		Specn No. ADRDE/SPECN/2002/58(a)		Revision no: 01
Prepared By: <i>Dev Kishan Bairwa</i> Dev Kishan Bairwa Sc 'B'	<i>P.K. Mallik</i> P.K. Mallik Sc 'D'	Reviewed By: <i>Gaurav Singh</i> Gaurav Singh Sc 'F', GD, TGTE	Issue: Dated:	Dated: Page 1 of 11

Government of India
Ministry of Defence

Specification
For

Tear Tape Nylon 36mm Undyed


Approved by

[Signature]
27/8/20

Sc 'G' & Associate Director




Aerial Delivery Research and Development Establishment
Ministry of Defence
Post Box No. 51
Station Road
Agra Cantt - 282 001

		Specn No. ADRDE/SPECN/2002/58(a)		Revision no: 01 Dated:
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RECORD OF AMENDMENTS


Amendment No.	Sub heading to which amendment pertains	Authority	Incorporated by Name & Rank in Block letters	Initials
1	<u>Appendix 'A', Column 6</u> For : Extension at break, %: 25-35 Read: Extension at break, %, min: 20	Director ADRDE	GD, TGTE	
2	<u>Appendix 'A', Column 9</u> For : Linear Density of twisted weft yarn in Tex (tolerance-3% to +8%): 16.7x9x4 Read: Linear Density of twisted weft yarn in Tex (tolerance: -5% to +10%): 16.7x9x3 or 150x3	Director ADRDE	GD, TGTE	
3	<u>Appendix 'A', Column 11</u> For : Picks per dm: 40 Read: Picks per dm: 40 (Suggested)	Director ADRDE	GD, TGTE	
4	<u>Appendix 'A', Column 12 & Column 13</u> For : Twist of warp and weft yarn(with tolerance of 15%): Initial - 200, Final -180 Read: Twist of warp and weft yarn (minimum): Single: Spin/Manufacturer's Twist Initial: 150 and Final: 100	Director ADRDE	GD, TGTE	

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0. FOREWORD


- 0.1 This specification is the revision of the specification ADRDE/SPECN/2002/58 based difficulties observed in recent supplies.
- 0.1 This specification has been prepared by a special committee, reviewed and approved by Group Director, Technology Group (Textile Engineering), ADRDE, Agra.
- 0.2 This specification would be used for manufacture inspection and procurement of tape Tear Nylon 36mm against defence requirements.
- 0.3 In case of any discrepancy between this specification and any sample or pattern, this specification shall be taken as correct.
- 0.4 Enquiries regarding this specification in relation to any contractual conditions should be addressed to the Inspection Authority named in tender or contract. Other enquiries will be referred to the issuing authority, Director, ADRDE, Agra.
- 0.5 Whenever a reference to any other specification occurs in this specification, it shall be taken as a reference to the latest version of that specification.
- 0.6 Copies of this specification can be obtained from:
- i. The Director,
A.D.R. & D.E.,
P.B. No. 51, Station Road,
Agra Cantt. - 282 001
 - ii. Concerned Inspectors and Inspection Authority.
- 0.7 IS specifications quoted in this specification may be obtained directly from B.I.S., Manak Bhawan, 9, Bahadur Shah Zafar Marg, New Delhi - 110 002 or its offices located in the country.

1. SCOPE

- 1.1 This specification covers the requirement of woven Tape Tear Nylon 36mm used in the manufacture of parachutes and other miscellaneous Aerial Delivery Equipments.

2. RELATED SPECIFICATIONS

- 2.1 Reference is made in this specification to:
- i. IS:2 Rules for rounding off numerical values.
 - ii. IS:6359 Methods for conditioning of textiles.
 - iii. IS:1954 Methods for determination of length and width of fabrics
 - iv. IS:7702 Method for determination of thickness of woven and knitted fabrics.
 - v. IS:1963 Method for determination of threads per unit length in woven fabrics.
 - vi. ADRDE/
SPECN/1980
/4(Appendix 'A') Method for determination of weight per meter.
 - vii. IS:1969 Methods for determination of breaking load and elongation at break of woven textile fabrics.
 - viii. ADRDE/
SPECN/1980
/4(Appendix 'B') Method for determination of tearing load.
 - ix. IS: 832 Method for determination of twist in yarn.
 - x. IS:1390 Method for determination of pH value of aqueous extracts of Textiles (cold method).
 - xi. IS:7151 Specification for corrugated fibre board boxes for Para dropping of supplies.
 - xii. IS:9738 Polythene bags.

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2.2 All specifications referred to in this specification for any tender or contract, shall mean the current edition on the date of such tender or contract.

