

5. MATERIALS

Body



Packing Bagg



Regulator



Pin Index



Mask



6. MANUFACTURE BLANK7. WORKMANSHIP AND FINISH

- 7.1 The Workmanship and finish of the Oxygen cylinder complete with mask shall be equal to the Sealed Pattern. It shall be the test of its class and to the entire satisfaction of the Inspector.

8. ACCEPTANCE TESTING PROCEDURE

- 8.1 TESTING The store shall be subjected to tests laid down in this specification and RELATED PARTICULARS (Clause-2) or to such tests which are deemed necessary by the Inspection Authority in order to determine whether they conform to this specification or otherwise.

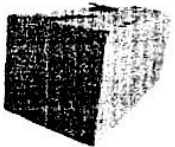
8.2 TEST - OXYGEN CYLINDER COMPLETE WITH MASK

Critical Test	Specified Limits
Capacity	1.0 lit
Working pressure	200 bar
Material (Cylinder body)	Aluminum alloy and non corrosive
Major Test	Up to minus 50°C
Operating Temp	99.5 - 99.9 %
Cylinder Filling	(Pure Medical Grade Oxygen)
Weight of cylinder	0.8 - 0.9 Kg (empty)
Accessories	
a. Valve	Pin-index, solid brass and non corrosive material
b. Regulator	Pin-index, flow rate 0 - 6 lpm in steps adjustable, solid brass and non corrosive material
c. Nasal canola & Face mask	a. Medical grade and should be high quality multichannel tubing and extreme comfortable b. 1 x Nasal canola and face mask will be provided with each set c. Size - adult
Carrying / packing bag	
(1) Fabric	Outer Inner

Contd.

(a) Material	Polyester	Nylon
(b) GSM	245 ± 5 g	60 ± 3 g
(c) Weave	Rip stop	Plain
(d) Colour	Snow white	Snow white
(2) Foam	I	II
(a) Type	Open Cell	Closed Cell
(b) Thickness	10 ± 1 mm	3.0 ± 0.5 mm
(c) Density	0.02 g/cc	0.10 g/cc
(3) Webbing	I	II
(a) Width	20 ± 1 mm	38 ± 1 mm
(b) Material	Polyester	
(c) Weight per m	20 ± 1 g	38 ± 1 g
(4) Buckle Material	Plastic	
(5) Eye let Material	Brass/Aluminum	
(6) Zip Performance (500 cycle)	Satisfactory	

8.3 Test – Carton Card Board

Major Test	Specified	
No. of Pies	07 Nos.	
Outer Paper Ply Weight/Sq meter	180 ± 5 gm	
Inner Paper Ply Weight/Sq meter	180 ± 5 gm	
Corrugated Paper Weight/Sq meter	120 ± 5 gm	
Paper Pasted with Corrugated Sheet	120 ± 5 gm	
Gauge of Stapler Pin	22 SWG	
Thickness of Pin	2 mm	

8.4 TEST – TWINE COTTON UN-DYED

Major Test	Specified Limits
Breaking Strength (B.G. 610 mm)	9 Kg (min)
Minor Test	
Circumference	3 mm ± 1 mm
No. of Strands	4 (Min)
Yarn Per Strand	6 (Min)

Weight Per 18.28 meter

19.49 gm

Count of Yarn

32 B Tex ± 5 Tex**8.5 Test - Plastic Hoops****Major Test****Specified**

Material

Plastic

Width

1.3 cm

Thickness

0.66-0.96 mm

B.C. Between Dig 7th

8.7 \pm Kg

Weight linear meter

6.8 \pm 0.5 gm**8.6 Test - Polythene Sheet / Polythene Bags****Major Test****Specified Limits**

Thickness (Polythene Sheet)

0.127 mm

Thickness (Polythene Bag large / Small)

0.06 \pm 0.01 mm**8.7 Test - Tin Stopper****Major Test****Specified**

Material

Mild Steel Tin

Length

Coated

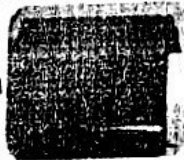
Width

3 to 3.5 cm

Height

13 mm

Thickness (Gauge)

1 \pm 0.2 cm34 \pm 2 BG**8.8 Test - Tape Adhesive****Major Test****Specified**

Length

66 Mtrs

Width

10 cm

Thickness

0.04 to 0.05 cm

Adhesion

Satisfactory

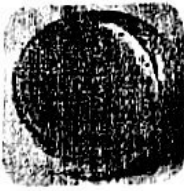
Adhesive Tape 10 cm wide

Shall be used

for sealing the

opening of

Carbon Can

**9 TESTING PROCEDURE - OXYGEN CYLINDER COMPLETE WITH MASK**

As per clause 2 in Test Standards

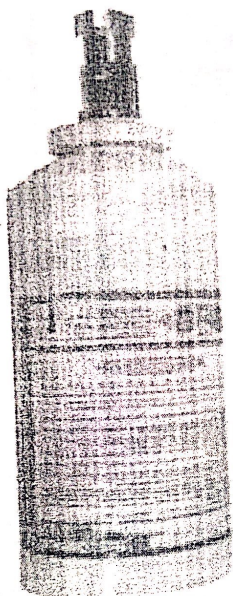
10 Batch / Lot Size and No. of Sample

Lot Size	No. of Sample
301 to 500	3
501 to 800	5
801 to 1300	7



PICTORIAL VIEW

Anx A



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