

8. IGNITER BAG FOR M-91 & M-92

1. ACCEPTANCE CRITERIA

1.1 CHEMICAL COMPOSITION

Sl. No.	Ingredients / Components		Composition (%) / Requirement
Cloth			
1	Acrylic cloth	Material	Acrylic Igniter woven from acrylic yarn spun from acrylic fibres containing 85% minimum polyacrylonitrile, no mono polymer shall be used.
		Colour	In all instances the cloth shall be dyed scarlet. The scarlet dye shall produce a colour closely equivalent to red colour no. 11105 Federal Standard no.595
Polyester Thread			
1	Polyester Thread	Material	Polyethylene Glycol terephthalate
		Colour	Blue Dye - Olive Drab, Shade S-1, Related cable no C.A 66022 (Combination of Disperse Blue 27, Disperse Red 59, Disperse Yellow 23)
Silk Ribbon			
1	Viscose Rayon		100%

1.2 PHYSICAL PROPERTIES

Sl. No.	Test Parameters		Specified Value
Acrylic Cloth			
1	Weight	(Oz. per sq. yd)	5.25 - 5.75
2	Breaking Strength	(lb per inch)	
		Warp	100 (Min)
		Fill	100 (Min)
3	Thread Count	(Threads per inch)	
		Warp	34 - 45
		Fill	35 - 45
Polyester Thread for Sewing			
1	Letter Size		E
2	Plies (Nos)		3
3	Final Twist (tpi)		6.0 (min.)
4	Length per pound (yards)		5700 (min.)
5	Breaking Strength (lbs)		8.0 (min.)
6	Elongation (%)		20 (max.)
Silk Ribbon			
1	Weave		Plain
2	Breaking Strength (N/5 cm)	WARP	300 (min)
		WEFT	220 (min)
3	Stretch (%)		10 (max.)
4	Slippage Value		60 (min.)
5	Thread count /cm (Warp & Weft)		16 (min.)
6	Mass (g/m ²)		75-150
Visual Inspection			
1	Abrasion mark or weak spot	Any open place or any area visibly thinner or weaker than surroundings normal cloth.	
2	Broken or missing yarn	Any cloth	

(02/06)

3	Cut, Hole, Tear	Any size
4	Floats or skips	Two or more, more than 5 mm in combined warp and weft direction or single floating over 25 mm in length
5	Knots	Any knot extending above surface of cloth or with untrimmed tails extending from cloth
6	Smash	Any
7	Slubs, jerked in weft, slough off or course yarn	Three or more times diameter of normal yarn
8	Overall appearance	Spots, stains or streaks extending for 25 mm or more in combined direction
9	Wrong draw	Two or more ends 12 mm or more in length or single, 225 mm or more in length.
10	Wrinkle or Crease	Hard embedded
11	Objectionable odour	Any
12	Uneven weaving	Any

1.3 DIMENSIONS OF IGNITER BAG

SI No	Characteristics	Specification Limit (mm)	
		M-91	M-92
1	Length	180±5.0	180±5.0
2	Width	30±2.0	50±2.0
3	Seam Width stitched with Blue Thread	6±1.0	6±1.0
4	Silk Ribbon Length	195±5.0	195±5.0
5	Silk Ribbon Width	8±2.0	8±2.0

Refer Drawing No: OFN/BMCS/M-91/IGNITER BAG & OFN/BMCS/M-92/IGNITER BAG

1.4 Inspecting Authority: GM/ O F Nalanda

1.5 Accepting Authority GM/O F Nalanda

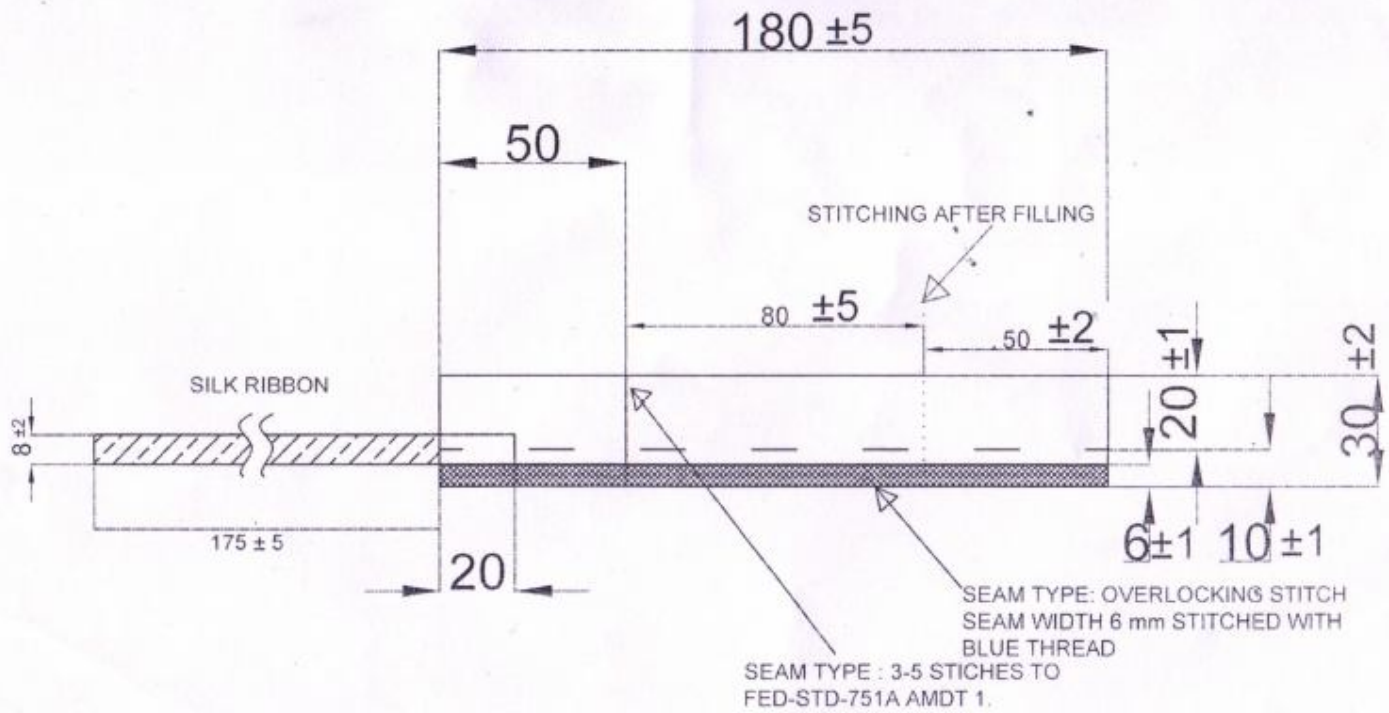
2.0 RAW MATERIAL INSPECTION

All raw materials used in the manufacture of **Igniter Bag** 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.

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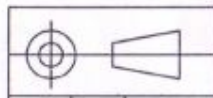
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All dimension is in mm

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

COMPONENT : Igniter Bag for M-91



	DATE	NAME
DRAWN	20/6	DL
CHECKED	21/6	SM
APPROVED	23/6	IL

DRAWING NO. : OFN/SMCS/M-91/Igniter Bag	REVISION :	SCALE :	FORMAT :
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the information contain in this drawing is to be used for official purposes only
and shall not be reproduced or transmitted in any form or by any means
disclosed to any third party without prior permission from OFN. This shall be
returned to OFN when no longer contractually required.

(40/50)