

h/60/6-5

(2) (H)

RECORD OF AMENDMENTS

Amendment Srl. No	Date dd/mm/yy	Details of Amendments	Amendment Carried out by & Date
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1.	De No. 696-GS dt 22.5.2002		te)
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2.	De No. 707-GS dt 3.7.02	Added clause 6.1.3	(f) Approved by Controller M.S. Page 23 of case S/10094/G-5 Pt II 3/7/02
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*[Signature]*  
3/7/02  
G-6-3

3	DC No. 858-GS dt. 21/2/06	Add in clause 12.6 Table I and II	(G) Approved by Controller M.S. Page 14 of case C/181/05 G-5/G-2 21/2/06 G-6-3
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## 0.0 FOREWORD

0.1 This specification has been prepared by Controllerate of Quality Assurance (General Stores), Kanpur on behalf of the Director General Quality Assurance, Ministry of Defence, New Delhi.

0.2 This Specification Supersedes IND/GS/1537(d).

0.3 This specification shall be used to guide procurement, manufacture & Quality Assurance of the store for which it is intended.

0.4 The Quality Assurance Authority for the store covered by this specification is the Controller, Controllerate of Quality Assurance (General Stores), P.B.No.127, Kanpur-208 001. Enquiries regarding this specification related to technical or any other contractual conditions shall be referred to the Quality Assurance Authority named in the purchase document viz. tender or contract.

0.5 This Specification is a live document and is, therefore, likely to undergo changes. Any major change in design should have the approval of General Staff/Users, financial concurrence in the form of DGQA approval. Thus, it may involve some price difference. Therefore, a specification issued holds good only for the supply order for which it is issued.

0.6 Copies of any other reference documents such as specification/drawing/instructions/guides etc. can be obtained on payment from the addresses as shown below :-

0.7 Wherever a reference to any other specification occurs in this specification it shall be taken as a reference to the latest version of that specification.

## Specification

## Source

I.S. Series

Director General  
Bureau of Indian Standards, Manak Bhawan  
9, Bahadur Shah Zafar Marg,  
NEW DELHI-110 002.  
Or its Regional Offices at Mumbai,  
Kolkata, Chennai and Kanpur.

IND/GS/series  
JSS & Supple.  
Schedule in  
COA(GS)/GS.  
Series

The Controller,  
Controllerate of  
Quality Assurance  
(GS), PB No.127,  
KANPUR-208 001.

Or their Regional Establishments

1. Sr. Quality Assurance officer  
S. Q. A. Estt. (GS)  
Hastings, KOLKATA - 700 022.

IND/SL series

The Controller,  
Controllerate of  
Quality Assurance  
(Materials),  
PB.No.229, KANPUR-  
208 001.

2. Sr. Quality Assurance officer  
S. Q. A. Estt. (GS)  
DGQA Complex, LBS Marg  
Vikhroli, MUMBAI - 400 083.

3. Sr. Quality Assurance Officer  
S. Q. A. Estt. (GS)  
P. B. No. 307, KANPUR-208 001.

IND/TC series

The Controller,  
Controllerate of  
Quality Assurance  
(T&C), PB No 294,  
KANPUR-208 001.

4. Sr. Quality Assurance Officer  
S. Q. A. Estt (GS),  
Shahjahanpur - 242 001.

IND/SL series  
for petroleum  
products (if  
required).

The Controller,  
Controllerate of  
Quality Assurance  
(petroleum produ-  
cts), P.B. No.244,  
KANPUR-208 001.

5. Sr. Quality Assurance Officer  
S. Q. A. Estt (GS)  
DGQA Complex,  
Pazhavanthangal,  
CHENNAI - 600 114.

DMSRDE series The Director,  
(if required) DMSRDE, GT Road,  
KANPUR-208 013.

Sr. Quality Assurance Officer  
S. G. A. Estt (BS), Anand Parbat  
NEW DELHI-110 005.

## 1.0 SCOPE

1.1 This specification covers the requirements of the following stores and provides guidance to contractors / suppliers, manufacturers, Quality Assurance agencies and stockists/indentors etc.

