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IFTEX TIMES

MONTHLY MAGAZINE OF THE INDIAN FEDERATION OF WOVEN TECHNICAL TEXTILES
Vol. XXIX No. 5 May 2025

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Iftex
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Vol. XXIX No. 5 May 2025

President's Message

Dear IFTEX Members,

Greeting from IFTEX! On behalf of the Office Bearers and the Management Committee, I thank all the members for their continued support which has strengthened our efforts to pursue various issues pertaining to the Industry. I am happy to share a brief on the successful interactions and developments with various agencies and departments in the recent past.

BIS (Bureau of Indian Standards)

With the inputs and data provided by IFTEX the standards of 50 Kg Food Grain Bags (IS 14887: 2014) and 10 to 30 Kgs Food Grain Bags (IS 16208: 2015) have been merged **in the 38th Cordage Sectional Committee TXD 23 Meeting held on 22.05.2025.** The merger of both these standards will bring about uniformity in Production and Inspection process.

DROP TEST- PP Cement Bags (IS 11652:2017) & Block Bottom Bags (IS 16709:2017)

BIS constituted a committee to review the drop test methodology for the above bag types. The committee included:

* Dr. Amit Singhla (IIP Ahmedabad)
* Dr. Awdesh Sindh (Ultratech Cement Ltd.)
* Dr. Prakash Khemani (IFTEX)

Based on their findings, BIS has provided interim relief by revising the drop test procedure:

Bag Type	Earlier	Present	Earlier	Present
	PP CEMENT BAGS		Block Bottom Bags	
Top	1	Nil	1	Nil
Bottom	1	Nil	1	Nil
Face	2	2	2	1
Back	2	2	2	1
Right Side	1	1	1	1
Left Side	1	1	1	1
Total Drops	**8**	**6**	**8**	**4**

The earlier Top and Bottom Drop Tests, which IFTEX strongly opposed, have been discontinued.

PRINTING INK

In a significant development driven by persistent efforts of the IFTEX Technical Committee, the Bureau of Indian Standards (BIS) has now agreed that the bag weight as mentioned in the specifications is for unprinted bag—an element previously ambiguous. The Ink Weight, which varies between 0.97 grams to 1.52 grams per bag depending on the specific artwork as determined by the buyer, will now be factored into the final bag weight.

As a result of this inclusion, the average bag weight is expected to increase by approximately 1 gram. This adjustment is the outcome of a mutual understanding between buyers and sellers, ensuring fairer weight standards across transactions. With this clarification, the bags weights mentioned in any specifications is for unprinted bags whether it is Food grain, Fertilizer, Polymer or Cement etc

DCPC (Department of Chemicals and Petrochemicals)

The President and Vice President attended the important stakeholder meeting that took place at DCPC on 15th May 2025 regarding the **mandatory QCO Implementation** for:

- ★ PP Cement Bags (IS 11652:2017)
- ★ Block Bottom Bags (IS 16709:2017)
- ★ Postal Bags (IS 17399:2020)

IFTEX requested a **90-day extension** (from 6th June 2025 to 6th September 2025), citing bags specifications revisions by BIS. We are pleased to inform members that this **extension was approved by Mr. Deepak Mishra, Joint Secretary, DCPC,** and officially issued on 11th June 2025.

CPCB (Central Pollution Control Board)

IFTEX has formally requested BIS to develop a standard for **Recycled Material** blended with Virgin Polymer where 10% blending has become mandatory from 01st April'2025. Given that many woven sacks fall under IS standards and QCO mandates and involve high-speed, complex production processes—**uniformity in recycled content** is critical.

CPCB has released a **draft notification dated 3rd June 2025** regarding recycled material usage (already circulated via email to all the members).

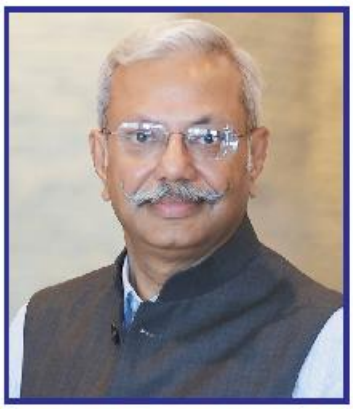
Reminder: The last date for **filing of EPR Annual Returns for FY 2024–2025 is 30th June 2025. Please ensure timely compliance.**

IFTEX will continue to represent and actively pursue all matters related to Growth, Development and Policy Advocacy of the Woven Technical Textiles Industry while upholding the interests of its members as Paramount.

Warm regards,

K.R. Padmaja Reddy
President, IFTEX

Vice President's Message



Dear Members of IFTEX,
Warm greetings!

As we step deeper into 2025, I take this opportunity to express my sincere appreciation to all our members for their proactive involvement and continuous faith in the activities of IFTEX. Each stride we make in policy dialogue, standardization, and technical evolution is powered by your support and trust.

