



KOLHAPUR ZILLA SAHAKARI DUDH UTPADAK SANGH LTD. KOLHAPUR

**TENDER - FORM**

**[ for Milk Packaging Polyethylene Film with CIF printing ]**

***A) GENERAL INFORMATION OF TENDERER-***

1) Name :

2) Address :

3) Phone/Mobile No:

Fax No :

E mail-

4) Name & designation of the Authorised Signatory –

***B) PRICE DETAILS -***

Sr. No.	Particulars of film	Rate / Kg	G.S.T.
1	Co-extruded five layer white opaque film having outer layer white and inner coloured layer with multicolour <b>CIF printing</b> (Up to six colour)		
2	Co-extruded five layer opaque film with three colour <b>CIF printing</b>		

These rates are quoted by considering given specifications and are based on the present price of LDPE raw material grade 1005FY20 supplied by M/s Reliance Industries Ltd. i.e. Rs. /- + GST per kg ( i.e. raw material price applicable for Mumbai-Bhivandi depot)

***C) OTHER INFORMATION IF ANY :***

Date -

Signature & Seal of the  
Tenderer

**D) Other Information Of The Tenderer -**

- 1) Factory Address :
- 2) Factory Phone No :
- 3) Whether In house facility of Multi Colour ( up to six colour) Central Impression Flexo printing (Anti-counterfeiting printing) is available with you. (If available submit at least two samples of printed film having anticounterfeiting multi colour CIF printing of tight registration) : Yes / No
- 4) Whether extruder to produce five layer film is available with you : Yes / No
- 5) Monthly film processing / printing Capacity ( in Tonnes )
- 6) Names of buyers to whom you are supplying this type of film (Attach respective documents) :
  - i)
  - ii)
  - iii)
  - iv)
  - v)
- 7) G.S.T. Information :

**Seal & Signature of the  
Tenderer**

**KOLHAPUR ZILLA SAHAKARI DUDH UTPADAK SANGH LTD.**  
**GENERAL TERMS AND CONDITIONS FOR THE TENDER FOR SUPPLYING CIF PRINTED MILK**  
**POLYFILM**

1)	Tender details should be given on the prescribed Format only. Tenderer should thoroughly study the specifications of film before submitting their Tender offer.
2)	<p>Earnest money deposit as given below should be sent alongwith the Tender. By D.D. Drawn in the name of Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd.Kolhapur payable at Kolhapur.</p> <p>1. EMD for 6 colour CIF printed film :- Rs.7,00,000/- (Rs.Seven Lac only) (i.e.Film having inner coloured layer)</p> <p>2. EMD for 3 colour CIF printed film :- Rs.4,00,000/- (Rs Ffour Lac only)</p> <p>Tender without EMD will not be considered.</p>
3)	Quantity of CIF printed polyethylene film mentioned in Tender Notice is our requirement for the period of one year & this film is required at our Gokul Shirgaon (Kolhapur), Satellite Dairy, Udgaon, Sindhubhumi Dairy Farm, Nadhawade, Navi Mumbai and Pune Packaging Stations. Actual purchases of film will be made as per our requirements during the period of supply. Detailed specifications of required polyethylene film are enclosed herewith.
4)	Tenderer should quote F.O.R. Destination prices, i.e. prices inclusive of P&F, Transportation, transit insurance etc. Local Levies if any will be borne by Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd.Kolhapur. Applicable G.S.T. Should be given separately.
5)	The party should prepare cylinder as per our requirement, the cost of which is to be borne by the party. In future, during supply peirod, if sangh requires to make any change in design or printing matter the charges to be incurred for the same also will have to be borne by the party.
6)	Tenderer who submits their Tender for supply of 6 colour & 3 colour sepertely CIF printed film with proper photocell marking must send at least 5 kg sample roll of multicolour CIF printed polyfilm having outer layer white opaque & inner coloured layer for 6 colour & 5kg seperate sample for 3 colour as per our Tender specifications .
7)	Duly filled Tender alongwith D.D. towards requisite EMD in a sealed cover duly marked as <b>"CIF PRINTED MILK FILM TENDER"</b> should reach our office at B-1, MIDC, Gokul Shirgaon, Kolhapur on or before - <b>16/6/2023</b>
8)	Successful Tenderer will have to execute agreement with us and will have to keep Security Deposit with us.
9)	Right to accept or reject any or all Tenders without assigning any reason is reserved.