3. REFERENCE STANDARD

3.1 The standard of the tapes, held by ADRDE, Agra Cantt, shall constitute the reference standard as regards any particulars of properties not noted/defined in this specification.

4. MATERIAL

4.1 The basic material shall be Nylon 6 or Nylon 66, suitably twisted as per Appendix 'A' to meet the requirement stipulated at clause 7. One spool of about 200 metre of the basic yarn material along with its test results should be supplied by the firm for testing/approval before starting the production of Advance sample (Ref. Clause 5.2)

5. MANUFACTURE

5.1 Nylon yarn used in the manufacture of the tape shall be of standard manufactures' product that will ensure the compliance of the tape with the requirement of this standard.

5.2 The tear tapes shall be evenly woven under suitable tension. The edges of tapes shall be firm and regular. The tension given to the yarn during weaving shall be intimated along with the processing/manufacturing details. A piece of five metre sample along with the test results shall be forwarded as an advance sample for approval.

5.3 The tapes shall not be more than one year old from the date of manufacture to the date of delivery. A certificate to this effect shall be provided by the manufacturer/contractor at the time of delivery.

6. FINISH

6.1 The tapes shall have minimum weaving defects. The tape when laid on a flat even surface shall be in a straight line without application of any tension. For detail classification of defects, Appendix 'B' of this specification may be consulted.

7. REQUIREMENTS

7.1 The tapes shall conform to the particulars given in Appendix 'A', when tested in accordance with the methods mentioned in Related Specifications under clause 2

7.2 pH Value : pH value of the finished tape shall be within the range or 5.5 to 8.5, when tested as per the relevant method.

7.3 Melting Point: The melting point of nylon yarn used in the manufacture of the tapes shall be 215±5°C or 250±5°C approx. in the case of nylon 6 or nylon 66 respectively

7.4 Sealed Sample: If, in order to illustrate or specify the un-measurable characteristics like general appearance, feel, etc of the tapes, sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.


7.4.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

8. MARKING

8.1 Each piece, prior to being offered for inspection, shall legibly be marked by the supplier with his name, initials or recognised trade mark, the year of manufacture, brief nomenclature, DS Cat. number of the store and length of the piece along with the number of flags contained in the piece.

9. QUALITY

9.1 On examination of sample taken from any portion of consignment, shall show that the tape conforms to the requirements of clause 7 above.


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10. PRE-INSEPCION OF STORES/CONSIGNMNET

- 10.1 Manufacturers/contractors must satisfy themselves that the stores are in accordance with the terms of the contract and fully conform to the required specification by carrying out a thorough pre-inspection of each lot before actually tendering the same for inspection to the inspecting officer nominated under the terms of the contract. A declaration by the contractor that necessary pre-inspection has been carried out on the stores tendered, will be submitted along with the challan. The declaration will also indicate the method followed in carrying out pre-inspection showing the features checked/tested and will have the test certificate attached to the challan/declaration.
- 10.2 If the Inspecting officer finds that pre-inspection of the consignment as required above has not been carried out, the consignment is liable for rejection.

11. SAMPLING

- 11.1 The manufacturer/supplier shall tender stores duly numbered and arranged in such a way that all the units are easily accessible to the Inspector.
- 11.2 The samples shall be drawn lot wise for carrying out tests specified in this specification. Unless otherwise agreed to between the buyer and the seller, the lot shall be defined under respective sampling plans as detailed below. The tape shall be in continuous length without joints of not less than 100 m or its multiple or as agreed between the buyer and the seller.
However, shorter cuts may be allowed in accordance with the following schedule or as agreed between the buyer and the seller:-
- 90 % of the total supply in length of 100 m
 - 10 % of the total supply in length of 50 m or above
 - 5% of the total supply in length of 30m or above
- 11.3 Sampling Plan 'A'
- 11.3.1 Lot - The total length of the tape manufactured from same type of yarn purchased from the same supplier/manufacturer and of same weave and finish, delivered to a buyer against one dispatch note shall constitute a lot.
- 11.3.2 Each roll of the lot shall be measured for its length
- 11.3.3 One sample of three metre length and of full width shall be drawn from each roll of the lot for carrying out the tear load.
- 11.4 Sampling Plan 'B'
- 11.4.1 Lot - All the rolls of tape manufactured from same type of yarn purchased from the same supplier/manufacturer and of same weave and finish, delivered to a buyer against one dispatch note shall constitute a lot.
- 11.4.2 Five samples or 10 % of the lot, whichever is more, shall be drawn for the following tests. Each sample shall be of three-metre length and of full width:
- a) Width
 - b) Thickness
 - c) Mass
 - d) Breaking Load & extension at break
- 11.5 Sampling Plan 'C'
- 11.5.1 Lot - The quantity of tape manufactured from the same type of yarn purchased from the same supplier/manufacturer and of the same weave and finish, delivered to a buyer against one dispatch note shall constitute a lot
- 11.5.2 Two samples or 2 % of the lot, whichever is more, should be drawn for the following tests; each sample shall be two metres length and of full width.
- a) Weave pattern – As per attached.
 - b) Total number of ends in full width

