

PROCESS - FILLING AND PRESSING AS ENUMERATED IN APPENDIX-'A-1'

S/N	Items	Dimension	Filling (mg)	1 st Pressing Kg/cm ²	Filling (mg)	2 nd Pressing Kg/cm ²	Filling (mg)	3 rd Pressing Kg/cm ²	Filling (mg)	4 th Pressing Kg/cm ²	Filling (mg)	5 th Pressing Kg/cm ²	Filling (mg)	6 th Pressing Kg/cm ²
1	1 Sec Delay Tube	10 mm x 1.25 pitch, Height-14.45 ± 0.5 mm	CHEMICAL – 17 (40±5)	4-6	DM(50±5) + DC(100±5)	4-6	CHEMICAL – 17 (50±5)	4-6	-	-	-	-	-	-
2	1 Sec delay tube DM	10 mm x 1.25 pitch, Height-14.45 ± 0.5 mm	CHEMICAL – 17 (50±5)+ DM(400±5)	3-3.	CHEMICAL – 17 (50±5)	3-3.5	-	-	-	-	-	-	-	-
3	2 Sec delay tube DM	10 mm x 1.25 pitch, Height-17.05 ± 0.5 mm	CHEMICAL – 17 (50±5)+ DM(400±5)	3-3.5	DM(200±5)	3-3.5	DM(100±5)+ CHEMICAL – 17 (50±5)	3-3.5	-	-	-	-	-	-
4	2.2 Sec delay tube	11.95 mm x 1.25 pitch, Height-25 ± 0.5 mm	CHEMICAL – 17 (50±5)	4-6	DM(50±5) + DC(150±5)	4-6	DC(150±5)	4-6	CHEMICAL – 17 (50±5)	4-6	-	-	-	-
5	5 Sec delay tube	11.95 mm x 1.25 pitch, Height-25 ± 0.5 mm	CHEMICAL – 17 (50±5)	4-6	DM(50±5) + DC(200±5)	4-6	DC(200±5)	4-6	DC(200±5)	4-6	DC(200±5)	4-6	CHEMICAL – 17 (50±5)	4-6
6	3 Sec delay tube	11.95 mm x 1.25 pitch, Height-25 ± 0.5 mm	CHEMICAL – 17 (50±5)	4-6	DM(50±5) + DC(300±5)	4-6	DC(200±5)	4-6	CHEMICAL – 17 (100±5)	4-6	-	-	-	-
7	1.7 Sec delay tube	11.95 mm x 1.25 pitch, Height-25 ± 0.5 mm	CHEMICAL – 17 (50±5)	4-6	DM(50±5) + DC(100±5)	4-6	DC(100±5)	4-6	CHEMICAL – 17 (100±5)	4-6	-	-	-	-

PROCESS – ALUMINIUM PLUG MACHINE AS ENUMERATED IN APPENDIX-'A-2'
PROCESS (5 SEC AL PLUG)

CHEMICAL -17 (50±5)	Filling (mg)
4-6 kg/cm2	1st Pressing
DM(50±5)+ DC(550±5)	Filling (mg)
4-6 kg/cm2	2nd Pressing
DC(300±5)	Filling (mg)
4-6 kg/cm2	3rd Pressing
DC(200±5)	Filling (mg)
4-6 kg/cm2	4th Pressing
DC(100±5)	Filling (mg)
4-6 kg/cm2	5th Pressing
CHEMICAL -17 (100±5)	Filling (mg)
4-6 kg/cm2	6th Pressing

PROCESS (3 SEC AL PLUG)

CHEMICAL -17 (50±5)	Filling (mg)
4-6 kg/cm2	1st Pressing
DM(50±5)+ DC(350±5)	Filling (mg)
4-6 kg/cm2	2nd Pressing
DC(300±5)	Filling (mg)
4-6 kg/cm2	3rd Pressing
CHEMICAL -17 (100±5)	Filling (mg)
4-6 kg/cm2	4th Pressing