLD, SINGLE STITCH AT MOUTH AND SINGLE FOLD,


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		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/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, SERIAL NO. OF BALE, NO. OF BAGS IN THE BALE AND THE BALE WEIGHT
13.0	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 9755:2016 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.
	i. THE NUMBER OF DEFECTIVE SACKS 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 SACK OR BALE OF 250 SACKS 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	

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	<p>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.</p> <p>v. NONE OF THE SAMPLE SACKS SHALL HAVE PERCENTAGE ELONGATION AND ASH CONTENT OUTSIDE THE SPECIFIED RANGE</p> <p>vi. NONE OF THE PP SACK SAMPLES AFTER EXPOSING TO UV RADIATION AND WEATHERING SHALL HAVE BREAKING STRENGTH LESS THAN 50 PERCENT OF THE ORIGINAL BREAKING STRENGTH.</p> <p>vii. NONE OF THE PP SACK SAMPLES SHALL FAIL IN THE DROP TEST</p> <p>viii. NONE OF THE PP SACK 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)</p>		
15.0	<table border="1"> <tr> <td data-bbox="359 963 630 1258"> APPLICABLE STANDARD </td><td data-bbox="630 963 1458 1258"> APPLICABLE STANDARD SHALL BE IS 9755: 2016 FOR PP WOVEN SACKS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2016, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS.9755:2016. </td></tr> </table>	APPLICABLE STANDARD	APPLICABLE STANDARD SHALL BE IS 9755: 2016 FOR PP WOVEN SACKS FOR PACKING FERTILISERS. HOWEVER, IN CASES WHERE REQUIREMENTS IN THIS SPECIFICATION DIFFER FROM THOSE IN IS 9755:2016, REQUIREMENTS IN THIS SPECIFICATION SHALL PREVAIL OVER THOSE IN IS.9755:2016.
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