

PROCUREMENT SPECIFICATION FOR CYLINDER 8703

1. DESCRIPTION				
The container shall be constructed of two multiple spirally wound tubes, with one glued inside the other, fitted with metal ends and telescopic-type removable cover.				
Sl.No	CHARACTERISTICS	UNIT	SPECIFICATION	REMARKS
<b>2</b>	<b>FINAL CYLINDER</b>			
<b>2.1</b>	<b>PHYSICAL PROPERTIES</b>			Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/BODY ASSEMBLY
2.1.1	Overall Height	mm	1002.00	
2.1.2	Thickness of tube	mm	6±0.3	
2.1.3	Inner Dia at the metal end	mm	181±0.2	
2.1.4	Distance Between two metal ends	mm	938±3.00	
<b>3</b>	<b>OUTER TUBE</b>			
<b>3.1</b>	<b>PHYSICAL PROPERTIES</b>			Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/OUTER BODY
3.1.1	Height	mm	752±1.00	
3.1.2	Thickness	mm	6±0.30	
3.1.3	Inner Dia	mm	181±0.02	
<b>3.2</b>	<b>MATERIAL</b>			
3.2.1	Asphalt Impregnated kraft Poly Kraft 150 micron		MIL-P-20293A	Colour- Light Stone to BS 381 TINT 361
3.2.2	Alluminium Strip		(BS 1470:1972	
3.2.3	Adhesive			
3.2.3.1	For Asphalt Impregnated Kraft		GENKEM AKV 6139	
3.2.3.2	For Ploy Kraft		GAR 169	
<b>4</b>	<b>INNER TUBE</b>			
<b>4.1</b>	<b>PHYSICAL PROPERTIES</b>			Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/INNER BODY
4.1.1	Height	mm	926±1.00	
4.1.2	Thickness	mm	3±0.25	
4.1.3	Outer Diameter	mm	181±0.2	
4.1.4	No of Holes	No.	2	
4.1.5	Dia of Holes 180° apart	mm	8.00	
4.1.6	Distance of Centre of holes from top	mm	190±1.00	
<b>4.2</b>	<b>MATERIAL</b>			
4.2.1	Asphalt Impregnated kraft		MIL-P-20293A	Colour- Light Stone to BS 381 TINT 361
4.2.2	Adhesive Asphalt Impregnated Kraft		GENKEM AKV 6139	
<b>5</b>	<b>LID (OUTER TUBE)</b>			
<b>5.1</b>	<b>PHYSICAL PROPERTIES</b>			Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/OUTER TUBE (LID)
5.1.1	Height	mm	250±1.00	
5.1.2	Thickness	mm	6±0.3	
5.1.3	Inner Diameter	mm	181±0.2	
<b>5.2</b>	<b>MATERIAL</b>			
5.2.1	Asphalt Impregnated kraft Poly Kraft 150 micron		MIL-P-20293A	Colour- Light Stone to BS 381 TINT 361
5.2.2	Alluminium Strip		(BS 1470:1972	
5.2.3	Adhesive			
5.2.3.1	For Asphalt Impregnated Kraft		GENKEM AKV 6139	
5.2.3.2	For Ploy Kraft		GAR 169	
<b>6</b>	<b>LID ASSEMBLY</b>			
<b>6.1</b>	<b>PHYSICAL PROPERTIES</b>			Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/LID ASSEMBLY
6.1.1	Height	mm	250±1.00	
6.1.2	Thickness	mm	6±0.3	
6.1.3	Thickness of Protecting Disc	mm	20.00	
6.1.4	Height Upto Protecting Disc from bottom	mm	218±1.00	
6.1.5	Height from top to Protecting Disc	mm	12.00	
<b>6.2</b>	<b>MATERIAL</b>			
6.2.1	Asphalt Impregnated kraft Poly Kraft 150 micron		MIL-P-20293A	Colour- Light Stone to BS 381 TINT 361
6.2.3	Alluminium Strip		(BS 1470:1972	
6.2.4	Adhesive			
6.2.4.1	For Asphalt Impregnated Kraft		GENKEM AKV 6139	
6.2.4.2	For Ploy Kraft		GAR 169	



