

CARTRIDGE CASE PUSH FIT MACHINE.

INPUT - PREPARED STUN SHELL BODY, CARTRIDGE CASE (N/E), SHELLAC VARNISH AND SPACER (N/E), PAPER STRIPE/SURGICAL TAPE, 1 MM HDPE RING

- a) **STUN SHELL BODY** OD 37.54 ± 0.2 MM
HEIGHT 186MM.
- b) **CARTRIDGE CASE (N)** OD(BASE RING) $43.3 \pm .20$ MM
OD(WITHOUT RING) $38.4 - 0.20$
ID $36.30 - .10$ MM
HEIGHT $45 \pm .20$ MM.
- c) **CARTRIDGE CASE (E)** OD(RING) $43.5 - .20$ MM
OD (WITH OUT RING) $38.4 - 0.20$
ID $36.30 - .10$ MM
HEIGHT 61.75 ± 0.20 MM.
- d) **SPACER (N)** OD $36 - .20$ MM
HEIGHT 14.5 ± 1.5 MM.
- e) **SPACER (E)** OD $35.56 - 0.25$ MM
HEIGHT $30.48 - 0.25$ MM.

OUTPUT - FINISHED PRODUCTS (STUN SHELL (N/E) :-

RATE/HRS. - 500 NOS.

DETAIL PROCESS:-

- FILLING OF SPACER (N/E) IN TO CARTRIDGE CASE (N/E).
- PLACING OF 1 MM HDPE RING IN ELECTRIC CARTRIDGE IF REQUIRED.
- PAPER STRIPPING/ FIXING OF SURGICAL TAPE ON IGNITOR OUTER DIA IF REQUIRED.
- APPLYING OF SHELLAC VARNISH IN INNER PORTION OF CARTRIDGE CASE/
OUTER PORTION OF PAPER STRIPED IGNITOR.

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- PUSH FIT STUN SHELL BODY (N & E) UP TO GIVEN SLOT IN PREPARED CARTRIDGE CASE.
- CLEANING OF SHELL BODY.

NOTE: - 1) BEFORE PLACING OF SPACER (E) INTO CARTRIDGE CASE (E) A CUT REQUIRED ON PAPER DISC OF SPACER, SO THAT SQUIB CAN EASILY INSERT INTO THE SPACER.






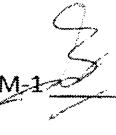



2) MAKE SURE THERE IS NO GAP LEFT BEHIND BETWEEN CARTRIDGE CASE AND IGNITOR.

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 HAVE ARRANGEMENT TO SAFE UNLOADING AND STACK UP OF STUN SHELL.
3)	MACHINE SHOULD HAVE DIGITAL DISPLAY TO INDICATE FINISHED NOS OF SHELLS.
4)	IN CASE OF MALFUNCTIONING, THE MACHINE SHOULD HAVE AUTOMATIC TRIPPING SYSTEM AND ALSO HAVE SOUND AND LIGHT INDICATION.
5)	MACHINE WILL BE EARTHENED TO DISCHARGE STATIC CHARGE
6)	ALL EQUIPMENT'S /COMPONENTS FITTED IN THE MACHINE SHOULD BE OF REPUTED BRAND AND OF ISO/ISI CERTIFIED COMPANY.
7)	MACHINE SHOULD OPERATE PREFERABLY ON PLC CONTROL OF IEC-61131 STANDARD.
8)	MACHINE SHOULD HAVE PROPER SAFEGUARDS FOR THE SAFETY OF OPERATOR.
9)	HIGH QUALITY OF INSULATION IN WIRING AND MACHINE PARTS TO AVOID BLAST OF ELECTRIC SHELL
10)	MACHINE SHOULD HAVE FACILITY OF DETECTION OF OMISSION AND MALFUNCTIONING AT ANY STAGES OF PROCESS AND SHOULD HAVE FACILITY TO SEPARATE THE REJECTED/ DEFECTIVE PRODUCT.
11)	MACHINE SHOULD WORK PREFERABLY ON PNEUMATIC BASE.

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12)	TUBES CONNECTING THE MACHINE TO PNEUMATIC MACHINE SHOULD BE OF REQUISITE DIMENSIONS AND ISI MAKE.
13)	MACHINE SHOULD BE ABLE TO OPERATE WITHIN OPERATING TEMPERATURE $25 \pm 10^{\circ} \text{C}$ AND OPERATING HUMIDITY $40 \pm 15\%$.
14)	ALL ELECTRIC WIRING AND ELECTRICAL COMPONENTS SHOULD BE PROPERLY CASED AND FLAME PROOF AND EASILY ACCESSIBLE FOR REPAIR AND MAINTENANCES.
15)	MACHINE SHOULD BE COMPACT TO SAVE SPACE AND EASY TO ACCESS FOR REPAIR AND MAINTENANCES.
16)	BASIC STRUCTURE OF MACHINE SHOULD BE MADE OF ISI / CLASS APPROVED QUALITY METAL, RESISTANT TO CORROSION / RUSTING AND FLAME.
17)	USER MANUAL WITH REQUIRED ILLUSTRATIONS TO BE PROVIDED WITH MACHINE.
18)	INSTRUCTION ON REPAIR & MAINTENANCE TO BE PROVIDED WITH MACHINE.
19)	RUNNING SPARE PARTS WITH ILLUSTRATED LIST SHOULD BE PROVIDED WITH MACHINE.
20)	OPERATIONAL TRAINING SHOULD BE ARRANGED FOR 1 WEEKS FOR MINIMUM 15 PERS.
21)	REPAIR AND MAINTENANCE TRAINING SHOULD BE ARRANGED FOR 1 WEEKS FOR MINIMUM 10 PERS.
22)	SPECIFIC GAUGES AND MAINTENANCE TOOLS SHOULD BE PROVIDED WITH MACHINE.
23)	<p><u>GUARANTEE / WARRANTY:-</u></p> <p>i) MACHINE SHOULD HAVE 2 YEARS GUARANTEE / WARRANTY AFTER COMMISSIONING.</p> <p>ii) PREVENTIVE MAINTENANCE ONCE IN 3 MONTH DURING GUARANTEE / WARRANTY PERIOD.</p> <p>iii) GUARANTEE/ WARRANTY WILL BE COMPREHENSIVE i.e INCLUSIVE OF SPARE PARTS.</p>
24)	AMC PERIOD SHOULD BE 05 YEARS AFTER EXPIRY OF GUARANTEE / WARRANTY PERIOD.

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CARTRIDGE CASE PUSH FIT MACHINE

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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 HAVE ARRANGEMENT TO SAFE UNLOADING AND STACK UP OF STUN SHELL.	Physical Verification by BOOs	
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