Managing Director

## SPECIFICATIONS FOR MILK PACKING POLYETHYLENE FILM

(500ml,1000ml FCM/ Cow milk film for Washi /Pune Branch With Multi Colours Central Impression Flexo Printing)

### A)Description :-

#### Composition: -

The film shall be made from virgin polyethylene LDPE food grade quality given in IS: 10146-1982 and IS: 10141-1982. The film may be co-extruded with **five layer** (outer layer opaque & inner layer colour) extrusions using above material in combination with other material to improve sealing performance (i.e. octane base LLDPE). The desirable composition of the film is octane base LLDPE with LDPE 1005 FY20 of RIL or equivalent of it. The pigment used, shall be from those listed in IS: 9833-1981.

#### Appearance & General requirements:

The film should be heat sealable and suitable for use in high speed form filling and sealing machines. The film must be odourless .The film shall be uniform in texture,finish,thickness,width and strength. It shall be clear ,free from pinholes, streak particles of foreign matter, gauge bends, fish eyes, wrinkles & undispersed raw material..There shall be no other visible defect such as holes ,tears or blisters. The film shall have even & wrinkle free surface. The edges must be free from cuts, hikes and wrinkles. The film must not show any handling marks. Static electricity from the film should be removed. The film rolls should be thoroughly protected against contamination. The film rolls not conforming to the above general requirements is liable to rejection at any stage of utilization with penalty . Outer layer of film should be white opaque & inner layer colored blue as approved. Other specifications shall be as per IS:2508-1984.

#### Form: -

The film shall be supplied in rolls weighing not more than 19kg including the weight of core on which it is wind & rolls shall be wrapped with poly-liner & packed in Kraft paper corrugated box to avoid damage & entry of dust & dirt. Rolls shall be covered with shrink wrap from outer side.

Each roll shall contain a slip pasted inside the core indicating the batch number ,date of production, weight of the roll (Gross and Net) and also copy of the same should be pasted outside the corrugated box.The above should be duly authenticated by the supplier

**Core:-** Core should be strong & properly compressed. Paper having smooth surface and dry preferably core will be use made from HDPE.

(a) Inner diameter of core = 76 mm

(b) Weight of the core = 500 gm to 1 kg.

**Winding:** -The film shall be wound on the core uniformly & with proper tension giving perfect edges. There shall be no telescoping of film layers. The core shall be strong enough so as not to collapse in use.

### B) Physical Standards

**Odor:** -The film shall be free from any extraneous odor.

#### Thickness: -

(a) Film printed with 500 ml = 51 to 54 micron(preferably 52 micron)

(b) Film printed with 1000 ml= 56 to 60 micron

The thickness of the film shall not exceed allowable tolerance as shown above.

**Width: -** The width of the film shall be 323 + 2 mm

**Drop Test:** -Sixteen samples of filled pouches shall be taken at random from the filling line. The sample bags drawn from the machine shall be dropped from the height of 1.2 meter on a flat, smooth, hard surface in four ways. i.e.

- (1) At vertical seam.
- (2) At opposite to vertical seam.
- (3) & (4) At vertical edges.

The samples shall deem to have the test of 75 % of the sample with stood all the above 4 drops.

**Impact Resistance:-**The maximum failures shall not more than 50 % tested by the procedure given in A-6 IS: 2508-1984

Dart for 500 ml = 190 g.

Dart for 1000 ml = 230 g.

**Tensile Strength (kg F/cm<sup>2</sup>)**

LD – 220 ± 5 %

CD –180 ± 5 %

**Percentage Elongation:-**

LD – 300 Min.

CD – 600 Min.

**Wastage:-** The overall operational wastages of the film on handling in plant, filling & storage shall not more than 2 % of the weight of the film used. Which will be reviewed after three months.

**Printing of Film: -**

Film shall be multi colours Central Impression Flexo Printing for Full Cream Milk and cow milk (Anti counterfeiting printing with tight registration.). Ink used for printing shall be confirm to IS: 6931-1972 & shall be permissible under FSSAI 2006 , Rules & Regulations 2011.The ink shall not bleed or spread over the heating element. There shall be no change or deviation in standard colour shade approved by sangh. The ink used in printing should be odourless ,fast drying and non toxic,foodgrade and conform to all applicable FSSAI 2006, Rules & regulations 2011.