<b>7</b>	<b>METAL END</b>				
<b>7.1</b>	<b>PHYSICAL PROPERTIES</b>				
7.1.1	Bottom Diameter	mm	205±0.5		
7.1.2	Top Diameter	mm	180.80±0.5		
7.1.3	Thickness between bottom and top Dia	mm	12±0.5		Refer Drawing No OFN/BMCS/M-91/M-92/PACKING TUBE/METAL END
7.1.4	Distance from Bottom dia to Lower Inner circle	mm	42.50±0.5		
7.1.5	Distance from Top dia to Upper Inner circle	mm	19±0.5		
7.1.6	Thickness between Top and bottom inner circles	mm	5±0.5		
7.1.7	Thickness of Decoration	mm	0.64±0.16		
<b>7.2</b>	<b>MATERIAL</b>				
7.2.1	TIN plate		ISCOR NORM S.P.E.150		
7.2.2	TIN coating type E1		Thickness-0.47 mm (Nominal)		
7.2.3	External Decoration		Light Stone		(MAT finish) to BS 381C:TINT 361 with a specular Gloss at 60° of 10% Maximum of SABS Method 134.
7.2.4	DECORATION				
	INTERNAL		SIZE MB 44:One Coating		ROLLER COATED
7.2.4.1	LAQUER MBT		Two coating		ROLLER COATED
	EXTERNAL		SIZE MB 44:One Coating		ROLLER COATED
	LIGHT STONE		Two Coating		LITHO PRINTED
7.2.4.2	VARNISH MB 32		One Coating		
	VARNISH MB 32 with MATING AGENT		One Coating		
<b>8</b>	<b>PROTECTING DISC</b>				
<b>8.1</b>	<b>PHYSICAL PROPERTIES</b>				
8.1.1	Diameter	mm	180.40±0.3		Refer Drawing No OFN/BMCS/M-91/M-
7.1.3	Diameter of Inner circle	mm	6±3		92/PACKING TUBE/PROTECTING DISC
7.1.4	Thickness	mm	20±1		
<b>8.2</b>	<b>MATERIAL</b>				
	BOARD		Softwood GRADE B, Semi-Clear to SABS 1359:1982		Remove all Burns and Sharp Edges 1X30 mm Flat Surface allowed on circumference of protecting disc.
8.2.1					
<b>9</b>	<b>SPACER, PACKING TOP</b>				
<b>9.1</b>	<b>PHYSICAL PROPERTIES</b>				
9.1.1	Outer Diameter	mm	165±2		
9.1.2	Thickness	mm	38±2		Refer Drawing No OFN/BMCS/M-91/M-
9.1.3	No of Holes	Nos	3		92/PACKING TUBE/SPACER
9.1.4	Dia of Holes	mm	20.00		
9.1.5	Angle Between the centre of two holes with centre of spacer	Deg	120°		
<b>9.2</b>	<b>MATERIAL</b>				
	FOAM		Expanded closed cell, Cross linked Polyethylene		
9.2.1	Colour		Charcol		
	Density	kg/m <sup>3</sup>	33		
	Type		SPX 33		