DS Cat No.	Store	Size	Construction
(a) 8115-000264	Equipment Cargo Aerial Delivery Box, Cargo Aerial Delivery Corrugated Card Board	380 x 380 x 455 mm	One piece
(b) 8115-000265	-- do --	560 x 560 x 560 mm	Two piece
(c) 8115-000266	-- do --	890 x 380 x 560 mm	Two piece
(d) 1670-000090	Equipment Cargo Aerial Delivery Box, Cargo Aerial Delivery Corrugated Card Board Type SDB Parachute Supply Dropping 5.5 m Cotton	940 x 380 x 380 mm	One piece
(e) 1670-000274	Boxes Corrugated Card Board	460 x 460 x 350 mm	One or Two piece
(f) 1670-000275	-- do --	690 x 380 x 380 mm	One or Two piece

## 2.0 RELATED SPECIFICATIONS AND DOCUMENTS

Srl.No.	Specification No.	Title / Subjects
(a)	IS:1068-1993 (Third Revision)	Electroplated Coatings of Nickel plus Chromium and Copper plus Nickel plus Chromium on Iron & Steel.
(b)	IS:1570-1961 (Amdt.5) (Reaffirmed-1993)	Schedules for wrought steels for general Engineering purposes.
(c)	IS:2102 (Pt-I)-1993 (Third Revision)	General Tolerances: Dimensions without individual tolerance indications.
(d)	IS:2500 (Pt-I)-1992 (Second Revision)	Sampling Inspection procedures: Attribute sampling plans indexed by Acceptable Quality Level (AQL) for lot-by-lot inspection.
(e)	IS:2771 (Pt-I)-1990 (2nd Rev. Amdt. 1)	Fibreboard Boxes: Corrugated Fibre Board Boxes.
(f)	IS:3748-1990 (Second Revision) (Amdt. 1) Superseeding IS:3749	Tool & Die Steels.
(g)	IS:4185-1989 (1st Rev.) and CIS/SS/185(b)	Adhesive Paper Tapes.
(h)	IS:4905-1968 (Amdt. 1) (Reaffirmed-1991)	Methods for Random Sampling.
(i)	JSS:8115-1 with Amdt No.1 & and CIS/SS/27(e)	Boxes Rigid Collapsible Covered Type 'D'.
(j)	JSS:9330-2 with Amdt. list No.1 and CIS/SS/313(a)	Polythene film 0.04 mm thick.

3.0. STANDARD PATTERN

3.1 Standard pattern of Equipment Cargo Aerial Delivery Box Cargo Aerial Delivery Corrugated Card Board (DS Cat No. 8115-000264, 8115-000265, 8115-000266; 1670-000090; 1670-000274 and 1670-000275) held by the Controllerate of Quality Assurance (General Stores), Post Box No. 127, Kanpur shall constitute the standard as regards any particulars or properties, not noted or defined in this specification.

4.0 MATERIAL

4.1 The item shall be manufactured from the following materials :

Srl No.	Store/component	Material & Grade if any	Specification
(a)	Corrugated Card Board	i) Paper used for facing. ii) Paper used for inter-leaving. iii) Paper used for fluting. The paper shall be well sized and its substance shall be adequate to ensure the minimum Bursting strength of fabricated cardboard as stipulated in clause i.e. Bursting strength.	
(b)	Adhesive	Dextrine or any other suitable adhesive capable of firmly adhering the various plies together shall be used. (Sodium Silicate or any other highly alkaline adhesive shall not be used.) Besides the board shall have good bending quality.	
(c)	Eyelets aluminium no.24 and washers	Aluminium	IS:4084-1978
(d)	Line jute 4mm dia	Jute	IS:5177-1985
(e)	Staples	Mild Steel galvanised 0.8 mm thick X 12 mm Crown X 3 mm width. The Average zinc coating shall not be less than 5 micron. The staple shall be lacquered to avoid corrosion at cutting ends of stapling.	
(f)	Water proofing material	Ordinary paraffin wax or its blends having min. melting point of 60 degree Celsius shall be used for water proofing.	

