

	CORPORATE PURCHASING SPECIFICATION			AA 514 26		
				Rev. No. 01		
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<u>POLYETHYLENE AIR BUBBLE / FILM</u>						
1.0 GENERAL:						
This specification governs the quality of polyethylene Air Bubble Film made of two layers of polyethylene sheathing with air bubbles entrapped with a uniform pattern to provide cushioning effect to the contents packed or wrapped in it. The film shall be chemically neutral and non-reactive with chemicals and alkalies at room temperature. The film shall be free from objectionable odour.						
2.0 APPLICATION:						
Used for packing and allied purposes.						
3.0 COMPLIANCE WITH NATIONAL STANDARDS:						
The material shall comply with the requirements of the following National Standard and also meet the requirements of this specification.						
IS: 12787-1989: Polyethylene Air Bubble films.						
Reaffirmed: 2004						
4.0 DIMENSIONS AND TOLERANCES:						
4.1 Sizes:						
Thickness, Width and Length shall be as stated on our order.						
4.2 Thickness of Composite Film:						
150 Microns Min.						
4.3 Width and tolerance:						
4.3.1 Preferred width:						
1500 mm.						
4.3.2 Tolerance on width: ± 20 mm						
4.4 Buble Diameter:						
10 ± 1 mm						
Revisions: Cl. 9. 12 of MOM of WG of T&PM				APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE- WG (T&PM)		
Rev. No. 1	Amd. No.	Reaffirmed	Prepared BHOPAL	Issued Corp. R&D	Dt. of 1st Issue 1st October 1995	
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4.4.1 No. of Bubbles:
7000 Nos/m² Minimum.

5.0 APPEARANCE AND FINISH:
The film shall be uniform in colour, And shall be free from pinholes, undispersed raw material, streaks and foreign particles and blisters. The edge shall be free of nicks and cuts visible to unaided eye.

6.0 COLOUR:
Unless otherwise specified, the film shall be supplied in Natural Colour (essentially - colourless). Any other colour can also be ordered as & when required.

7.0 ODOUR:
The film shall be free from any objectionable odour.

8.0 TEST SAMPLES:
One square metre (1 sq.m) of ordered thickness shall be supplied for testing & approval purpose.

9. PROPERTIES:
When tested in accordance with the relevant methods of IS : 1060 (Part 1) and IS : 2508, the material shall show the following properties:

9.1 Physical Properties

9.1.1 Yield at 27 ± 1° C:
100 - 185 gm/m²

9.2 Mechanical properties:

9.2.1 Bursting Strength:
2500 kg/m²

9.2.2 Elongation at Break:
120% Min.

**10.0 TEST CERTIFICATES:**

Three copies of test certificates shall be supplied unless otherwise stated on the order.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

AA 514 26: Polyethylene Air Bubble film.

Rev. 01

BHEL Order No.

Batch/Lot No.

Test results of clauses 9.

11.0 PACKING AND MARKING:

To be supplied in rolls suitably packed to prevent damage during transit and storage. Each roll shall be tightly wound on centre bobbin and wrapped with thick packing paper properly tied with cotton lace.

Each roll shall be marked legibly with the following information:

AA 514 26

BHEL Order No.

Manufacturer's name and grade

Batch No. /Lot No.

Thickness, Width and Length

Net weight of the roll.