Progress through Partnership

May has been a month marked by tangible progress—each discussion, each representation has pushed the envelope forward. Our engagement with BIS, CPCB, and DCPC has shown what can be achieved when industry and institutions work together with purpose and persistence.

The successful merger of the BIS specifications for 50 kg and 10–30 kg food grain bags marks a critical advancement in harmonizing standards. This alignment not only simplifies production but fosters inspection efficiency—a step welcomed by many in our industry.

Technical Interventions that Matter

As a member of the joint committee on drop testing for cement and block bottom bags, I am happy to inform that as a nominee from IFTEX, I played a pivotal role in redefining practical testing norms. The revised drop test protocols, which now eliminate the top and bottom drops, reflect a more realistic handling simulation. These are not just procedural wins—they represent significant operational fairness for our manufacturers.

Recognizing Nuance: The Ink Weight Breakthrough

One of the more nuanced developments has been the acknowledgment of printing ink weight in total bag calculations. This seemingly minor detail, long debated, has now been resolved through IFTEX's persistent efforts. By accounting for ink weight, the revised interpretation brings clarity and balance to buyer-seller dynamics, reinforcing fairness in transactions across the board.

Moving Forward with Preparedness

Our meeting with the DCPC on QCO implementation was both timely and constructive. The 90-day extension secured through IFTEX's representation allows our members the necessary window to adapt to revised specifications—a reflection of regulatory responsiveness to legitimate industry feedback.

Simultaneously, developments around the use of recycled material have moved a step forward. The draft notification by CPCB is a welcome step, and we remain committed to ensuring that the final guidelines recognize the operational realities of our sector.

Looking Ahead

The journey of standardization and compliance is an ongoing one. IFTEX remains steadfast in its mission to be a bridge between the industry and policy. As Vice President, I assure you of our continued engagement at every level—technical, regulatory, and strategic.

As always, I urge all members to stay updated and compliant—especially with the upcoming deadline for annual return filings by June 30th. Let us ensure our foundation remains strong through diligence and mutual support.

Thank you once again for your contributions to this shared endeavor. Together, we will continue to shape a resilient and future-ready technical textile ecosystem.

Warm Regards,

Dr. Prakash Kumar Khemani
Vice President, Indian Federation of Woven Technical Textiles (IFTEX)

BAG WEIGHT CALCULATION OF - FERTILIZER BAG (IS 9755 : 2021) as per BIS

ANNEX E

[*Table* 1, *Note* 3]

METHOD FOR CALCULATION OF MASS OF SACK

E-1 CALCULATION FOR MASS OF SACK

E-1.1 Total mass of sacks comprises of:

a) Mass of fabric;

b) Mass of stitching tape or threads, and

c) Mass of lamination.

E-1.2 Calculate the mass of sacks with the help of the following formula as the case may be:

a) Mass of tubular fabric:

Double fold stitching =

$$(L + 55 \text{ mm}) \times 2W \times M \times 10^{-6}$$

b) Mass of stitching tape or thread = $L_1 \times T \times 10^{-6}$

c) Mass of lamination:

Double fold stitching =

$$(L + 55 \text{ mm}) \times 2 (W + 5 \text{ mm}) \times M_1 \times 10^{-6}$$

Where,

L = length of sack, in mm;

L_1 = approximate length of stitching tape or thread, in mm;

W = width of sack, in mm;

M = Mass of fabric, in g/m^2;

T = linear density of stitching tape in tex; and

M_1 = mass of lamination, in g/m^2.

Symbol	Details	As per formula	As per BIS	As per Customer
M	Mass of fabric in gms/m^2		88.00	
M_1	Mass of lamination in gms/m^2		23.00	
T	Linear density of stitching tape in tex		100.00	
L	Length of sack in mm			925.00
W	Width of sack in mm			600.00
L_1	Length of stitching tape in mm (W + 25 mm each side) x 2 rows X 8 tapes / row	10,400		
G	Mass of tubular fabric in gms (L + 55mm) X 2 W X M X 10^{-6}	103.49		
G_t	Mass of stitching tape in gms L_1 x T x 10^{-6}	1.04		
G_M	Mass of lamination in gms (L + 55mm) X 2 (W + 5mm) X M_1 X 10^{-6}	27.27		
G_B	Mass of Un - printed Sack in gms	131.80		
G_{Ink}	Printing Ink weight in gms			2.00
$G_{Final\ Bag}$	$G_B + G_{Ink}$	133.80		

*** We have shared this above Excel Sheet of bag Weight Calculation with all the members by E-Mail.**

The items in Green are variable (Ex: Length, Width and Weight of Ink) which need to be changed as per the Bag Weight Specifications provided by the Buyer to arrive at the required Bag Weight as per BIS Specifications.

Kindly share this Excel Sheet with your buyer to arrive at the exact Bag weight as per BIS Calculation.

BAG WEIGHT CALCULATION OF - PP CEMENT BAGS (IS 11652:2017) as per BIS

ANNEX E

(*Table* 1, *Note*)

METHOD FOR CALCULATION OF MASS OF SACKS

E-1 Total mass of sacks comprises of;

a) mass of fabric, and

b) mass of stitching tape or thread.