4.2 Test certificates of materials from recognised laboratories shall be obtained showing physical and chemical properties if the manufacturer does not have his own laboratory.

5.0 PROCESSING

5.1 Equipment Cargo Aerial Delivery, Box Cargo Aerial Delivery Corrugated Card Board shall be manufactured to the shape and design as shown in the relevant plate attached to this specification.

5.2 Number of corrugations per 30 cm shall be 50 to 60.

5.3 The construction of the ECAD Box Cargo Aerial Delivery Corrugated Card Board shall be of 7 Ply, as shown in the plate attached to this specification.

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5.4 The Face forming the outside surface of the assembled box shall be made water proof by waxing.

5.5 The body joints shall be lapped outside and the lapping shall be not be less than 50 mm. Two rows of staples spaced not more than 65 mm apart, shall be used for securing the lapped portion and both the lapped ends shall be stapled with one additional staple. The distance between the outer staple end and the end of joints shall not exceed 25 mm.

5.6 The Alluminium eyelets shall be properly fitted as shown in the plates attached to this Specification.

5.7 Four pieces of the line jute each 61 cm long, shall be provided with each box and both the ends of each line shall waxed for a distance of 25 cm approximately.

6.0 DIMENSIONS AND TOLERANCES

6.1 DIMENSIONS

6.1.1 The store shall conform to the dimension shown in the plate attached to this specification.

6.1.2 The dimension of the boxes are internal as these are related with the capacity of box; hence no tolerances shall be allowed on internal dimensions affecting capacity.

6.1.3 TOLERANCES

6.1.3 - "The drawing to specification is to render guidance to manufacturer and is to be interpreted in conjunction with clause 6.1.2 and other stipulations"

02 (Pt-I)-1993  
/Parts  
staples, eyelets  
of box.

7.1 The boxes shall be smoothly finished and free from surface defects, like wrinkles, delamination, deformation or damage. The flap should be neatly cut/slotted and evenly creased. The joints shall be uniformly stapled and eyelets shall be properly clinched. General workmanship and finish shall be similar to the sealed sample held by the AHSP.

7.2 The general workmanship and finish shall be of a high standard and similar to sealed pattern.

8.0 PRE-INSPECTION OF SUPPLIES BY THE PRODUCER

8.1 ADVANCE SAMPLE : If required the manufacturers shall submit three(3) advance samples of acceptable quality fabricated from specified material for approval by CGA(68) Kanpur prior to commencement of bulk production.

8.2 Manufacturers/contractors must satisfy themselves first that the store manufactured are in accordance with the contract and fully conform to the specification, by carrying out thorough pre-inspection of each lot/batch, before actually tendering the same for inspection to the Quality Assurance Officer nominated under the terms of the contract.

JOYI OFFICE  
ZETA  
WARRINGTON, J.A. 12  
EZA

8.3 A declaration by the Contractor that necessary pre-inspection tests have been carried out on the stores tendered and the same are fit for inspection and test, shall be rendered along with the challan. The declaration shall include the method followed in pre-inspection showing features checked/tested.

#### 9.0 QUALITY ASSURANCE

9.1 Examination of samples taken from any portion of the consignment or during surveillance inspection, shall conform to the requirement when tested in accordance with the methods mentioned against each in this specification.

9.2 Control samples shall be forwarded to CQA(GS) Kanpur from bulk supplies to check/monitor the quality whenever required.

#### 10.0 SAMPLING PROCEDURE

10.1 The suppliers shall arrange the units of the homogeneous lot in such a way that all the units are easily accessible to the Quality Assurance Officer to enable him to draw samples from any portion of the homogeneous lot.

10.2 Sampling of stores shall be done adopting appropriate sampling method as per IS:4905-1968 Amdt.1 (Reaffirmed-1991) so that samples drawn as per Table I and II given for assessing various quality requirements, are truly representative of the lot.