**Colour coding**

Following are the pantone shades/ colours suggested to be used for printing of milk film for mentioned variants

Sr.No	Variant Name	Pantone colour/code No.
1	FCM film	CYAN
	1000ml/500ml	MAGENTA
	Vashi/Pune	YELLOW
		BLACK
		P 1495
		P354
Sr.No	Variant Name	Pantone colour/code No.
2	COW MILK FILM	C10Y30
	1000ml/500ml	CYAN
	Vashi/Pune	P144
		GREY
		P356
		P361
		BLACK

**Sealing Property:-**The film have good sealing property for vertical & horizontal sealing.

**Printing Matter On Polyethylene Film:-**Printing shall be done as per Legal Metrology Act 2009 , FSSAI- 2006, Rules & Regulations 2011.The invoice should bear the declaration that all materials used in the manufacturer of the material being supplied by you are food grade and can safe for use in the production /packing of our food products.

**Vendor Inspection:** We reserve our rights to visit your factories at any time without prior notice. If we find use of any substandard raw material is being used in manufacture of milk film during the contract period, it may lead to cancellation of the orders in addition to forfeiting your security deposit and also delisting your name from our approved suppliers' list once for all. Also we reserve the right to inspect your factory premises and go through relevant original invoices of purchases and other records at any time during the contract period without prior notice if at any time we are not satisfied with any aspect of procurement of your raw material, storage of raw material / work in progress / storage of finished goods. We reserve the right to take suitable action.

**Good manufacturing practice:** The material supplied by you will be used directly to pack the food product for human consumption; hence it is essential that the material conform to food grade standard and hygienic quality. Toward this it is essential that your factory premises and its surroundings where the material is produced/ manufactured/ packed are maintained in utmost clean dust free/ insect free environment with good hygienic condition. You are therefore requested to ensure absolute cleanliness and hygiene to avoid any chances of contamination or infestation. The consequence of supplies not confirming to desired Good manufacturing practices will fall entirely on the supplier and hence of such material is heavily penalized

We reserve the right to get your material tested from authentic independent laboratory. The result of which would be binding to both of us. In case of any non-specified/non standard material being used in your material. We reserve the right to suspend business with you, cancel rate contract, take legal action and forfeit your security deposit.

The right of printing Gokul logo design on packing material belongs to Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd., Kolhapur. If it is found than any manufacturer is occupied or instrumental in printing the Gokul Logo/design for other than Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd. They will heavily penalized depending on the depth of the grievance and will be liable for legal action.

Destruction of rejected material in production run:

The sorted out/rejected quantities of film at your end should be immediately destroyed. If any such stock is found lying in your premises it will be deemed for unhealthy use and your security deposit shall be forfeited and you shall be de listed from our approved list

In the usage of any particular consignment if any rolls is not conforming to the specifications such as thickness,width,drop test,colour fastness test,extraneous test pinholes & sealing performance etc such rolls shall be rejected.All rejected film rolls for any reason of non conforming with specifications or parameters specified in the tender terms & conditions shall be duly cold punched before sending back to the suppliers

**Quality :**

Supplies not conforming to our specification will be rejected or accepted with penalty. Right of acceptance or rejection is reserved by sangh .Rejected film will be damaged and returned to supplier.Supplier should lift this material within fifteen days after intimation.

The name and logo of the milk film processor should be printed on the sides in such manner that the same appear at least once on each pouch length, and may not come in between the sealing area.

The material must also retain the desired quality as per our specification till expiry / consumption of the product in which used /packed therein.

**C) Acceptance Criteria :-**

In – house physical analysis.

Every year polythene film from supplier lot shall be check for food grade quality material from specified INDIAN INSTITUTE OF PACKAGING at the supplier cost. and original certificate should be produced for validation purpose along with attested Xerox copy.

**Number of sound bags/Kg of polyfilm** \_\_\_\_\_

Description	Bag Length	Min.yield of bag/kg	Max yield of bag/kg	Average yield of bag/kg
500ml	15 cm	397( 54micron)	421( 51 micron)	413( 52 micron)
1000ml	23cm	233( 60 micron)	250( 56 micron)	241( 58 micron)

**The name and logo of the milk film processor should be printed on the sides in such manner that the same appear at least once on each pouch length, and may not come in between the sealing area.**

Every supplier has to submit approved 3 copies L.S.D.(Light ,Standard ,Dark) in digital printing form as well as polythene film sample which will be used for acceptance of film for colour code.

Manager(Q.C.)

