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D3312



HIGH DENSITY POLYTHENE CLOTH LAMINATED WITH KRAFT PAPER ON BOTH SIDES

**SPEC. No. D 3312
ISSUE No. 5
15 - 03 - 2005**

STANDARD

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1. SCOPE

This specification covers the construction & requirements of high density polythene cloth lined water proof paper intended for packing heavy Telecommunication & similar equipments.

2. CONSTRUCTION

The material shall be manufactured by lining one ply of high density polythene cloth (HDP), with kraft paper single width on either side using bitumen. The bonding shall be adherent & kraft paper shall not come off easily and satisfy the Test as per clause 3.3.2

3. REQUIREMENTS

3.1 WEIGHT OF MATERIAL

The weight of the HDP cloth laminated with kraft paper (finished material) shall not be less than 250 g/m².

Note: weight of the roll also to be checked which will indicate the quality & length also (112 cm x 100 metre roll shall weigh 28 kg minimum without the core if any). Any other size calculation to be made.

3.2 KRAFT PAPER

The weight of the kraft paper used shall be 50 to 70 g / m².

3.3 BITUMEN

The Bitumen used shall have a softening point of not less than 80°C (only for guidance)

3.3.1 Test for Bitumen :

A sample piece of 100 x 100 mm shall be subjected to a temperature of 60°C for half an hour in an oven & after this test the bitumen shall not ooze out. (the temperature of 60°C has been fixed on the basis that at no place the tropical temperature would go beyond this limit).

3.3.2. BONDING TEST

The method of test for bonding shall be as follows :

a) A sample of HDP cloth laminated with kraft paper (finished material) of 150 mm width (cut in the middle) & length of minimum one meter shall be taken. Two sides of the material shall be marked as "A" & "B".

b) Full length of specimen shall be rolled on a mandrel of 100 mm dia. approx., so that the face "A" shall be in contact with mandrel & then it shall be unrolled.

c) In the same way with face "B" in contact with mandrel, the specimen shall be rolled fully on to it & then it shall be unrolled.

d) The operations (b) & (c) constitute one cycle & this cycle shall be repeated for 4 times.

e) The specimen after the above test shall be now visually examined. The adhesion of the kraft paper shall be considered as not satisfactory if it comes off on its own during the above test cycle.

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3.4 HDP CLOTH

The HDP Cloth shall be woven from high density polythene film with 15-20 mesh measured along the length & 8-10 mesh measured along the width. Alternatively mesh 10 x 10 or 12 x 12 (per 25mm width) may also be used & the fabric shall be closely woven. The weight of the cloth shall be 80-90g /m².

3.5 FINISH

The finished cloth shall be smooth (without any wrinkles), clean & free from any stains or spots of bitumen.

4. DIMENSION

The width & length of the roll supplied shall be as per the order. Unless otherwise specified in the purchase order, the material shall be supplied in rolls having width of 112 cm & length of 100 metre. A tolerance of $\pm 2\%$ shall be allowed both on length & width.

5. TYPE APPROVAL

5.1 SAMPLE FOR TYPE APPROVAL

3 Pieces of free samples size 112cm x 1 metre: 1 piece of kraft paper, 1 piece of HDP cloth & 1 piece of finished material.

5.2 TYPE APPROVAL TESTS

1	Bonding Test	(CI 3.3.2)
2	Weight of material	(CI 3.1)
3	Weight of kraft paper	(CI 3.2)
4	Bitumen Test	(CI 3.3.1)
5	Weight of HDP cloth, material & mesh size	(CI 3.4)
6	Finish	(CI 3.5)

6. BATCH ACCEPTANCE

7. SAMPLING PLAN

The sampling plan as given in quality system documents pertaining to the units shall be followed for batch acceptance.

8. BATCH ACCEPTANCE TESTS

1	Bonding Test	(CI 3.3.2)
2	Weight of material	(CI 3.1)
3	Weight of HDP cloth, material & mesh size	(CI 3.4)
4	Finish	(CI 3.5)
5	Weight of roll	(CI 3.1)
6	Bitumen Test	(CI 3.3.1)
7	Marking	(CI 10)
8	Dimension	(CI 4)



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Note: All rolls to be checked for weight (Cl 3.1 Note) & Marking (Cl 10.2) before accepting in stores.

9. ORDERING CODE

The material shall be designated as per the 15 digit code **STDS-DRX**
Eg., DRR2D331200M(N1).
(For 1120mm = MO & For 100000 mm = N 1)

10. PACKING & MARKING

10.1 PACKING

The material (rolls) shall be suitably packed to prevent damage during transit, handling & storage.

10.2 MARKING

The rolls shall be legibly marked with the information:

- (a) Order Code.
- (b) Batch No. and date of manufacture
- (c) Manufacture's name, address, and trade mark
- (d) Quantity in mts/wt in kgs.
- (e) Any other relevant details.

11. REJECTION OF SUPPLIES

M/s ITI LIMITED., has the right to reject any material which does not conform to the aforesaid conditions and to return any material which subsequently proves faulty in manufacture / usage.

12. DEPARTURE FROM SPECIFICATION

Any departure from this specification shall be agreed to in writing by the Company before Execution of the order by the supplier.

13. ACCEPTANCE

The acceptance of this specification without any comment shall be taken to indicate that the supplier agrees to comply with the conditions herein contained.

HISTORY: Specification revised & Issue Advanced, 15 digit codification incorporated.

PREPARED

CHECKED

APPROVED

CEQ(D)

DGM(QV)

Ref :

Spec : D3312

Issue : 4

Dated: 23 July 1998

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