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- c) No. of threads/dm (weft)
- d) Linear density of yarn
- e) pH value
- f) Twist of yarn
- g) Melting point of yarn

12. CRITERIA FOR CONFORMITY

- 12.1 All the sample units drawn as per clause 11.2 above, shall be tested/examined to the relevant requirement/specification. The lot shall be considered to be in conformity if the requirements given in clause 7 are satisfied.

13. INSPECTION

- 13.1 If, on examination, 20 percent of those examined, are found not to conform to this specification in any respect, the whole consignment may be rejected.

14. WARRANTY

- 14.1 The stores supplied, shall be deemed to bear a warranty of the contractor against defective material, poor workmanship and performance for a period of twelve months from the date of receipt of the stores at consignee's depot.
- 14.2 If, during the period, the stores supplied are found by the consignee to be defective, the same shall be replaced immediately with serviceable stores by the contractor at site, free of any charge or cost.

15. PACKAGING


- 15.1 Each roll/piece shall be wrapped with polythene bag as per IS: 9738 and secured by line cotton (0.32 cm) to form a unit pack. Suitable number of such unit packs shall then be wrapped with paper craft wrapping and placed in corrugated fibre-board box as per IS: 7151 of suitable size provided with line waterproof bag. The gross mass of the box shall not exceed 40 kg. The empty spaces if any shall be filled in with cushioning material to prevent any movement of the contents inside the corrugated fibre board box and the top lid of box shall be properly fixed with adhesive tape. The box packing shall be made secured by fastening with suitable tapes/cords.
- 15.2 Packing material used, should be approved by Inspecting Officer. If ordered for delivery to a local inspection depot, the store shall be delivered in the same fashion as stated above in Cl no. 15.1. After inspection, the accepted supplies shall be packed by the inspection depot concerned as indicated in para. 15.1 above.
- 15.3 Before dispatch, each box of corrugated fibre board packing shall be legibly and indelibly marked, showing following details:
- a) Nomenclature and D S Cat number.
 - b) Quantity packed in each corrugated fibre board box.
 - c) Serial no. of the corrugated fibre board box.
 - d) Month and year of packing.
 - e) Name and trade mark of the manufacturer.
 - f) Gross mass of each corrugated fibre board box in kg.
 - g) Name and address of the consignee.
 - h) Inspection Note number and date.

16. DEFENCE STORES CATALOGUE NUMBER

- 16.1 Not yet allotted.

17. SUGGESTION FOR IMPROVEMENT


- 17.1 Any suggestion for improvement of this document may be forwarded to the Director, ADRDE, Agra Cantt - 282 001.

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APPENDIX 'A'

Roll Length, min or as agreed	Width,	Thickness, under 200g/cm ² pressure, max	Mass, max	Breaking Load, min	Extension at break, min	Tear Load	Linear Density of twisted yarn (with a tolerance of -5 to +10 %), Tex		Total no. of ends, min	Picks per dm (Suggested)	Twist of yarn, TPM, min	
m	mm	mm	g/m	kgf	%	Kgf	Warp	Weft			Warp	Weft
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)
100	36±1	2.2	34	600	20	35 - 65	16.7x9x4	16.7x9x3	32	40	Single: Spin / Manufacturer's Twist Initial: 150 Final: 100	Single: Spin / Manufacturer's Twist Initial: 150 Final: 100

Note: Weave of the tape shall be as per APPENDIX 'C'

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APPENDIX 'B'