Asst.General    Manager (Dairy)

**SPECIFICATIONS FOR POLYETHYLENE FILM**  
**(For Vashi & Pune Central Impression Flexo Printing)**  
For Toned milk & Standardised milk film

<b>A)Description :-</b> <b>Composition: -</b> The film shall be made from virgin polyethylene LDPE food grade quality given in IS: 10146-1982 and IS: 10141-1982 .The film may be co-extruded with <b>five layer</b> (outer & inner layer opaque )using above material in combination with other material to improve sealing performance (i.e. octane baseLLDPE). The desirable composition of the film is Octane base LLDPE with LDPE 1005 FY20 of RIL or equivalent of it. The pigment used, shall be from those listed in IS: 9833 – 1981 and minimum 5% of raw material used for manufacturing of polyfilm
<b>Appearance &amp; General requirements:</b> The film should be heat sealable and suitable for use in high speed form filling and sealing machines. The film must be odourless .The film shall be uniform in texture,finish,thickness,width and strength. It shall be clear ,free from pinholes,streak particles of foreign matter, gauge bends,fish eyes,wrinkles & undispersed raw material..There shall be no other visible defect such as holes ,tears or blisters. The film shall have even & wrinkle free surface. The edges must be free from cuts,hikes and wrinkles. The film must not show any handling marks. Static electricity from the film should be removed. The film rolls should be thoroughly protected against contamination. The film rolls not conforming to the above general requirements is liable to rejection at any stage of utilization with penalty. Other specifications shall be as per IS:2508-1984.
<b>Form: -</b> The film shall be supplied in rolls weighing not more than 21kg including the weight of core on which it is wind. Rolls shall be wrapped with poly-liner & packed in Kraft paper corrugated boxes to avoid damage the film & entry of dust & dirt. Rolls shall be covered with shrink wrap from outer side. Each roll shall contain a slip pasted inside the core indicating the batch number ,date of production, weight of the roll (Gross and Net) and also copy of the same should be pasted outside the corrugated box. The above should be duly authenticated by the supplier.
<b>Core: -</b> Core should be strong & properly compressed. Paper having smooth surface and dry preferably core will be use made from HDPE. (a) Inner diameter of core = 76 mm (b) Weight of the core = 500 gm to 1 kg.
<b>Winding: -</b> The film shall be wind on the core uniformly & with proper tension giving perfect edges. There shall be no telescoping of film layers. The core shall be strong enough so as not to collapse in use..There must not be more than one joint in a roll.
<b>B) Physical Standards</b> <b>Odor: -</b> The film shall be free from any extraneous odor.
<b>Thickness: -</b> For film used at Washi and pune packing station: (a) Film printed with 500 ml = 51 to 54 micron(preferably 52 micron) (b) Film printed with 1000 ml=56 to 60 micron The thickness of the film shall not exceed allowable tolerance as shown above..
<b>Width: -</b> The width of the film shall be 323 + 2 mm
<b>Drop test: -</b> Sixteen samples of filled pouches shall be taken at random from the filling line. The sample bags drawn from the machine shall be dropped from the height of 1.2 meter on a flat, smooth, hard surface in four ways i.e. (1) at vertical seam (2) at opposite to vertical seam (3) & (4) at vertical edges.The samples shall deem to have the test of 75% of the sample with stood all the above 4 drops.



<b>Impact Resistance:</b> - The maximum failures shall not more than 50% tested by the procedure given in A-6 IS: 2508-1984
<b>Wastages:</b> - The overall operational wastages of the film on handling in plant, filling & storage and distribution shall not more than 2% of the weight of the film is used. Which will be reviewed after three months.
<b>Printing of Film:</b> - The film shall be printed in three colour central impression printing for toned milk, standardized milk. Ink used for printing shall be confirm to IS: 6931-1972 and shall be permissible under FSSAI-2006, Rules & Regulations 2011. The ink shall not bleed or spread over the heating element .The ink used in printing should be odourless ,fast drying and non toxic,foodgrade and conform to all applicable FSSAI 2006, Rules & regulations 2011.
<b>Sealing Property:</b> - The films have good sealing property for vertical & horizontal sealing.
<b>Printing Matter On Polyethylene Film:</b> - Printing shall be done as per Legal Metrology Act 2009 & FSSAI 2006 , Rules & Regulations 2011. .Printing matter & colour for printing shall be suggested by Sangh.
The invoice should bear the declaration that all materials used in the manufacturer of the material being supplied by you are foodgrade and can safe for use in the production /packing of our food products.
<p><b>Vendor Inspection:</b></p> <p>We reserve our rights to visit your factories at any time without prior notice. If we find use of any substandard raw material is being used in manufacture of milk film during the contract period, it may lead to cancellation of the orders in addition to forfeiting your security deposit and also delisting your name from our approved suppliers' list once for all. Also we reserve the right to inspect your factory premises and go through relevant original invoices of purchases and other records at any time during the contract period without prior notice if at any time we are not satisfied with any aspect of procurement of your raw material, storage of raw material / work in progress / storage of finished goods. We reserve the right to take suitable action.</p>
<p><b>Good manufacturing practice:</b></p> <p>The material supplied by you will be used directly to pack the food product for human consumption; hence it is essential that the material conform to food grade standard and hygienic quality. Toward this it is essential that your factory premises and its surroundings where the material is produced/ manufactured/ packed are maintained in utmost clean dust free/ insect free environment with good hygienic condition. You are therefore requested to ensure absolute cleanliness and hygiene to avoid any chances of contamination or infestation. The consequence of supplies not confirming to desired Good manufacturing practices will fall entirely on the supplier and hence of such material is heavily penalized.</p>
We reserve the right to get your material tested from authentic independent laboratory. The result of which would be binding to both of us. In case of any non specified/non standard material being used in your material. We reserve the right to suspend business with you, cancel rate contract, take legal action and forfeit your security deposit.
The right of printing Gokul logo design on packing material belongs to Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd., Kolhapur. If it is found than any manufacturer is occupied or instrumental in printing the Gokul Logo/design for other than Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd. They will heavily penalized depending on the depth of the grievance and will be liable for legal action.
<b>Destruction of rejected material in production run:</b> The sorted out/rejected quantities of film at your end should be immediately destroyed. If any such stock is found lying in your premises it will be deemed for unhealthy use and your security deposit shall be forfeited and you shall be de listed from our approved list.
In the usage of any particular consignment if any rolls is not conforming to the specifications such as thickness,width,drop test,colour fastness test,extraneous test, pinholes & sealing performance etc