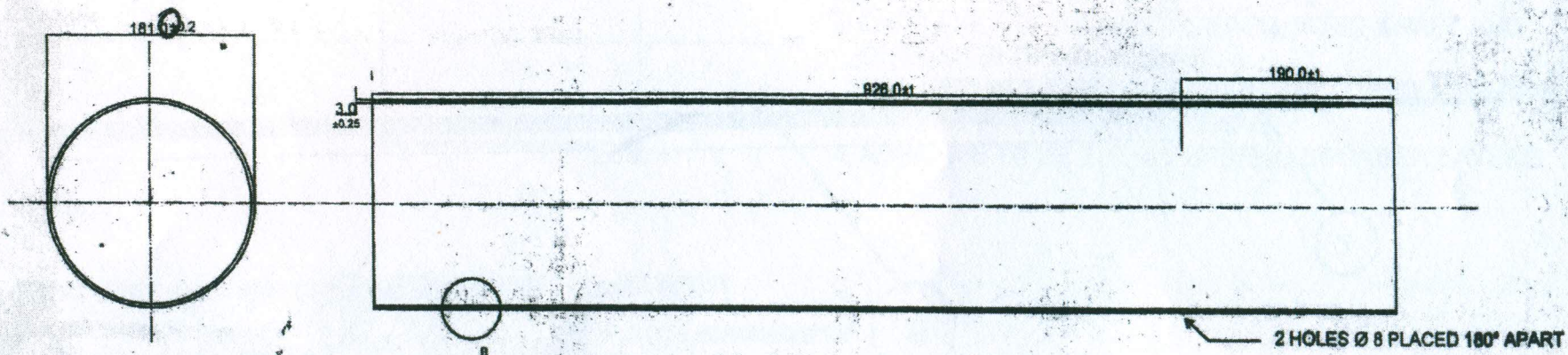
**MATERIAL:**

1. ASPHALT IMPREGNATED KRAFT TO SPECIFICATION MIL-P-20293A

COLOUR : LIGHT STONE TO BS 381 C : TINT 361

2. FOR ASPHALT IMPREGNATED KRAFT: USED ADHESIVE (CONTACT GENKEM AKV 6139)

3. ADHESIVE TO BE EVENLY SPREAD BETWEEN LAYERS.



PLIES OF EITHER 230 OR 340 g/m<sup>2</sup>  
KRAFT TO SUIT WALL  
REQUIREMENT



DETAIL OF B

ALL DIMENSION IN mm

ORDNANCE FACTORY NALANDA,  
RAJGIR, DIST. NALANDA, BIHAR-800121

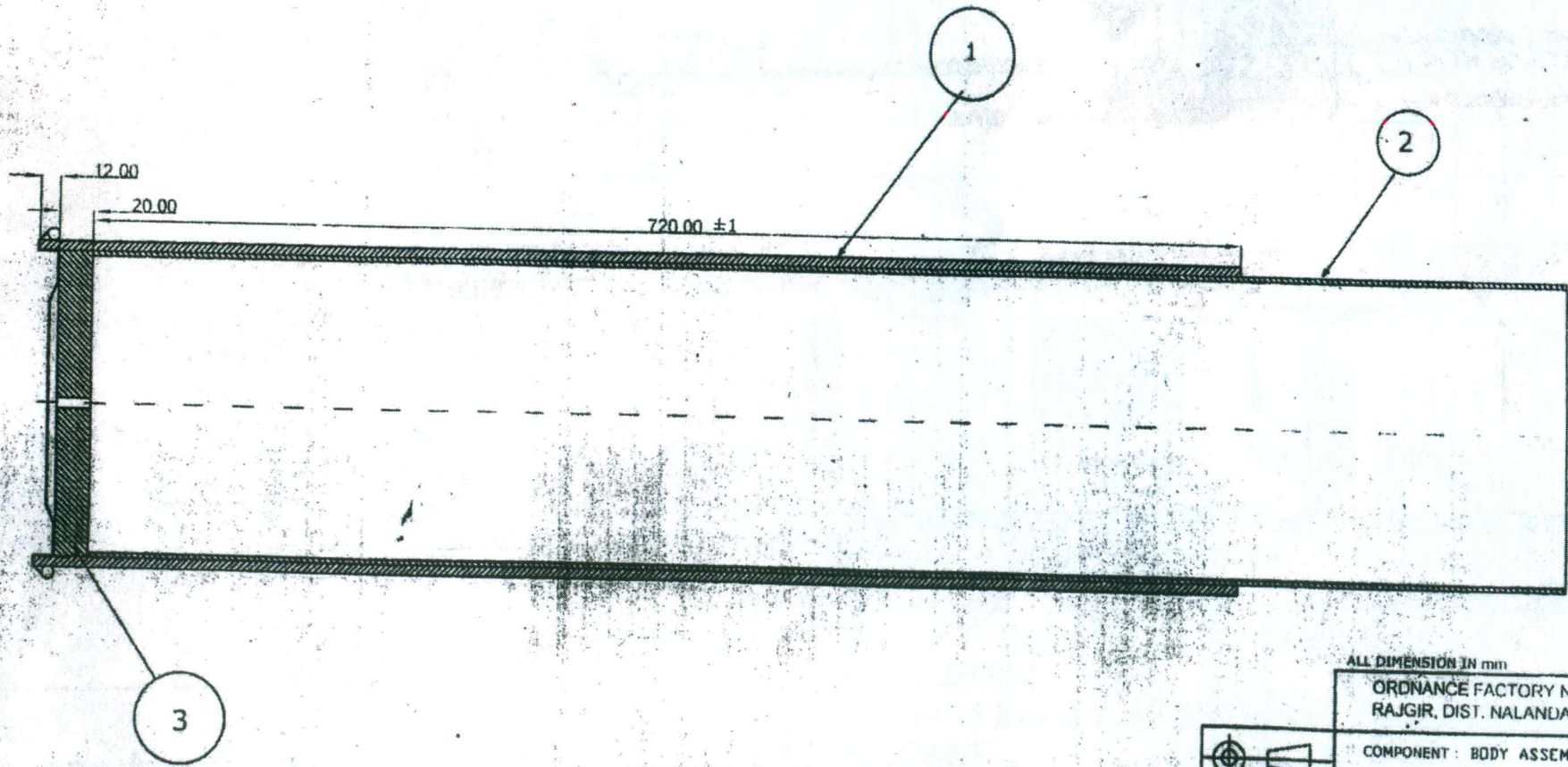
COMPONENT : INNER TUBE (BODY)

