

AUTOMATIC CRIMPIING MACHINE (FOR NORMAL STUN SHELL)

INPUT - SEMI FINISHED ASSEMBLED STUN SHELL BODY WITH CARTRIDGE CASE.

OD - 38.4 - 0.2 MM

HEIGHT - 209 MM.

OUTPUT - CRIMPED STUN SHELL (N) DEPTH OF CRIMPING 0.75 ±.25MM .

RATE - 1000 NOS/HOUR.

PROCESS:-

LOADING OF STUN SHELL (N) → CRIMPING OF SHELL (N) → UNLOADING OF SHELL (N).










- a) CRIMPING SHOULD BE AT SYMMETRICAL FOUR POINTS.
- b) CRIMPING POINTS SHOULD BE AT THE DISTANCE OF 181+1 MM (ADJUSTABLE UP TO ± 10 MM) FROM TOP OF SHELL.

QUALITATIVE REQUIREMENT:-

1)	ALL MOVING PARTS OF MACHINE SHOULD BE CORROSION RESISTANT, FLAME AND SPARK PROOF AND MADE OF ISI / CLASS APPROVED QUALITY MATERIAL.
2)	MACHINE SHOULD WORK PREFERABLY ON PNEUMATIC BASE.
3)	TUBES CONNECTING THE MACHINE TO PNEUMATIC MACHINE SHOULD BE OF REQUISITE DIMENSIONS AND ISI MAKE.
4)	MACHINE SHOULD HAVE ARRANGEMENT TO SAFE LOADING OF STUN SHELL (N).
5)	MACHINE SHOULD HAVE ARRANGEMENT TO SAFE UNLOADING AND STACK UP OF STUN SHELL(N) AFTER CRIMPING
6)	MACHINE SHOULD HAVE DIGITAL DISPLAY TO INDICATE FINISHED NO'S OF SHELLS.
7)	IN CASE OF MALFUNCTIONING, THE MACHINE SHOULD HAVE AUTOMATIC TRIPPING SYSTEM AND ALSO HAVE SOUND AND LIGHT INDICATION.

PO AD M-1 S M-2 B M-3 OL M-4 PSP Co-M-1 S Co-M-2 A Co-M-3 L Co-M-4 GN









8)	MACHINE WILL BE EARTHED TO DISCHARGE STATIC CHARGE.
9)	ALL EQUIPMENTS / COMPONENTS FITTED IN THE MACHINE SHOULD BE OF REPUTED BRAND AND OF ISO/ISI CERTIFIED COMPANY.
10)	MACHINE SHOULD OPERATE PREFERABLY ON PLC CONTROL OF IEC-61131 STANDARD.
11)	MACHINE SHOULD HAVE PROPER SAFEGUARDS FOR THE SAFETY OF OPERATOR.
12)	MACHINE SHOULD HAVE FACILITY OF DETECTION OF OMISSION AND MALFUNCTIONING AT ANY STAGES OF PROCESS AND SHOULD HAVE FACILITY TO SEPARATE THE REJECTED/ DEFECTIVE PRODUCTS.
13)	GENTLE HANDLING OF HARDWARE TO AVOID FRICTION AND HIT AT .22 CAP.
14)	MACHINE SHOULD BE ABLE TO OPERATE WITHIN OPERATING TEMPERATURE $25 \pm 10^{\circ}C$ AND OPERATING HUMIDITY $40 \pm 15\%$.
15)	ALL ELECTRIC WIRING AND ELECTRICAL COMPONENTS SHOULD BE PROPERLY CASED AND FLAME PROOF AND EASILY ACCESSIBLE FOR REPAIR AND MAINTENANCES.
16)	MACHINE SHOULD BE COMPACT TO SAVE SPACE AND EASY TO ACCESS FOR REPAIR AND MAINTENANCES.
17)	BASIC STRUCTURE OF MACHINE SHOULD BE MADE OF ISI / CLASS APPROVED QUALITY METAL, RESISTANT TO CORROSION / RUSTING AND FLAME.
18)	USER MANUAL WITH REQUIRED ILLUSTRATIONS TO BE PROVIDED WITH MACHINE.
19)	INSTRUCTION ON REPAIR & MAINTENANCE TO BE PROVIDED WITH MACHINE.
20)	RUNNING SPARE PARTS WITH ILLUSTRATED LIST SHOULD BE PROVIDED WITH MACHINE.
21)	OPERATIONAL TRAINING SHOULD BE ARRANGED FOR 1 WEEKS FOR MINIMUM 15 PERS.
22)	REPAIR AND MAINTENANCE TRAINING SHOULD BE ARRANGED FOR 1 WEEKS FOR MINIMUM 10 PERS.
23)	SPECIFIC GAUGES AND MAINTENANCE TOOLS SHOULD BE PROVIDED WITH MACHINE.