E-2 Calculation of mass of sack with the help of the following formulae as the case may be:

a) *Mass of tubular fabric*:

1) For plain, non-gusseted sack;

$G = [L + (v \times 1.3) + 55\ \text{mm}] \times 2W \times M \times 10^{-6}$

2) For gusseted sack;

$G = [L + v + 1/2e + 55\ \text{mm}] \times 2W \times M \times 10^{-6}$

b) *Mass of stitching tape or thread*:

$G_t = L_1 \times T \times 10^{-6}$

where

G = mass of sack, in g;

L = length of sack, in mm (measured for stitch to stitch);

W = width of sack, in mm;

M = mass of fabric, in g/m^2;

v = width of valve, in mm;

e = width of gusset, in mm;

G_t = mass of stitching tape or thread, in g;

L_1 = length of stitching tape or thread, in mm; and

T = linear density of stitching tape, in tex.

Symbol	Details	As per formula	As per BIS	As per Customer
M	Mass of fabric in gms/m^2		79.00	
T	Linear density of stitching tape in tex		100.00	
L	Length of sack in mm			740.00
W	Width of sack in mm			500.00
v	Width of valve in mm			100.00
L_t	Length of stitching tape in mm (W + 25 mm each side) x 4 rows X 8 tapes / row	13,200		
G_t	$L_t \times T \times 10^{-6}$			
G_t	Mass of stitching tape in gms	1.32		
G	[L + (v x 1.3) + 55 mm] x 2W x M x 10^{-6}			
G	Mass of tubular fabric in gms	73.08		
G_s	Mass of Un - printed Sack in gms	74.40		
G_{Ink}	Printing Ink weight in gms			1.00
$G_{Final\ Bag}$	$G_s + G_{Ink}$	75.40		

*** We have shared this above Excel Sheet of bag Weight Calculation with all the members by E-Mail.**

The Items in Green are variable (Ex: Length, Width, Valve and Weight of Ink) which need to be changed as per the Bag Weight Specifications provided by the Buyer to arrive at the required Bag Weight as per BIS Specifications.

Kindly share this Excel Sheet with your buyer to arrive at the exact Bag weight as per BIS Calculation.

RAW MATERIAL SELECTION CRITERIA & TROUBLE SHOOTING FOR PP WOVEN SACKS AND FIBC

Dr. U.K Saroop
Advisor
Lohia Corp Limited Kanpur, India

Polymeric raw materials are very important to achieve the desired properties in the end-product. The present paper describes the various physical and structural properties of polypropylene (PP) resin in relation to various end use properties for woven sacks application which will help the customers and processors to choose appropriate grade selection. Also, troubleshooting tips are provided to get the best results in Raffia and FIBC products.

Key Attributes:

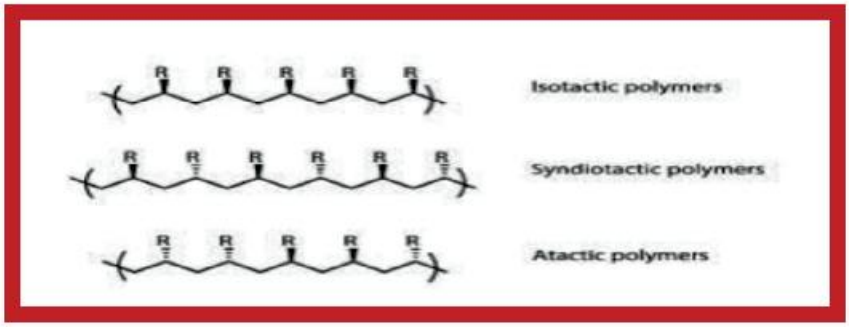
- Polypropylene grade for raffia tapes should be able to impart combination of:
  - Desired tape properties – mainly tenacity & elongation
  - Good extruder output
  - Desired filler intake
- Presence of enough tie molecules between crystalline lamella directs to higher molecular weight which will result in low MFI.
- Extruder output reduces with decreasing MFI & vice versa.
- For high denier/high tenacity tape application (FIBC) – lower MFI 1.5 to 2 is preferred.
- For general purpose application (cement and food grain sacks) – MFI 3.0 to 3.6 is preferred.
- For lower denier & lower tenacity application (wrapping fabrics) - higher MFI 4 to 6 is desirable for better filler acceptability.

Isotacticity: Polypropylene is a thermoplastic resin prepared by polymerization of propylene. There are three kinds of polypropylene: isotactic, syndiotactic & atactic polypropylene. Tacticity in PP occurs due to arrangement of methyl group in polymer chain. If all methyl groups are arranged on same side, PP is called Isotactic PP. If methyl groups are arranged in alternate fashion, PP is called Syndiotactic PP. If Group are arranged in random order, PP is called Atactic PP. These 3

types of PP re different from each other in terms of Melting point, glass transition temperature, melt strength, processing parameters etc. Commercially available PP grades consists of 85-95% isotactic part rest is atactic/syndiotactic.

