



## CORPORATE PURCHASING SPECIFICATION

AA 51408

Rev. No. 02

PREFACE SHEET

### POLYTHYLENE FILM – LOW DENSITY

**FOR INTERNAL USE ONLY**  
**REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS**

#### Equivalent/Comparable Standards:

1. Indian : IS:2508-1984(Reaffirmed 2003) ?  
 Gr:001

#### Suggested/Probable suppliers and grades: ?

1. Jagdamba Tools Bhopal
2. ITW India, Hyderabad
3. Shri Balajee Entreprises, Bhopal
4. The Supreme Industries ltd

#### User Plant References:

- |                  |            |
|------------------|------------|
| 1. HEEP, HARDWAR | : 0507-601 |
| 2. BHOPAL        | : BP22980  |
| 3. HYDERABAD     | : HY 78476 |
| 4. TRICHY        | : IS 2508  |

#### Revisions :

CL 8.5 OF 8<sup>th</sup> MOM WG -T&PM

**APPROVED :**  
**INTERPLANT STANDARDISATION**  
**COMMITTEE –WG - T&PM**

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### POLYETHELENE FILM - LOW DENSITY

#### 1.0 GENERAL:

This specification governs the quality requirement of flexible (non-rigid), low density polyethylene film suitable for use at temperatures -45°C to 90°C

#### 2.0 APPLICATION:

Used for packing and allied purposes

Note: When the film is intended for use in fumigation purpose, film thickness above 175 microns shall be used

#### 3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply with the requirements of following National standard and also meet the requirements of this specification

IS: 2508 - 1984 (Re affirmed 2003) Low density polyethylene film Gr.001

#### 4.0 DIMENSIONS AND TOLERANCES:

4.1 Sizes: Thickness, width and length shall be stated on our order.

#### 4.2 Preferred Thickness and tolerances:

100, 125, 150, 175, & 200 micron with a tolerance of  $\pm 20\%$

#### 4.3 Preferred width:

900, 1000, 1500, 2000, 2500 & 3000 mm

Width, mm		Tolerances $\pm$ mm
Above	Upto and incl	
900	1250	8
1250	2500	20
2500	3000	40

Revisions :

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**5.0 MANUFACTURE:**

The low density polyethylene shall be manufactured from compound having polyethylene resin with additives to impart the additional qualities to the film such as slip, antioxidant, low water permeability, dust protection, transparency etc.

“BHEL” emblem of size A40 shall be embossed at an interval of 500mm along the length of film and 250 mm along it’s width. The colour of emblem shall be Air Craft Blue (Shade No.108) as per IS:5.

**6.0 APPEARANCE AND FINISH:**

The film shall be uniform in colour, texture and finish. And also shall be free from pinholes, undispersed raw material, streaks, foreign particles holes, and tears or blisters. The edge shall be free of nicks and cuts when seen with unaided eye.

**7.0 COLOUR:**

Unless otherwise specified, the film shall be supplied in natural colour (essentially colourless). Black colour or any other colour can also be ordered.

**7.0 ODOUR:**

The film shall be free from any objectionable odour.

**8.0 TEST METHOD:**

Unless otherwise specified, the tests shall be conducted in accordance with the relevant methods of IS:2508.

**9.0 TEST SAMPLES:**

One square metre (1sq.m) of ordered thickness shall be supplied for testing purpose.

**10.0 PHYSICAL PROPERTIES**

Density at 27°C

Natural and colour other than Black	: 0.912 to 0.923 g/cc	?
Black colour	: 0.922 to 0.937g/cc	?

**11.0 MECHANICAL PROPERTIES:****11.1 Tensile Strength at Break:**

Direction	N/mm <sup>2</sup> Min.	
Length wise/Machine (MD)	11.77	?
Cross wise/Cross Machine (XD)	8.33	?

**11.2 Elongation at Break (Min.)**

Machine direction	200%
Cross-Machine Direction	400%

**12.0 INSPECTION AT SUPPLIERS WORKS:**

Whenever specified, tests and inspection are to be conducted in presence of BHEL's Representative.

BHEL representative shall have free access at all times while the work on contract is being Performed to all parts of manufacturer's works. The manufacturer shall offer BHEL's representative all reasonable facilities without charge to satisfy latter that the material is being furnished in accordance with this specification. The manufacturer shall prepare and provide necessary test specimen for testing to be carried out at his premises. If facility do not exist at his premises works, the manufacturer shall make necessary arrangements for carrying out the prescribed tests elsewhere. The manufacturer shall notify BHEL representative in advance about Readiness of the material for inspection and testing. BHEL reserves the right to test the material at BHEL's works and the final acceptance of material shall be based on these tests results.

**13.0 TEST CERTIFICATES:**

Unless otherwise specified, three copies of test certificates shall be supplied with each consignment, indicating the following information:

- AA 51408 (Rev 02): Polyethylene film low density
- BHEL Order No.
- Batch / Lot No.
- Results of dimensional inspection
- Test results of clause 10 and 11

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

#### **14.0 PACKING & 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 following information

Each drum shall bear the following information :

- \* AA51408
- \* BHEL order No.
- \* Manufacturer's name and grade
- Batch / Lot No.
- Thickness
- Net Weight on Roll

#### **15.0 REJECTION AND REPLACEMENT :**

In the event of any film proving defective during the course of preparation, testing, subsequent use etc. such material shall be rejected notwithstanding any previous certification of satisfactory testing and/or inspection. The supplier shall undertake to replace the rejected film at his own cost and the rejected material shall be taken by supplier after fulfilling the commercial terms and conditions

#### **16.0 REFERRED STANDARDS: (Latest Publications Including Amendments) :**

- 1) IS: 5