such rolls shall be rejected. All rejected film rolls for any reason of non conforming with specifications or parameters specified in the tender terms & conditions shall be duly cold punched before sending back to the suppliers.

**Quality :**

Supplies not conforming to our specification will be rejected or accepted with penalty. Right of acceptance or rejection is reserved by sangh. Rejected film will be damaged and returned to supplier. Supplier should lift this material within fifteen days after intimation.

The name and logo of the milk film processor should be printed on the sides in such manner that the same appear at least once on each pouch length, and may not come in between the sealing area.

**C) Acceptance Criteria :-**

In – house physical analysis.

Every year polythene film from supplier lot shall be check for food grade quality material from specified INDIAN INSTITUTE OF PACKAGING at the supplier cost. and original certificate should be produced for validation purpose along with attested Xerox copy.

**Number of sound bags/Kg of polyfilm**

Description	Bag Length	Min.yield of bag/kg	Max yield of bag/kg	Average yield of bag/kg
500ml	15 cm	397( 54micron)	421( 51 micron)	413( 52 micron)
1000ml	23cm	233( 60 micron)	250( 56 micron)	241( 58 micron)

Every supplier has to submit approved 3 copies L.S.D.(Light ,Standard ,Dark) in digital printing form as well as polythene film sample which will be used for acceptance of film for colour code.

Manager(Q.C.)

Asst.General Manager (Dairy)

## **SPECIFICATION FOR POLYETHYLENE FILM WITH CENTRAL IMPRESSION FLEXO PRINTING**

[ Washi ,Pune – 5 Liter Packing])

### **A)Description :-**

#### **Composition:-**

The film shall be made from virgin polyethylene LDPE food grade quality given in IS: 10146-1982 and IS: 10141-1982. The film may be co-extruded with five layer (outer and inner layer opaque) extrusions using above material in combination with other material to improve sealing performance . The desirable composition of the film is octane base LLDPE with LDPE 1005 FY20 of RIL or equivalent of it. The pigment used, shall be from those listed in IS: 9833-1981 and minimum 5% of raw material used for manufacturing of polyfilm.

#### **Appearance & General requirements:**

The film should be heat sealable and suitable for use in high speed form filling and sealing machines. The film must be odourless .The film shall be uniform in texture, finish, thickness, width and strength. It shall be clear ,free from pinholes, streak particles of foreign matter, gauge bends, fish eyes, wrinkles & undispersed raw material..There shall be no other visible defect such as holes ,tears or blisters. The film shall have even & wrinkle free surface. The edges must be free from cuts, hikes and wrinkles. The film must not show any handling marks. Static electricity from the film should be removed. The film rolls should be thoroughly protected against contamination. The film rolls not conforming to the above general requirements is liable to rejection at any stage of utilization with penalty

#### **Winding: -**

The film shall be wound on the core uniformly & with proper tension giving perfect edges. There shall be no telescoping of film layers. The core shall be strong enough so as not to collapse in use. Each roll shall contain a slip pasted inside the core indicating the batch number ,date of production, weight of the roll (Gross and Net) and also copy of the same should be pasted outside the corrugated box.