DESIGN NO.	QPL/2012/01-01/02/TACKING	REVISED	SCALE	FORM NO.
DATE				
BY				
CHECKED				
APPROVED				



Fit

- 1. METAL END AND OUTER TUBE (BODY ASSEMBLY).
- 2. INNER TUBE.
- 3. PROTECTING DISC.



ALL DIMENSION IN mm

ORDNANCE FACTORY NALANDA,  
RAJGIR, DIST. NALANDA, BIHAR-803121

COMPONENT : BODY ASSEMBLY



DATE	HOW

REVISION NO. 001/0002/01/01/02/PACKING  
TUBE/BODY ASSEMBLY

DIVISION	SCALE	FORMAT

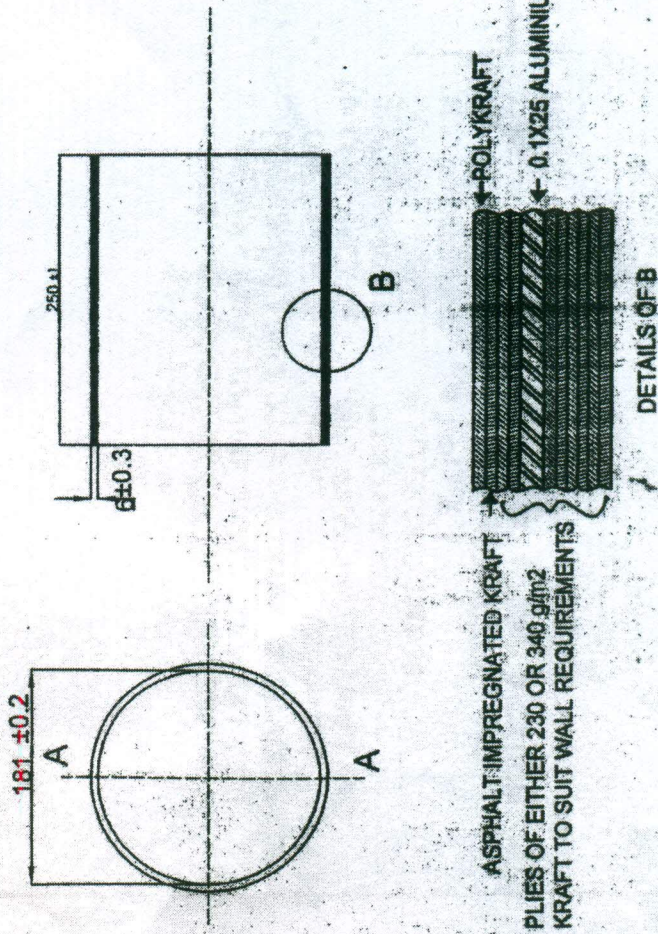


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3 of 16

**MATERIAL:**

1. ASPHALT IMPREGNATED KRAFT TO SPECIFICATION MIL-P-20293A AND POLY KRAFT 150 MICRON (150 g/m<sup>2</sup> BAG LINER / 24 g/m<sup>2</sup> P.E. )  
COLOUR : LIGHT STONE
2. ALUMINIUM STRIP TO BS 1470: 1972
3. ONE LAYER OF ASPHALT IMPREGNATED KRAFT AND ONE LAYER OF POLY KRAFT FOR ASPHALT IMPREGNATED KRAFT ; USED ADHESIVE FOR POLY KRAFT USE ADHESIVE
4. ADHESIVE TO BE EVENLY SPREAD BETWEEN LAYERS.