PO  M-1  M-2  M-3  M-4  Co-M-1  Co-M-2  Co-M-3  Co-M-4 

24) GUARANTEE / WARRANTY:-

- i) MACHINE SHOULD HAVE 2 YEARS GUARANTEE / WARRANTY AFTER COMMISSIONING.
- ii) PREVENTIVE MAINTENANCE ONCE IN 3 MONTH DURING GUARANTEE / WARRANTY PERIOD.
- iii) GUARANTEE/ WARRANTY WILL BE COMPREHENSIVE i.e INCLUSIVE OF SPARE PARTS.

25) AMC PERIOD SHOULD BE 05 YEARS AFTER EXPIRY OF GUARANTEE / WARRANTY PERIOD.









PO  M-1  M-2  M-3  M-4  Co-M-1  Co-M-2  Co-M-3  Co-M-4 

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SL NO	QUALITATIVE / REQUIREMENTS	METHODOLOGY	COMPLIED / NOT COMPLIED
1	ALL MOVING PARTS OF MACHINE SHOULD BE CORROSION RESISTANT, FLAME AND SPARK PROOF AND MADE OF ISI / CLASS APPROVED QUALITY MATERIAL.	The firm should submit national / International accredited Lab test report for this aspect	
2	MACHINE SHOULD WORK PREFERABLY ON PNEUMATIC BASE.	Physical Verification by BOOs	
3	TUBES CONNECTING THE MACHINE TO PNEUMATIC MACHINE SHOULD BE OF REQUISITE DIMENSIONS AND ISI MAKE.	Physical Verification by BOOs	
4	MACHINE SHOULD HAVE ARRANGEMENT TO SAFE LOADING OF STUN SHELL (N).	Physical Verification by BOOs	
5	MACHINE SHOULD HAVE ARRANGEMENT TO SAFE UNLOADING AND STACK UP OF STUN SHELL(N) AFTER CRIMPING	Physical Verification by BOOs	
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7	IN CASE OF MALFUNCTIONING, THE MACHINE SHOULD HAVE AUTOMATIC TRIPPING SYSTEM AND ALSO HAVE SOUND AND LIGHT INDICATION.	The firm should submit national / International accredited Lab test report for this aspect & Physical Verification by BOOs	
8	MACHINE WILL BE EARTHED TO DISCHARGE STATIC CHARGE.	Physical Verification by BOOs	
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PO [Signature] M-1 [Signature] M-2 [Signature] M-3 [Signature] M-4 [Signature] Co-M-1 [Signature] Co-M-2 [Signature] Co-M-3 [Signature] Co-M-4 [Signature]

13	GENTLE HANDLING OF HARDWARE TO AVOID FRICTION AND HIT AT .22 CAP.	Physical Verification by BOOs
14	MACHINE SHOULD BE ABLE TO OPERATE WITHIN OPERATING TEMPERATURE $25 \pm 10^{\circ}$ C AND OPERATING HUMIDITY 40 ± 15 %.	Physical Verification by BOOs
15	ALL ELECTRIC WIRING AND ELECTRICAL COMPONENTS SHOULD BE PROPERLY CASSED AND FLAME PROOF AND EASILY ACCESSIBLE FOR REPAIR AND MAINTENANCES.	The firm should submit national / International accredited Lab test report for this aspect & Physical Verification by BOOs
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