- If higher the possibility of obtaining better tenacity is higher. Even if crystallinity developed during casting may be less if MWD is narrow, crystallinity development will get completed in stretching Out of process and product requirements additives are added at manufacturing levels of at processors end.
- Water carryover from waterbath to oven has to be low or nil, compulsory additives like antioxidants and acid neutralizers which lead to low water carryover are used.
- **For UV resistance:** UV additives giving desired duty, of food-contact approvals and also of low water carryover are used.
- Processors use antifibrillation masterbatches based on LDPE containing CaCO3 (upto 70%) at a level of 4% or lower. More than 4% addition is for filler incorporation & not anti – fibrillation. These avoid spontaneous splitting by increasing elongation at break at weak fibril boundaries.
- For increasing tenacity as well as increasing fibrillation desired for some applications (Ropes from tapes), HPE is added as per need.

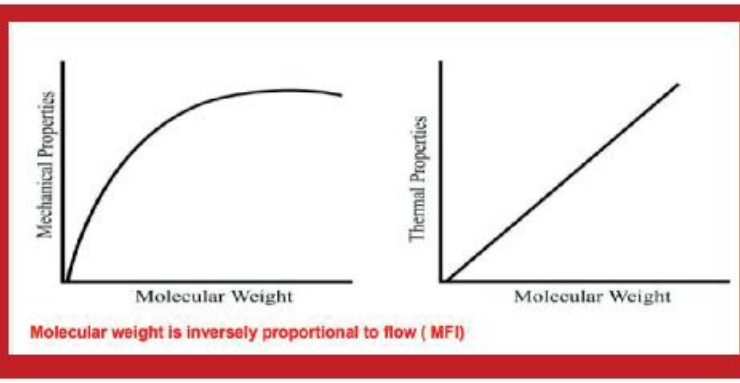
Structure Development:



- At the stage of casting in water spherulitic morphology gets developed in the film.
- The crystallinity developed will depend on the rate of cooling and kinetics of crystallization.
- Rate faster for wide MWD grades, for higher isotacticity grades & enhanced by nucleation. (not by nucleators but filler/pigments catalyst residues etc.)
- When heated in oven and stretched, the degree of crystallinity increases as full crystallinity is not developed during casting & temperature at which rate of crystallization is high is available in the stretching oven
- Beta crystallinity present in cast film (more probable for narrow MWD) gets converted to alpha.
- During stretching stage chains in amorphous regions get stretched in machine directions, crystalline lamella slips to get oriented perpendicular to stretching direction to form fibrillar morphology.
- Stretching beyond a limit will lead to inter-fibrillar slippages and breakages into fibrils.
- Attainment of higher degree of crystallinity & stretching of tie molecules and orientation of lamella lead to increase in tensile strength and reduction in elongation at break.

TROUBLESHOOTING OF PP RAFFIA APPLICATION

The mechanical strength properties of the final stretched product are dependent on the basic properties of the resin, the amount of orientation contained in the film before stretching, and the stretch ratio during orientation. Resin properties that affect the mechanical properties of the stretched tape include density, molecular weight and molecular weight distribution (MWD):



1. Raw Material Related

1.1 Density

- Stiffness and tenacity increase with increasing density
- Resistance to fibrillation decreases with increasing density

1.2 Molecular Weight (Melt Flow)

- Increase in MFI will reduce Tenacity, Elongation and melt viscosity. Generally, MFI around 3.5 is preferred.
- Polypropylene grades of higher melt flow tend to process easier than lower melt flow grades i.e., extrusion pressures are lower for a given extrusion rate.

1.3 Molecular Weight Distribution

- Molecular weight distribution is a function of catalyst system and polymerisation process. Molten PP is shear sensitive i.e., apparent viscosity decreases as applied pressure increases.
- PP with broad MWD is more shear sensitive than the one with narrow MWD. Hence broad MWD PP's are easier to process than one with narrow MWD.
- MWD is found to have little effect on physical properties of PP. Toughness increases as the molecular weight distribution (MWD) is narrowed.

1.4 Stereo Regularity

- Polypropylene has a methyl group attached to every other carbon atom. Unless these methyl groups are arranged in one position relative to the chain (isotactic arrangement), PP cannot crystallize.
- The crystallinity is responsible for the strength, stiffness and solvent resistance of PP. Higher the isotactic content, better the physical properties of the tape. Hence isotactic PP is preferred.
- Xylene solubles determines the percentage of lower molecular weight fraction in polypropylene. Higher xylene solubles will lead to decreased tenacity, increased shrinkage, stickiness and weaving problems. On the other hand, lower solubles will lead to tape splitting and draw breaks.

2. Additive Related

Commonly used fillers are CaCO3 and Talc. Talc is preferred for applications with more transparency. Other additives as polymer processing aids, Elastomers, colour master batch or UV stabilizer are added based on requirement.