#### 11.0 SCALE OF SAMPLING

11.1 The number of sample-units to be drawn for assessing the quality of the store, characteristic wise, should be in accordance with the Table I for dimensional/non destructive/visual inspection and Table II for detailed laboratory testing.

#### 12.0 CRITERIA FOR CONFORMITY

12.1 All the sample units as specified in Table I and II are required to be tested / inspected irrespective of the rejection number (= Ac+1) being achieved earlier.

12.2 The Quality Assurance Officer shall draw samples as per Table I for dimensional/nondestructive/visual inspection to assess the quality of the lot. If the quality of the lot indicates conformity to the standard as laid down in Table I, sampling for laboratory testing will be done. Otherwise the lot shall be straightway rejected.

#### 12.3 Sampling for Laboratory Testing

12.3.1 If the lot is considered conforming to the quality standards as specified in Table I, sampling for laboratory tests shall be carried out as per Table II and the samples shall be subjected to the laboratory tests.

#### 12.4 Bulk Sentencing

12.4.1 If the laboratory test report indicates that the lot does not conform to the standards as specified in Table II, the whole lot shall be rejected.

12.4.2 The lot shall be considered conforming to the specified quality if the number of defective units observed in the sample is not more than the respective acceptance number of each class of defects.

12.4.3 When the sample size equals to the lot size, do 100% Quality Assurance.

12.4.4 The number of sample units to be sampled for laboratory testing should be a multiple of the number of Characteristics / tests which can not be carried out simultaneously on the same sample units.

12.5 Sampling and Formation of Lot

12.5.1 The delivery shall be visually inspected by the Quality Assurance Officer at the spot in the first instance to ascertain its homogeneity in respect of nature, size, shape, source and year of manufacture. If it is homogeneous, the delivery shall be treated as one lot. If not, it shall be segregated by the supplier into separate groups so that each group which is homogeneous within itself forms a lot.

12.6 Sampling Tables

Table I  
Sampling plan for Visual Inspection  
(Based on General Inspection Level II, AQL 2.5%)

Lot Size	Sample Size (n)	Acceptance Number (Ac)
Up to 50	8	1
51 to 90	13	1
91 to 150	20	1
151 to 280	32	2
281 to 500	50	3
501 to 1200	80	5
1201 to 3200	125	7
3201 to 10000	200	10
10,001 to 35,000	315	14 (2)

Table II  
Special inspection level S-3 and S-4 AQL 2.5%  
Based on Table II A for laboratory testing.

Lot Size	Sample Size (n)		Acceptance Number (Ac)	
	S-3	S-4	S-3	S-4
up to 50	3	5	0	0
51 to 90	5	5	0	0
91 to 150	5	8	0	1
151 to 280	8	13	1	1
281 to 500	8	13	1	1
501 to 1200	13	20	1	1
1201 to 3200	13	32	1	2
3201 to 10000	20	32	1	2
10,001 to 35,000	20	50	1	3 (2)

- Note :
- i) When the sample size equals or exceeds lot size do 100% inspection/non-destructive testing with zero acceptance number.
  - ii) The Rejection number (Re) will always be one more than the Acceptance number (Ac).
  - iii) Level S-3 for Chemical tests (individual sample to be tested).
  - iv) Level S-4 for Physical tests (individual sample to be tested).

Source : IS:2502(Pt-I)-1992 (2nd Rev) : (Sampling Inspection Procedures).



## 12.7 Test Methods

### 12.7.1 Physical Tests :

12.7.1.1 Samples shall be drawn as per special Inspection level S-3 of table-II.

12.7.1.2 Conditioning:- The corrugated card board shall be conditioned before carrying out bursting test, by exposure in an atmosphere maintained at a temperature of  $27 \pm 2$  degree celcius and  $65 \pm 5\%$  relative humidity for a minimum period of 24 hours.

