


INTER PLANT STANDARD - STEEL INDUSTRY		
 IPSS	SPECIFICATION FOR HDPE BAGS	IPSS:3-01-010-98
	Corresponding IS does not exist	

0. FOREWORD

- 0.1 This Inter Plant Standards has been prepared by Sub-committee on A & X Category Items, IPSS 3:1/5 and was approved by the Standards Committee on Materials Management, IPSS 3:1. This was adopted as an IPSS Standards in August 1998.
- 0.2 HDPE (High Density Polyethylene) Bags for packaging of Ammonium Sulphate, Napthalene, Ferrous Sulphate, Pitch and Ammonium Nitrates belong to A & X Category items and thus attracted the attention of SAIL Management for effecting the necessary variety reduction for cost saving. It was observed that different plants in SAIL were purchasing HDPE Bags having nearly same size and material specification but at a much higher price as compared to another plant. After an extensive data collection and their analysis, it came to light that Rourkela Steel Plant (RSP) were purchasing HDPE Bags of optimum quality and at lower price. This aspect has been kept into consideration while preparing this standard.

1. SCOPE

- 1.1 This Inter Plant Standard covers the requirements of HDPE Bags made from tubular fabric (woven in circular looms) for packaging of different by-products from steel plants.

2. DEFINITIONS

- 2.1 Denier - Weight of 9000 m length of fibre in gm.
- 2.2 Mesh - No. of threads per inch, in the fabric.

3. REQUIREMENTS

- 3.1 The requirements of different characteristics of HDPE Bags shall be as per Table-1.
- 3.2 The material for the manufacture of bags shall generally conform to the material specified in IS:9755-1989 'High Density Polyethylene (HDPE) woven sacks for packaging fertilizers (second revision)' and shall be virgin raw material of white colour and flat woven.
- 3.3 HDPE tape or nylon thread shall be used for stitching the bag having at least 20% higher denier than the HDPE flat thread used for the manufacture of the bag. Stitching shall be in two rows separated by a distance of 6 mm by double folding (so that the stitching thread passes through six layers of the fabric) with the fold of 25 mm.
- 3.4 The bags shall be supplied in bales of 500 or 1000 bags.
- 3.5 The bags shall have inside lamination with 25 micron thick Low Density Polyethylene (LDPE) film.

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TABLE - 1 REQUIREMENTS OF HDPE BAGS FOR PACKAGING

(Clause 3.1)

Characteristics	For Packaging of					
	Napthalene (Hot pressed)	Napthalene (flakes)	Ammonium Sulphate	Ammonium Nitrate (lumps)	Ferrous Sulphate	Pitch, Granu- lated
Internal size of Bag (mm) Tolerance +3%, -0%	560x920	700x1120	560x920	540x1040	560x920	610x920
Mesh Tolerance +5%, -0%	10x10	10x10	10x10	10x10	10x10	10x10
Denier (Min)	1000	1000	1000	1000	1000	1000
Capacity (Kg)	50	50	50	50	50	50
Colour for Printing	Green	Green	Black	Bright, as per purchaser's choice (Acid resistant paint)	Dark Green	As per purcha- ser's choice.