The above should be duly authenticated by the supplier.

#### **Form: -**

Rolls shall be wrapped with poly-liner & packed in Kraft paper corrugated box to avoid damage & entry of dust & dirt. Rolls shall be covered with shrink wrap from outer side.

Each roll shall contain a slip pasted inside the core indicating the batch number ,date of production, weight of the roll (Gross and Net) and also copy of the same should be pasted outside the corrugated box.

The above should be duly authenticated by the supplier

**Core:-** Core should be strong & properly compressed. Paper having smooth surface

(c) Inner diameter of core = 76 mm

(d) Weight of the core = 500 gm to 1 kg.

### **B) Physical Standards**

**Odor:-** The film shall be free from any extraneous odor.

#### **Thickness:-**

(a) Film printed for 5000 ml packing =  $110 \pm 5$  micron.

The thickness of the film shall not exceed allowable tolerance as shown above

**Width:-** The width of the film shall be  $590 \pm 2$  mm

#### **Wastage:-**

The overall operational wastages of the film on handling in plant, filling & storage shall not more than 2 % of the weight of the film used. Which will be reviewed after three months.

**Printing of Film:-**

The film shall be printed in three colour Central Impression Flexo printing for Full Cream Milk, Standardised Milk Packing, Ink used for printing shall confirm to IS: 6931-1972 & shall be permissible under FSSAI-2006 Rules & Regulations 2011. The ink shall not bleed or spread over the heating element. There shall be no change or deviation in standard colour shade approved by Sangh. The ink used in printing should be odourless, fast drying non toxic, food grade and conform to all applicable FSSAI -2006, Rules & Regulations 2011.

**Sealing Property:-**

The film have good sealing property for vertical & horizontal sealing.

**Printing Matter On Polyethylene Film:-**

Printing shall be done as per Legal Metrology Act 2009, FSSAI 2006, Rules & Regulations 2011. Ink used for printing shall be confirm to IS: 6931-1972.

The invoice should bear the declaration that all materials used in the manufacturer of the material being supplied by you are foodgrade and can safe for use in the production /packing of our food products.

**Vendor Inspection:**

We reserve our rights to visit your factories at any time without prior notice. If we find use of any substandard raw material is being used in manufacture of milk film during the contract period, it may lead to cancellation of the orders in addition to forfeiting your security deposit and also delisting your name from our approved suppliers' list once for all. Also we reserve the right to inspect your factory premises and go through relevant original invoices of purchases and other records at any time during the contract period without prior notice if at any time we are not satisfied with any aspect of procurement of your raw material, storage of raw material / work in progress / storage of finished goods. We reserve the right to take suitable action.

**Good manufacturing practice:**

The material supplied by you will be used directly to pack the food product for human consumption; hence it is essential that the material conform to food grade standard and hygienic quality. Toward this it is essential that your factory premises and its surroundings where the material is produced/ manufactured/ packed are maintained in utmost clean dust free/ insect free environment with good hygienic condition. You are therefore requested to ensure absolute cleanliness and hygiene to avoid any chances of contamination or infestation. The consequence of supplies not confirming to desired Good manufacturing practices will fall entirely on the supplier and hence of such material is heavily penalized.

We reserve the right to get your material tested from authentic independent laboratory. The result of which would be binding to both of us. In case of any non specified/non standard material being used in your material. We reserve the right to suspend business with you, cancel rate contract, take legal action and forfeit your security deposit.

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**Destruction of rejected material in production run:**

The sorted out/rejected quantities of film at your end should be immediately destroyed. If any such stock is found lying in your premises it will be deemed for unhealthy use and your security deposit shall be forfeited and you shall be delisted from our approved list.

**Quality :**

Supplies not conforming to our specification will be rejected or accepted with penalty. Right of acceptance or rejection is reserved by sangh. Rejected film will be damaged and returned to supplier. Supplier should lift this material within fifteen days after intimation.

In the usage of any particular consignment if any rolls is not conforming to the specifications such as thickness, width, drop test, colour fastness test, extraneous test, pinholes & sealing performance etc such rolls shall be rejected. All rejected film rolls for any reason of non conforming with specifications or parameters specified in the tender terms & conditions shall be duly cold punched before sending back to the suppliers

The name and logo of the milk film processor should be printed on the sides in such manner that the same appear at least once on each pouch length, and may not come in between the sealing area.

The material must also retain the desired quality as per our specification till expiry / consumption of the product in which used /packed therein.