ALL DIMENSION IN mm

ORDNANCE FACTORY NALANDA,  
RAJGIR, DIST. NALANDA, BIHAR-803121

COMPONENT : OUTER BODY (LID)  
TUBE



DRAWN	DATE :	NAME :	DRAWING NO. :
CHECKED			
APPROVED			

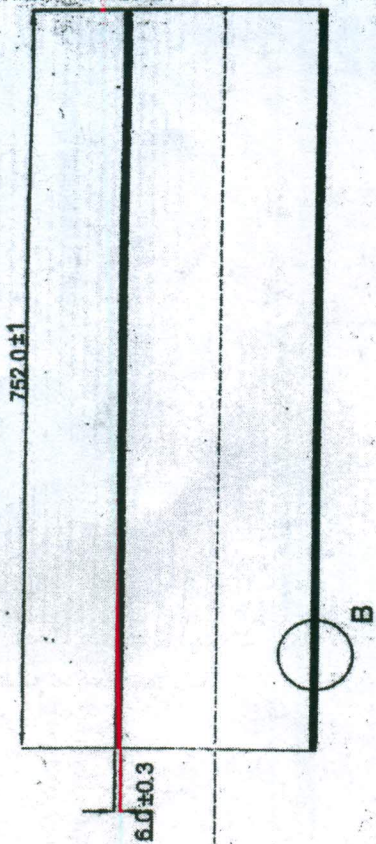
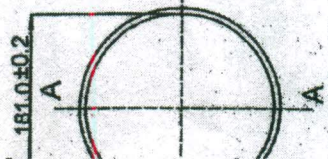
REVISION :  
DATE :  
BY :  
FOR :  
UTTER BODY / LID

SCALE :

FORMAT :

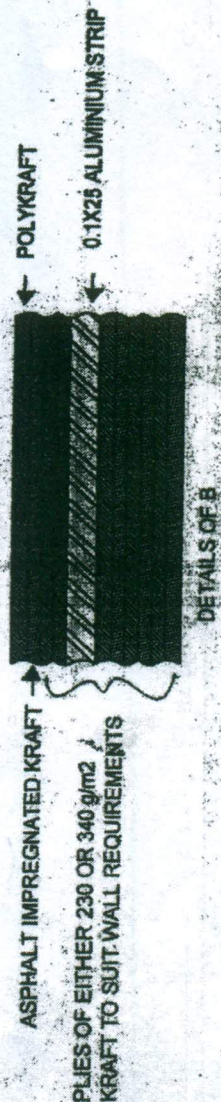


First



**MATERIAL:**

1. ASPHALT IMPREGNATED KRAFT TO SPECIFICATION MIL-P-20293A AND POLY KRAFT 150 MICRON (150 g/m<sup>2</sup> BAG LINER / 24 g/m<sup>2</sup> P.E.)  
COLOUR : LIGHT STONE TO BS 381C TINT 361
2. ALUMINIUM STRIP TO BS 1470: 1972
3. ONE LAYER OF ASPHALT IMPREGNATED KRAFT AND ONE LAYER OF POLY KRAFT. (GENIKEM AKV 619 B FOR ASPHALT IMPREGNATED KRAFT ; USED ADHESIVE FOR POLY KRAFT USE ADHESIVE (GAR 16 B))
4. ADHESIVE TO BE EVENLY SPREAD BETWEEN LAYERS.