2.1 Advantages of using Optimum level of CaCO3:

- CaCO3 improves heat flow in the melt composition since CaCO3 is having higher thermal conductivity and lesser specific heat than polymer.
- Reduces Splitting tendency
- Improves printability

Common Problems	Cause/Solution
More dust formation. Fine particle size filler should be used	May be due to coarser calcium carbonate used.
Poor adhesion of polymer & Filler	Polymer processing aid may be used.
Discoloration	Due to incorrect grade of Color Master batch

3. Machine Process Parameters Related

Major problems faced in tape plant and its solution is given below:

Common Problems	Cause/Solution
Tape Strength is Less	Due to either of the below: i. Die – Barrel higher temp. ii. Improper temp. of oven/platen/quench water
Elongation is Less	Due to either of the below: i. Stretch Ratio is high ii. Air gap is less iii. Annealing Ratio is high iv. Hot Air Oven temp. should be optimum v. Also, PP based elastomers or EVA can be added to improve elongation
Puncture in the Film	Due to either of the below: i. Raw Material is contaminated with foreign particles or moisture II. Less temp. In die or barrel and due to that improper mixing occur iii. Mesh chocked and due for cleaning

Tape Breakage	Due to either of the below: i. High stretch ratio. Stretch ratio should be reduced ii. Contamination or moisture in Raw material iii. Improper temp. (Set temp. of Barrel, Die, Quech Water or Oven)
Denier Variation	Due to either of the below: i. Improper mixing of filler ii. Temp. of Die zone varying iii. Die – lip gap should be adjusted properly iv. Proper Roller gap should be maintained
Roughness in the Film	Due to either of the below: i. Higher dosage of filler or Masterbatch ii. Low barrel and die temp. iii. Higher dosage of reprocess material
Screen Chocking	Due to either of the below: i. Contamination in raw material ii. Low barrel and screen changer temp. iii. High percentage of filler or masterbatch iv. Improper mesh combination
Fibrillation in the Tape	Due to either of the below: I. Stretch ratio is high ii. Spacer blades are not replaced on regular interval
Color Variation in the Tape	Due to either of the below: i. Improper mixing of material ii. Improper temp. setting of die iii. Denier variation iv. Use of bad quality masterbatch
Tenacity values are in range, but elongation is on higher side	Either of the changes below may be done: i. Reduce the air gap ii. Reduce the stretch ratio iii. Reduce the hot air oven temp.

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16	WATER COOLED CHILLER 100 TR, 120 TR & 140 TR	1 NO EACH
17	AIR COMPRESSOR MAKE ELGI TS15120H (12 BAR)	1 NO
18	AIR COMPRESSOR MAKE ELGI E11-10 (9.32 BAR)	1 NO
19	AIR COMPRESSOR MAKE ELGI E37-10 (9.5 BAR)	1 NO
20	AIR COMPRESSOR MAKE ELGI GNFE670079 (19.8 BAR)	1 NO
21	AIR COMPRESSOR MAKE ELGI E 55C-10 (290 CFM)	1 NO
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Automation in Woven Technical Textiles and Transforming the Industry towards 2030 and Onwards

Umesh Kumar Anandani
Secretary – IFTEX

The woven technical textiles industry is undergoing a remarkable transformation as automation is significantly enhancing the production of PP woven bags, manufacturing, design, and supply chain operations. With cutting-edge technologies driving efficiency, sustainability, and precision, automation has become a cornerstone for industry growth and innovation. Here is how automation is transforming the PP Woven Bag Industry landscape.

1. Automated Weaving & Fabric Production

Modern PP woven machines integrate automation to streamline the weaving process, ensuring uniform fabric quality and reducing material waste. Automated feeding systems optimize raw material usage, while AI-driven monitoring detects inconsistencies in real time.

The integration of artificial intelligence (AI) and machine learning (ML) is revolutionizing weaving processes. AI-powered looms analyse data in real time, detecting defects, adjusting tension levels, and optimizing production parameters automatically. These smart weaving systems ensure higher fabric quality while reducing material waste, making operations more cost-effective.

2. High-Speed Cutting & Stitching Systems

Advanced automatic cutting and stitching machines precisely shape PP woven bags, minimizing errors and improving consistency. These systems allow manufacturers to produce bags at high speeds—up to 2,400 bags per hour—while maintaining structural integrity.

3. IoT-Enabled Quality Control

Internet of Things (IoT) have sensors embedded in production lines continuously monitor fabric tension, stitch quality, and durability. Predictive maintenance algorithms analyse machine performance, preventing breakdowns before they occur, preventing costly downtime and ensuring smooth operations and ensuring uninterrupted production

4. Smart Looms & Adaptive Weaving

The next-generation smart looms have feature embedded sensors that dynamically adjust warp and weft tension according to fabric requirements. These adaptive weaving technologies allow for seamless production of high-performance woven technical textiles, including conductive fabrics, fire-resistant materials, and composite textiles used in aerospace, automotive and other woven textile applications.