**(C) Acceptance Criteria:-**

In – house physical analysis.

Every year polythene film from supplier lot shall be check for food grade quality material from specified INDIAN INSTITUTE OF PACKAGING at the supplier cost. and original certificate should be produced for validation purpose along with attested Xerox copy.

**Number of sound bags/Kg of polyfilm**

Description	Bag Length	Min yield of bag/kg
5000ml	40 cm	35( 110 micron)

Every supplier has to submit approved 3 copies L.S.D.(Light ,Standard ,Dark) in digital printing form as well as polythene film samples which will be used for acceptance of film for colour code.

Manager(Q.C.)

Asst.General Manager (Dairy)

**SPECIFICATIONS FOR MILK PACKING POLYETHYLENE FILM**  
(For Kolhapur , Shirol, Sindubhumi Central Impression Flexo Printing)

<b>A)Description :-</b>
<b>Composition: -</b> The film shall be made from virgin polyethylene LDPE food grade quality given in IS: 10146-1982 and IS: 10141-1982. The film may be co-extruded with <b>five layer</b> (outer & inner layer opaque ) extrusions using above material in combination with other material to improve sealing performance (i.e. octane base LLDPE). The desirable composition of the film is octane base LLDPE with LDPE 1005 FY20 of RIL or equivalent of it. The pigment used, shall be from those listed in IS: 9833-1981.
<b>Appearance &amp; General requirements:</b> The film should be heat sealable and suitable for use in high speed form filling and sealing machines. The film must be odourless .The film shall be uniform in texture,finish,thickness,width and strength. It shall be clear ,free from pinholes,streak particles of foreign matter, gauge bends,fish eyes,wrinkles & undispersed raw material..There shall be no other visible defect such as holes ,tears or blisters. The film shall have even & wrinkle free surface. The edges must be free from cuts,hikes and wrinkles. The film must not show any handling marks. Static electricity from the film should be removed. The film rolls should be thoroughly protected against contamination. The film rolls not conforming to the above general requirements is liable to rejection at any stage of utilization with penalty . Outer layer of film should be white opaque & inner layer colored blue as approved.Other specifications shall be as per IS:2508-1984.
<b>Form: -</b> The film shall be supplied in rolls weighing not more than 19kg including the weight of core on which it is wind & rolls shall be wrapped with poly-liner & packed in Kraft paper corrugated box to avoid damage & entry of dust & dirt. Rolls shall be covered with shrink wrap from outer side. Each roll shall contain a slip pasted inside the core indicating the batch number ,date of production, weight of the roll (Gross and Net) and also copy of the same should be pasted outside the corrugated box. The above should be duly authenticated by the supplier
<b>Core:-</b> Core should be strong & properly compressed. Paper having smooth surface and dry preferably core will be use made from HDPE. (e) Inner diameter of core = 76 mm (f) Weight of the core = 500 gm to 1 kg.
<b>Winding: -</b> The film shall be wound on the core uniformly & with proper tension giving perfect edges. There shall be no telescoping of film layers. The core shall be strong enough so as not to collapse in use.
<b>B) Physical Standards</b>
<b>Odor: -</b> The film shall be free from any extraneous odour.
<b>Thickness: -</b> (a) Film printed with 500 ml = 51 to 54 micron( preferably 52 micron) (b) Film printed with 1000 ml= 56 to 60 micron (c) Film printed with 200 ml = 51 to 54 micron. ( preferably 52 micron) The thickness of the film shall not exceed allowable tolerance as shown above..
<b>Width: -</b> The width of the film shall be 323 + 2 mm

**Drop Test: -**

Sixteen samples of filled pouches shall be taken at random from the filling line. The sample bags drawn from the machine shall be dropped from the height of 1.2 meter on a flat, smooth, hard surface in four ways. i.e.

(4) At vertical seam.

(5) At opposite to vertical seam.

(6) & (4) At vertical edges.

The samples shall deem to have the test of 75 % negative of the sample with stood all the above 4 drops.

**Impact Resistance:-**

The maximum failures shall not more than 50 % tested by the procedure given in A-6 IS: 2508-1984

Dart for 500 ml = 190 g.

Dart for 1000 ml = 230 g.

**Tensile Strength (kg F/cm<sup>2</sup>)**

LD - 220 ± 5 %

CD -180 ± 5 %

**Percentage Elongation:-**

LD - 300 Min.

CD - 600 Min.

**Wastage:-**

The overall operational wastages of the film on handling in plant, filling & storage shall not more than 2 % of the weight of the film used. Which will be reviewed after three months.