12.7.1.3 Bursting Strength:- After carrying out conditioning when tested by the method mentioned in clause 12.5 of IS:1060 (Pt-I) - 1966, the average bursting strength of the corrugated card board boxes shall not be less than 235 N/Sq. Cm (24 Kg/Sq. Cm). The average shall be based on 5 (five) determinations on each face but no individual reading shall be less than 206 N/Sq. Cm (21 Kg/Sq. Cm). The test specimen shall be taken from the central faces of boards.

12.7.1.4 Waterproofness test:- The outer waxed face of the Corrugated Card Board shall be subjected to waterproofness test (Cobb/30 minutes) as per method given in clause 6 of IS:4006(Pt-I). At the end of 30 minutes the increase in mass due to water absorption shall not be more than 120 g/sqm.

12.7.2 Chemical Tests : Chemical analysis, thickness/amount of plating/coating shall be checked as per special inspection level S-4 of Table II.

12.7.2.1 Acidity and Alkalinity :- The Hydrogen ion concentration (pH value) of the water extract shall be not less than 5.5 and not more than 8.0 when determined according to the method given in clause 10 of IS:1060(PT-I)-1966.

### 12.7.3 Performance Tests :

12.7.3.1 Strength of Joints :- The strength of joints shall be observed by grasping a body or a cover in the hands, on each side of the joint, and pulling until the joint ruptures, Failure shall occur in the Board but not in the fasteners.

12.7.3.2 Flap Bend Test : The Flap when bent through 180 degree forward along the line of crease to touch the inner surface and then bent back through 360 degrees to touch the outer surface, the Board shall not show any sign of rupture at the crease.

## 13.0 MARKING

### 13.1 Marking by the supplier

13.1.1 The store shall be legibly and indelibly marked with :

- (a) Manufacturer's name, initials or recognised trade mark.
- (b) The year of manufacture.
- (c) D. S. Catalogue number of the store.

### 13.2 Marking by the Quality Assurance Officer

13.2.1 Each accepted store shall be legibly and indelibly marked using stencil plate or Rubber / Steel stamp of letter size 6 mm depending upon the size of the store/component.

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13.2.2 In case of small components, where steel stamping or stencilling is not possible, the rubber acceptance mark shall be stamped on individual packages containing the items for this purpose, each package shall be sealed by a continuous piece of gummed tape such that ends overlap each other. Acceptance marks shall be affixed on the joint of the tape end partly covering the package.

13.3 The final rejections may be marked by Quality Assurance Officer by stamping the letter 'X' on both sides of the manufacturer's marking thus :

DS Cat No.  
X M - - - & CO X  
2002

14.0 PACKAGING

14.1 Packing

14.1.1 Materials

Conforming to

- (a) Polythene Film 0.04 mm thick (Low density bag) JSS:9330-2 with Amdt. List No.1 and D165/SS/313(a).
- (b) Label Card Board 45 x 25 mm with Bursting Strength 775 kPa.
- (c) Country jute twine IS:1912-1984 (2nd Rev.) Amdt.1 Reaffirmed - 1991.
- (d) Textile Heavy Cee Jute Cloth tie-on-tag IS:3751-1993 (1st Rev.).

14.2 Method

14.2.1 The number of boxes per bundle shall be as follows.

940 mm x 380 mm x 380 mm	:	
890 mm x 380 mm x 560 mm	:	10 per bundle
560 mm x 560 mm x 560 mm	:	
690 mm x 380 mm x 380 mm	:	
460 mm x 460 mm x 350 mm	:	
380 mm x 380 mm x 455 mm	:	20 per bundle.

The boxes of any one size in collapsed condition shall be covered with at least one layer of Polythene Film 0.04 mm thick conforming to JSS:9330-02 and securely tied with Jute Twine conforming to IS:1912-1984, then sewn in a single layer of Heavy Cloth Cee conforming to IS:3751-1993 to form a bundle.

14.2.2 One item in each bundle shall be tied with a label Card Board 45 x 25 mm bearing DS Cat No. and Nomenclature of the store.

14.2.3 Mass of any bundle shall not exceed 40 kg. In order to maintain the limit of mass, the number of items in the package may be altered at the discretion of OAO.