5. Automated Design & Prototyping

Advanced computer-aided design (CAD) software, powered by AI, is streamlining the woven textile design and prototyping. There is automated pattern generation which accelerates product

development, enabling shop floor managers to visualize and test fabric structures virtually before physical production begins. This reduces lead times and minimizes resource consumption.

6. Smart Printing & Customization

Automated printing systems ensure precise logo placement and branding on PP woven bags. These systems use AI to adjust ink distribution and optimize print quality, reducing defects and enhancing visual appeal.

7. Robots in Manufacturing & Material Handling

Industrial robots are now playing a vital role in weaving and finishing processes. Robotic arms assist in yarn preparation, fabric cutting, and stacking, enhancing precision and minimizing human error. By automating repetitive tasks, manufacturers can increase production speed, reduce labour costs, and improve workplace safety and compliances.

8. Blockchain & Supply Chain Automation

Blockchain-integrated tracking systems improve traceability and transparency in PP woven bag production. Manufacturers can verify material sourcing, monitor inventory in real time, and streamline logistics, reducing delays and ensuring ethical production.

Transparency and traceability are critical in woven textile production, and blockchain technology is addressing these challenges. Automated supply chain management powered by blockchain ensures secure transactions, ethical sourcing, and real-time inventory tracking, reducing inefficiencies and promoting responsible manufacturing practices where stakeholders can position themselves at the forefront of innovation, ensuring long-term growth and resilience in an ever-changing market.

9. Energy-Efficient Production

Automation has reduced energy consumption by optimizing machine operations. Smart power management systems adjust production speeds based on demand, lowering costs and minimizing environmental impact. By embracing automation, PP woven bag manufacturers are achieving higher productivity, better quality control, and sustainable production practices and greater profitability in a very competitive landscape.

10. Digital Twin Technology

Digital twins—virtual simulations of physical production lines—allow processors to experiment with different weaving parameters without disrupting actual workflows. By testing designs and optimizing efficiency in a simulated environment, companies can reduce waste, enhance productivity, and make data-driven decisions with greater accuracy for their actual production lines.

Keeping in mind growing requirement for sustainability and eco-Friendly Innovations. Many processors are investing in biodegradable and recyclable PP woven bags to reduce environmental impact and carbon foot print.. The industry is shifting towards laminated PP woven bags, which offer better durability and reusability.

The adaption to customization and branding is also on the rise with companies focusing on high-quality printing and branding to enhance product visibility. Also customized woven bags with unique designs and reinforced structures are gaining popularity in this day and becoming the norm.

There is greater focus on growth in agricultural & industrial applications where PP woven bags are increasingly being used for packaging agricultural products like grains, fertilizers, and animal feed. Alongside this the construction and chemical industries are also driving demand for high-strength woven sacks. The increased demand from FMCG, food packaging, and logistics sectors is driving exponential market expansion and growth.

With the advent of rapid technological advancements taking place in manufacturing, smart packaging solutions with RFID tracking and QR codes are being integrated into PP woven bags. Simultaneously, automation in weaving, cutting, and printing is improving efficiency and reducing production costs.

We are moving towards an expanding Global Market with trade opportunities growing exponentially. The PP woven bag market is projected to grow at a CAGR of 4.2%, reaching $6.1 billion by the year 2034.

The PP woven bags industry is evolving with several key trends shaping its future. Automation is reshaping woven technical textiles, driving advancements in precision, efficiency, and sustainability. As AI, robotics, IoT, and digitalization continue to evolve, the industry is poised for a bright future where intelligent manufacturing will enhance global competitiveness by embracing automation and evolving technologies.

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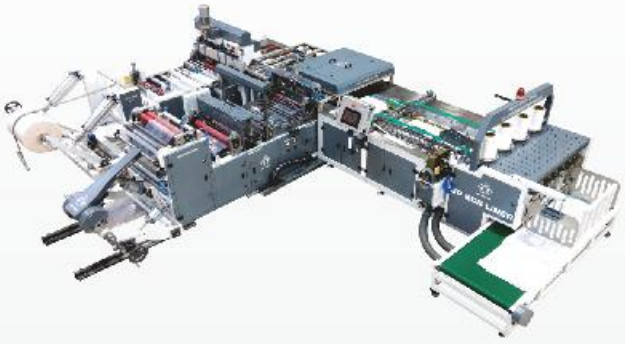

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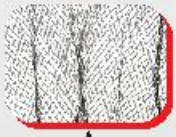

