

Annexure - I

9. PLASTIC FILM BAG FOR M-91 & M-92 & SLEEVE FOR M-92

1. ACCEPTANCE CRITERIA

1.1 CHEMICAL COMPOSITION

Sl. No.	Ingredients	Composition	Specification No.
1.	Polyethylene Terephthalate	100(%)	TOT Specification No. 06-7600-2010-168

1.2 PHYSICAL PROPERTIES

Sl. No.	Test Parameters	Specified Value		
		M-91	M-92	Sleeve
1	Mean Tensile Strength (MPa) #	210	210	210
2	Any dirt, oil or foreign matter affecting appearance or usability	None to be Observed (Visual)		
	Any deep scratch	None to be Observed (Visual)		
	Any holes including pin holes	None to be Observed (Visual)		
	Any rough or sharp edge	None to be Observed (Visual)		
	Any cut, blister, bubble, tear, scuff, crack or crease	None to be Observed (Visual)		
	Any pimple or pit	None to be Observed (Visual)		
	Any chipping	None to be Observed (Visual)		
	Any spot, stain or other discolouration affecting appearance or usability	None to be Observed (Visual)		
	Not clear or clarity not uniform	None to be Observed (Visual)		
Not uniformly transparent	None to be Observed (Visual)			

Minimum 150 MPa to be ensured

1.3 DIMENSIONS

Sl. No.	Characteristics	Specified Value		
		M-91	M-92	Sleeve
1	Thickness (μ)	15 Nominal	17-30	15 Nominal
3	Length (mm)	457±10.0	457±10.0	190±10.0
4	Width (mm)	260±10.0	260±10.0	85±10.0 flat (Dia 54)
5	Width of Heat Seal (mm)	Not Less than 2 (Both side)	Not Less than 2 (Both side)	Not Less than 2 (One side)

Refer Drawing No OFN/BMCS/M-91/M-92/PLASTIC FILM BAG &
OFN/BMCS/ M-92/PLASTIC FILM SLEEVE

1.4 Inspecting Authority: GM/ O F Nalanda

1.5 Accepting Authority GM/ O F Nalanda

Yodanis

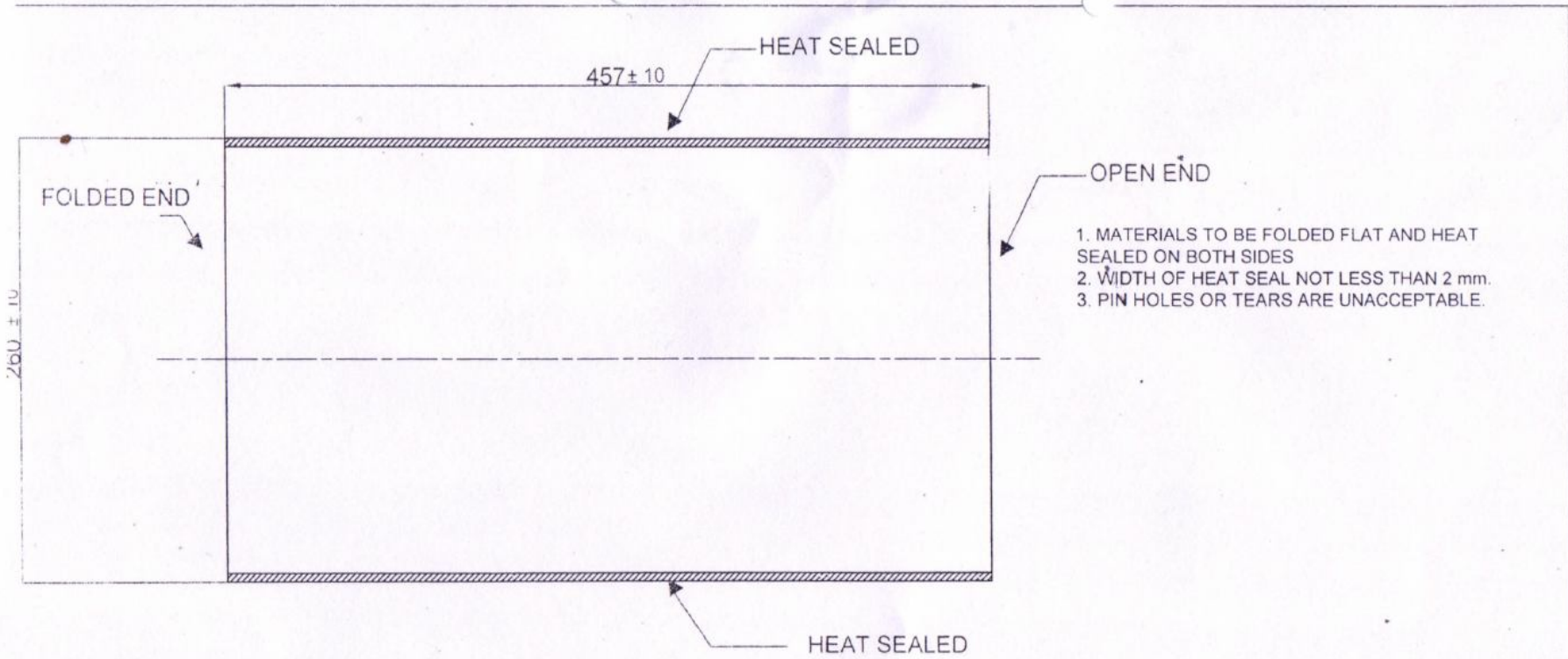
W

(02/04)

2.0 RAW MATERIALS

All raw materials used in the manufacture of **Plastic Film Bags and Sleeve** to be tested in NABL Accredited Laboratory. The firm will submit test reports for the raw materials used at the time of inspection of components.

Note: GM/OFN reserves the right to inspect the raw materials at any stage of production if required.



1. MATERIALS TO BE FOLDED FLAT AND HEAT SEALED ON BOTH SIDES
2. WIDTH OF HEAT SEAL NOT LESS THAN 2 mm.
3. PIN HOLES OR TEARS ARE UNACCEPTABLE.

Dimensions in mm

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ORDNANCE FACTORY NALANDA, RAJGIR, DIST. NALANDA, BIHAR-803121			
COMPONENT : Plastic Film Bag for Charge M-91 & M-92			
	DATE	NAME	DRAWING NO.:
DRAWN	02/06	SM	OFN/BMCS/M-91/M-92/
CHECKED	02/06	SM	Plastic Film Bag
APPROVED	02/06	SM	
	REVISION:	SCALE: NTS	FORMAT:

(03/04)

OPEN END

190 ± 10

85 ± 10 FLAT
(∅ 54)

OPEN END

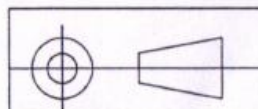
HEAT SEAL

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

COMPONENT : Plastic Film Sleeve FOR M-92



	DATE :	NAME :	DRAWING NO. :	REVISION :	SCALE : NTS	FORMAT :
DRAWN	20/6	[Signature]	OFN/BMCS/M-92/Plastic Film sleeve			
CHECKED	21/6	[Signature]				
APPROVED	22/6	[Signature]				

(ho/no)