14.3 Marking on Package

14.3.1 Each final package shall be legibly and indelibly marked as under.

- (a) Front and Top
  - i) D.S. Cat.No. and designation of the store.
  - ii) Qty packed, preceded by the abbreviation 'QTY'.

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13.2.2 In case of small components, where steel stamping or stencilling is not possible, the rubber acceptance mark shall be stamped on individual packages containing the items for this purpose, each package shall be sealed by a continuous piece of gummed tape such that ends overlap each other. Acceptance marks shall be affixed on the joint of the tape end partly covering the package.

13.3 The final rejections may be marked by Quality Assurance Officer by stamping the letter 'X' on both sides of the manufacturer's marking thus :

DS Cat No.  
X M - - - & CO X  
2002

14.0 PACKAGING

14.1 Packing

14.1.1 Materials

Conforming to

- (a) Polythene Film 0.04 mm thick (Low density bag) JSS:9330-2 with Amdt. List No.1 and CI65/SS/313(a).
- (b) Label Card Board 45 x 25 mm with Bursting Strength 775 kPa.
- (c) Country jute twine IS:1912-1984 (2nd Rev.) Amdt.1 Reaffirmed - 1991.
- (d) Textile Heavy Cee Jute Cloth tie-on-tag IS:3751-1993 (1st Rev.).

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380 mm x 380 mm x 455 mm	:	20 per bundle.

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14.2.3 Mass of any bundle shall not exceed 40 kg. In order to maintain the limit of mass, the number of items in the package may be altered at the discretion of OAO.

14.3 Marking on Package

14.3.1 Each final package shall be legibly and indelibly marked as under.

- (a) Front and Top
  - i) D.S. Cat.No. and designation of the store.
  - ii) Qty packed, preceded by the abbreviation 'QTY'.

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specification No IND/GS/1537(105)  
(9)

- (b) Back
  - i) Name and address of the consignee as given in the contract.
  - ii) Mass of the package in Kilogram preceded by the abbreviation 'Kg'.
  - iii) Number of the individual package and total number of packages in the consignment i.e. 1 of 4, 2 of 4, 3 of 4 and 4 of 4 when the consignment consists of 4 packages.
- (c) Left end
  - i) Consignor's name, initials or recognised Trade Mark.
  - ii) Month and year of packing.
  - iii) A/T, S/D or Extract No. and Date.
  - iv) I/Note No. and Date.

15.0 TECHNICAL LITERATURE / DOCUMENTS

15.1 Illustrated spare parts list History sheet/maintenance manual shall be supplied with each store wherever required/demanded.

16.0 WARRANTY

16.1 Stores supplied against this specification shall be deemed to bear the warranty of the contractor against defective design material, workmanship and performance for a period of twelve months from the date of receipt of store at consignee end, and if during the specified period, the store supplied are found to be defective, the same shall be replaced immediately with serviceable store by the contractor at site free of any charges as may be decided by the purchasing officer, on recommendation of consignee/Quality Assurance Authority.

17.0 DRAWINGS & SKETCHES

Sl.No.	Sheet No.	Detail No.	Component/Assembly
1.	Plate 1 of 6	--	890 x 380 x 560 mm
2.	Plate 2 of 6	--	560 x 560 x 560 mm
3.	Plate 3 of 6	--	380 x 380 x 455 mm
4.	Plate 4 of 6	--	940 x 380 x 380 mm
5.	Plate 5 of 6	--	690 x 380 x 380 mm
6.	Plate 6 of 6	--	460 x 460 x 350 mm

18.0 SUGGESTIONS FOR IMPROVEMENT

18.1 This specification is a live document and subject to change/updating. Any suggestions for improvement of this document may be sent to the Controller, CQA(GS) Kanpur.

(J.C. MAKANI)  
Jt. Controller

(A.K. BANDYOPADHYAY)  
CONTROLLER

(R.K. THAKUR)  
DCIA-3

CONTROLLERATE OF QUALITY ASSURANCE (GS)

POST BOX NO.127.

KANPUR - 208 001

(SC. AGARWAL)  
JSD

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