**Printing of Film: -**

Film shall be printed in three colours Central Impression Flexo Printing . Ink used for printing shall be confirm to IS: 6931-1972 & shall be permissible under FSSA 2006 , Rules & Regulations 2011.The ink shall not bleed or spread over the heating element. There shall be no change or deviation in standard colour shade approved by sangh. The ink used in printing should be odourless ,fast drying and non toxic,foodgrade and conform to all applicable FSSA 2006, Rules & regulations 2011.

**Sealing Property:-**

The film have good sealing property for vertical & horizontal sealing.

**Printing Matter On Polyethylene Film:-**

Printing shall be done as per Legal Metrology Act 2009 , FSSA 2006, Rules & Regulations 2011.

The invoice should bear the declaration that all materials used in the manufacturer of the material being supplied by you are foodgrade and can safe for use in the production /packing of our food products.

**Vendor Inspection:**

We reserve our rights to visit your factories at any time without prior notice. If we find use of any substandard raw material is being used in manufacture of milk film during the contract period, it may lead to cancellation of the orders in addition to forfeiting your security deposit and also delisting your name from our approved suppliers' list once for all. Also we reserve the right to inspect your factory premises and go through relevant original invoices of purchases and other records at any time during the contract period without prior notice if at any time we are not satisfied with any aspect of procurement of your raw material, storage of raw material / work in progress / storage of finished goods. We reserve the right to take suitable action.

<b>Good manufacturing practice:</b> The material supplied by you will be used directly to pack the food product for human consumption; hence it is essential that the material conform to food grade standard and hygienic quality. Toward this it is essential that your factory premises and its surroundings where the material is produced/ manufactured/ packed are maintained in utmost clean dust free/ insect free environment with good hygienic condition. You are therefore requested to ensure absolute cleanliness and hygiene to avoid any chances of contamination or infestation. The consequence of supplies not confirming to desired Good manufacturing practices will fall entirely on the supplier and hence of such material is heavily penalized				
We reserve the right to get your material tested from authentic independent laboratory. The result of which would be binding to both of us. In case of any non-specified/non standard material being used in your material. We reserve the right to suspend business with you, cancel rate contract, take legal action and forfeit your security deposit.				
The right of printing Gokul logo design on packing material belongs to Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd., Kolhapur. If it is found than any manufacturer is occupied or instrumental in printing the Gokul Logo/design for other than Kolhapur Zilla Sahakari Dudh Utpadak Sangh Ltd. They will heavily penalized depending on the depth of the grievance and will be liable for legal action.				
<b>Destruction of rejected material in production run:</b>				
The sorted out/rejected quantities of film at your end should be immediately destroyed. If any such stock is found lying in your premises it will be deemed for unhealthy use and your security deposit shall be forfeited and you shall be de listed from our approved list.				
In the usage of any particular consignment if any rolls is not conforming to the specifications such as thickness,width,drop test,colour fastness test,extraneous test ,pinholes & sealing performance etc such rolls shall be rejected.All rejected film rolls for any reason of non conforming with specifications or parameters specified in the tender terms & conditions shall be duly cold punched before sending back to the suppliers				
<b>Quality :</b> Supplies not conforming to our specification will be rejected or accepted with penalty. Right of acceptance or rejection is reserved by sangh .Rejected film will be damaged and returned to supplier.Supplier should lift this material within fifteen days after intimation.				
<b>The name and logo of the milk film processor should be printed on the sides in such manner that the same appear at least once on each pouch length, and may not come in between the sealing area.</b>				
The material must also retain the desired quality as per our specification till expiry / consumption of the product in which used /packed therein.				
<b>C) Acceptance Criteria :-</b> In – house physical analysis. Every year polythene film from supplier lot shall be check for food grade quality material from specified INDIAN INSTITUTE OF PACKAGING at the supplier cost. and original certificate should be produced for validation purpose along with attested Xerox copy.				
<b>Number of sound bags/Kg of polyfilm</b>				
Description	Bag Length	Min.yield of Bags per kg	Max yield of bags per kg	Average yield of bags per kg
500ml	14.8 cm	410( 54micron)	434( 51 micron)	425(52 micron)
1000ml	22.5cm	242( 60 micron)	260( 56 micron)	251( 58 micron)
200ml	9.5 cm	638( 54 micron)	676(51 micron)	663(52 micron)
Every supplier has to submit approved 3 copies L.S.D.(Light ,Standard ,Dark) in digital printing form as well as polythene film sample which will be used for acceptance of film for colour code.				

Manager(Q.C.)

Asst.General Manager (Dairy)