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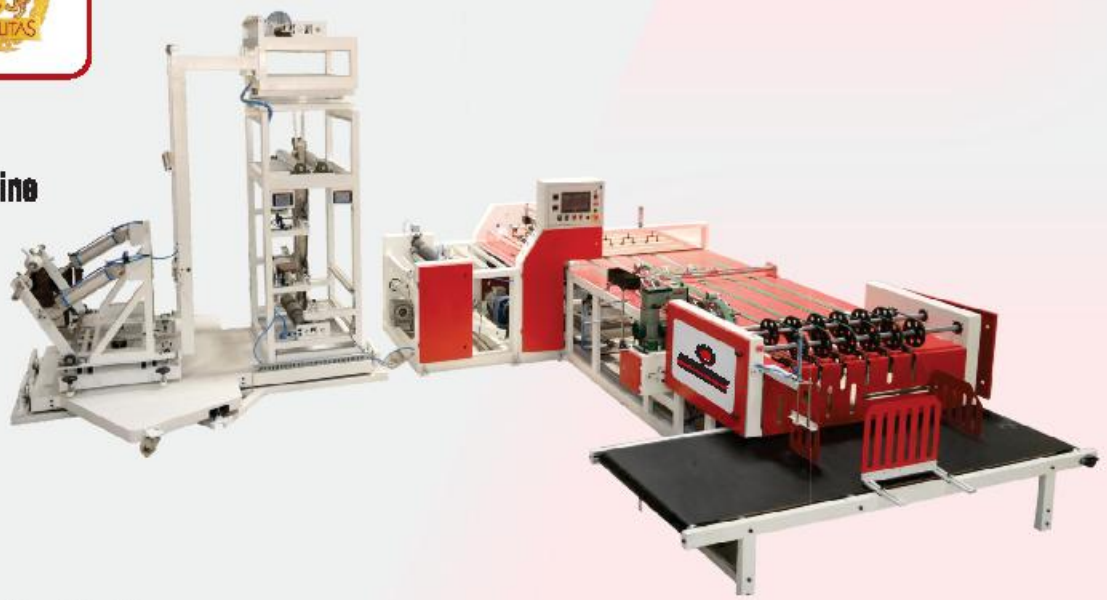

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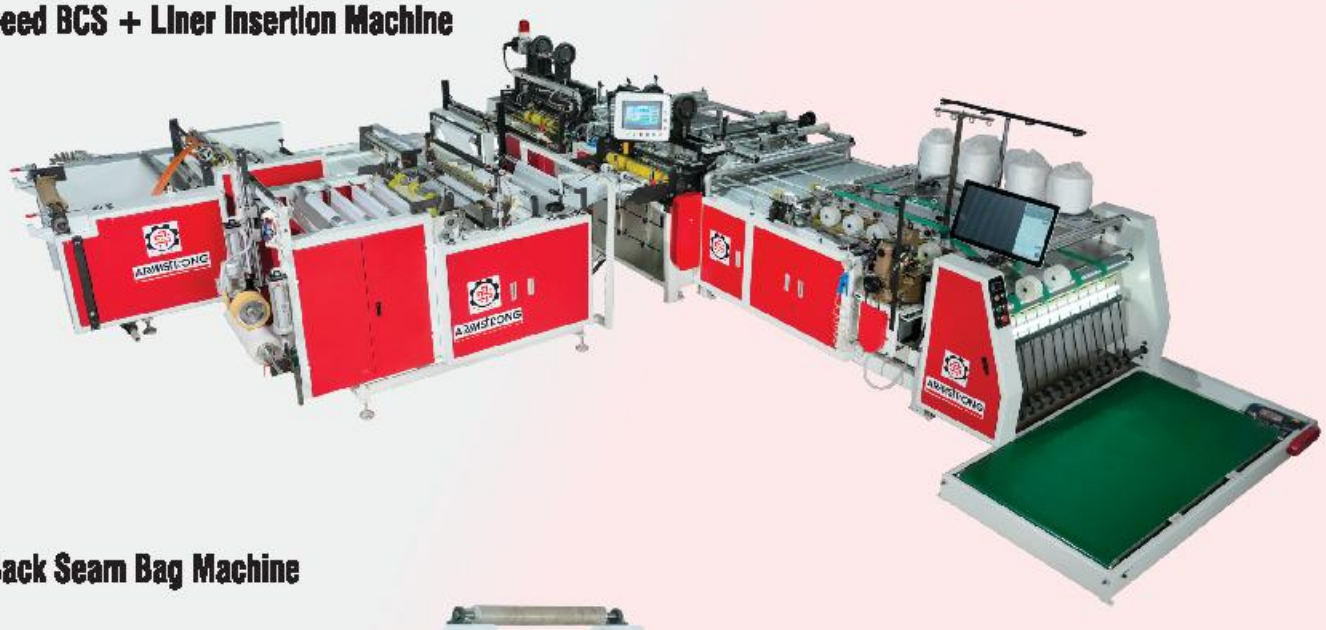