ALL DIMENSION IN mm

ORDNANCE FACTORY NALANDA  
 RAJGIR, DIST. NALANDA, BIHAR-803171  
 COMPONENT / DUTCH BODY / BP-ASSEMBLY OF

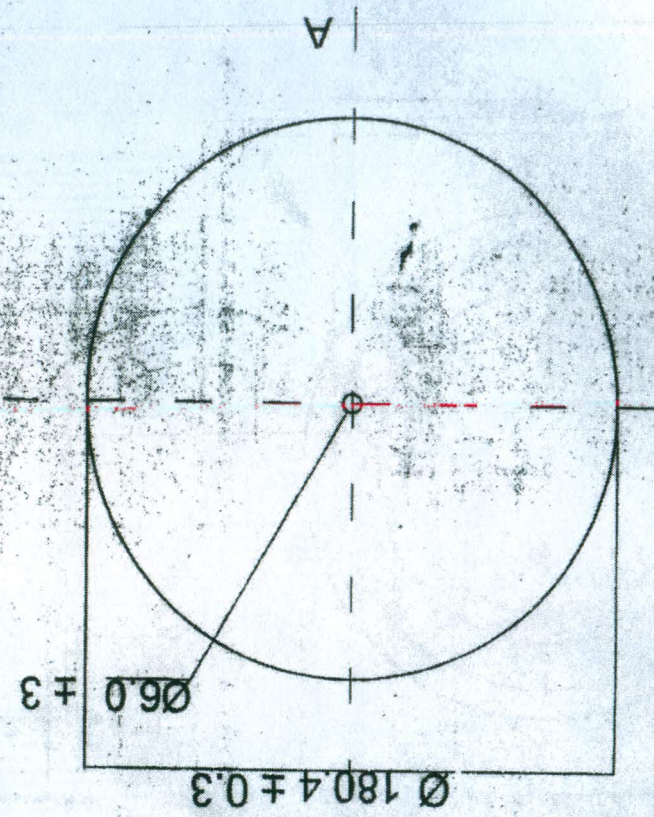
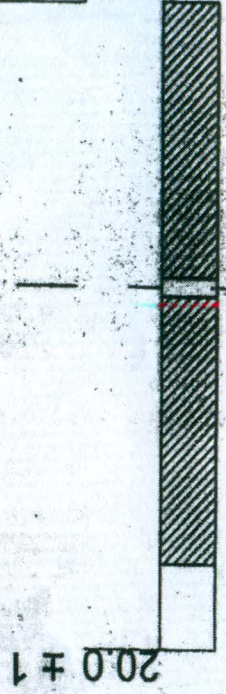


ORIGIN	DATE	NAME	DRAWING NO.	SECTION	SCALE	FORMAT
			OPN/MBE/M-91/M-92/PACKING TUBE/			

COMPONENT : PROTECTING DISC

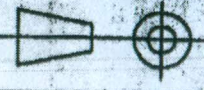
ORDNANCE FACTORY NALANDA,  
RAJGIR, DIST. NALANDA, BIHAR-803121

SECTION A-A



1. MATERIAL : BOARD, SOFTWOOD, GRADE B,  
 REFER TO SABS 1959-1982  
 2. REMOVE ALL BURRS AND SHARP EDGES  
 3. A MAXIMUM OF 1X30 mm FLAT SURFACE  
 ALLOWED ON CIRCUMFERENCE OF  
 PROTECTING DISC.

ALL DIMENSION IN MM





MATERIAL :

1. TIN PLATE TO ISCOR NORM S.P.E. 150

2. THICKNESS : 0.47 mm (NOMINAL) TIN COATING TYPE E1

3. FINISH PROCESS : STONE OR ORDINARY BRIGHT TEMPER

TS4 (T52.5 TO 55.5)

EXTERNAL DECORATION : LIGHT STONE (MAT FINISH) TO BS

381C:TINT 361 WITH A SPECULAR GLOSS AT 60° OF 10 %

MAXIMUM TO SABS METHOD 134

4. DECORATION TO CONSIST OF THE FOLLOWING :

4.1. INTERNAL : SIZE MB 44: ON COATING

LAQUER MBT: TWO COATINGS

4.2. EXTERNAL: SIZE MB 44: ONE COATING

LIGHT STONE : TWO COATINGS

VARNISH MB 32: ONE COATING

VARNISH MB 32 WITH MATING AGENT: ONE COATING

5. SEQUENCE OF COATING ON METAL END : AS SET OUT IN

POINT 4

6. METHOD OF APPLICATION OF DECORATION:

6.1 ALL MB 44 SIZE VARNISHES AND LAQUERS : ROLLER

COATED

6.2. LIGHT STONE : LITHO PRINTED

METAL THICKNESS INCLUDES DECORATION

ALL DIMENSION IN MM

ORDNANCE FACTORY NALANDA,

RAJGIR, DIST. NALANDA, BIHAR-803121

COMPONENT : METAL END



SECTION A-A