CLASSIFICATION OF DEFECTS

1. The following defects found in metre-by-metre examination are classified as major/minor.

a) **Major defects detectable visually during inspection**

Defects	Description	Major
Abrasion	Abrasion resulting in broken filaments, rupture of individual yarn and distortion in the orientation of threads	X
Broken and missing threads (ends/picks)	Two or more, regardless of length	X
Coarse or light filling bar	Extending for more than 13 mm in the length direction or more than 50 % of width resulting in visible differences in thickness	X
Floats skips	Single float or skip over 1 cm or more in length	X
	Contiguous float, the sequence of which measures 0.5 cm or more in length	X
	Any multiple float 5 mm square or more	X
Jerked-In filling	Any jerked-in filling occurring 4 times within 25 cm	X
Edge cut, torn or frayed	Complete separation of one or more yarns within 3 mm of the edge or at any adjoining point	X
Mispick or double pick	Two or more additional picks across full width	X
Slack end	Two or more for a minimum of 13 mm in length	X
Loose, Irregular and uneven Selvedges	Clearly noticeable waviness along selvedge edge when no tension is on selvedge	X
Selvedge tight	Any clearly noticeable roll of edge or edges when tension is released.	X
Spot, stain	Single thread 40 cm or more in length	X
	Double threads 20 cm or more in length	X
	Over two threads 12 cm or more in length or clearly noticeable area more than 6 mm ² , whichever is greater	X
Slubs or strip back*	More than 5 over 1 cm in length	X
	Two to five over 2 cm in length	X
	One over 5 cm in length	X
Smash	Any smash	X
Wrong draw	Extending for more than 25 cm	X


* A strip back in defined as a broken filament (s) wrapped around the remaining yarns forming an enlarged area resembling a slub.

b) **Minor defects detectable visually during inspection**

The classification of the defects defined under clause a) above, may be considered minor, if it exists to a lesser degree than that given under the column 'Description'.

2. **Acceptance of rolls with defects**

2.1 Each roll shall be visually examined for defects as described in a) and b) above. No roll shall contain more than 5 major defects per 100 m or 18 minor defects per 100 m. For this purpose, all the rolls shall be visually examined metre by metre and the defects classified in accordance with a) and b) of

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Appendix 'B'. The unit of product for examination, shall be one linear metre. For each unit of product, the defects shall be counted as follow:

- i) One major defect and one minor defect shall be counted as one major defect.
- ii) Three or more minor defects shall be counted as one major defect.
- iii) A continuous major defect shall be counted as one major defect for each unit of product or fraction thereof in which it occurs.

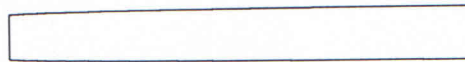
2.2 Each major defect shall be flagged by a red string sewn in the selvedge. Each minor defect shall be flagged by a blue string sewn in the selvedge. Three or more minor defects occurring per linear metre shall be flagged by a red string sewn in the selvedge.

2.3 An allowance of 50 cm shall be claimed for each major defect flagged except for continuous defects, which shall be given an allowance of one metre for each metre in which it occurs. An allowance of 16 cm shall be claimed for each minor defect flagged.

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APPENDIX 'C'

TEAR TAPE NYLON 36 MM U/D

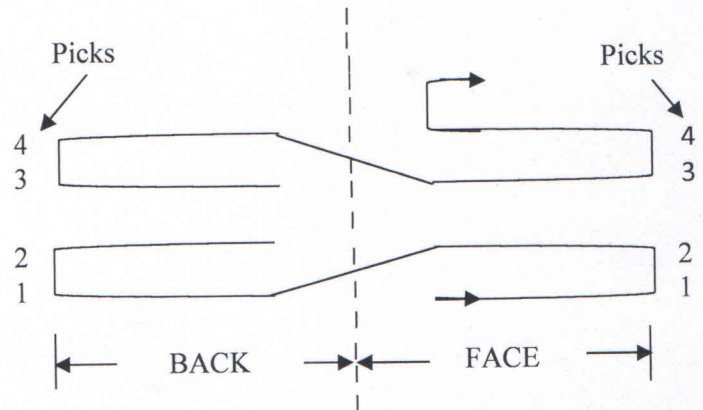


ONE SIDE 2-PLY NARROW FABRIC

	← × 1 →		← × 7 →					
4 F			X				X	
3 F	X				X			
4 B	/		/	O	/		/	O
3 B	/	O	/		/	O	/	
2 B	/		/	O	/		/	O
1 B	/	O	/		/	O	/	
2 F			X				X	
1 F	X				X			
	F	B	F	B	F	B	F	B



CENTRE OF TEAR TAPE



ABOVE WEAVE DESIGN REPRESENTS REPEAT
OF 8 PICKS & TOTAL ENDS IN FULL WIDTH
(TOTAL NO. OF ENDS – 32)

KEY TO MARKS –

- X – FACE END UP ON FACE PICK
- O – BASE END UP ON BASE PICK
- / – FACE END UP ON BASE PICK

NOTE - TEAR TAPE IS FORMED BY OPENING – UP OF THIS 2 – PLY FABRIC.