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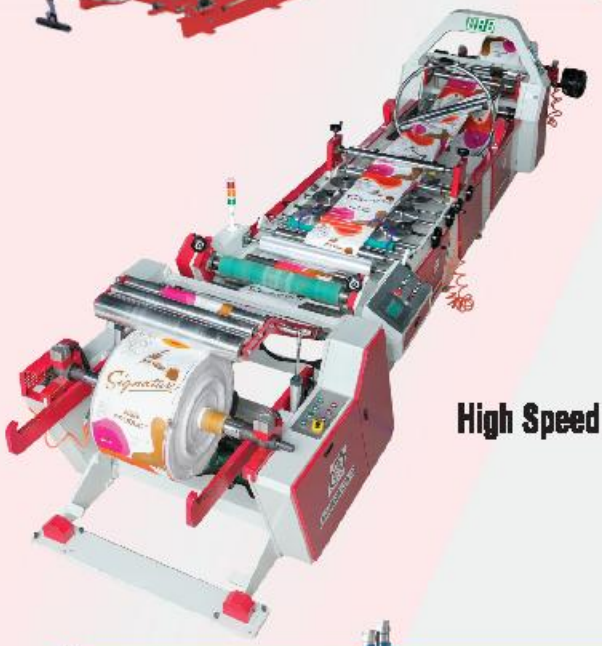

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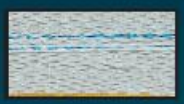

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Company Detail

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Points To Keep In Mind Before Procurement Of Cheese Pipe. (Depends Upon Winder)

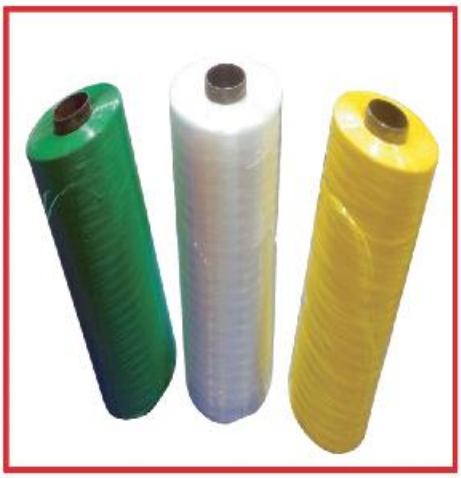
1) Weight: Should be between 195 gms to 280 gms per pc. (appx)

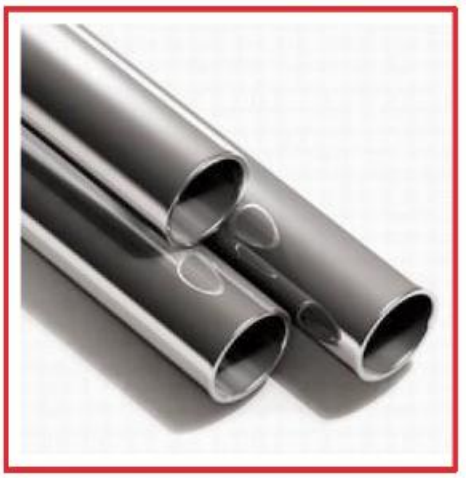
2) Inner Dia: Must be finished smooth & must be accurate in size & roundness. Inaccurate size and welding projection causes slippage or seizure on the winding spindle. It also causes damage to the holder components.

3) Thickness: should be that it gives optimum strength to pipe. Usually 1 mm to 1.5 mm thickness pipe is adequate.

4) Strength: The cheese pipe is subjected to high loop stress during winding and storage. The stress is due to two factors, the winding tension & the shrinkage tension. The adjustment of the cheese winder controls the winding tension and the latter is control by stabilizing adjustment of the tape plant. It is necessary to know in details the roles played by both kinds of tensions in the event of failure of pipe.

Grade	Description	Outer Dia. (mm)	Inner Dia. (mm)	Length (mm)	Weight (grams) ± 5grams	Tensile Strength		
						Mpa.	Vpn.	Kgs/mm²
H	High Tensile Cheese Bobbins	37	35	218	195	529	167	54
H Supreme	High Tensile Cheese Bobbins	37	35	218	195	1362	431	139
H power	High Tensile Cheese Bobbins	38	35	218	260	578	183	59
H power Supreme	High Tensile Cheese Bobbins	38	35	218	260	784	248	80
H Lit	High Tensile Cheese Bobbins	36.8	35	218	160	1558	493	159





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Mirror Like Finish
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Available in Black or Plain

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High Tensile Strength
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Super Enamel
Mirror Like Inner Finish
Steel Pipe of Aluminum
Weight

H- Power 260 ± 5Grams
In Build Strength
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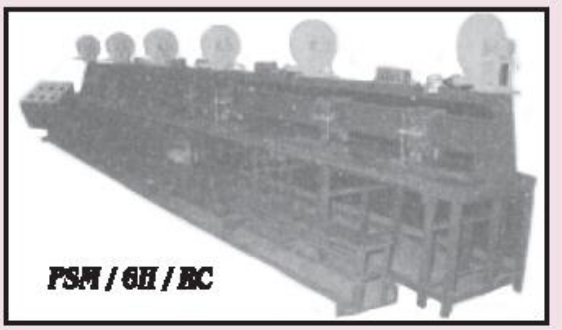

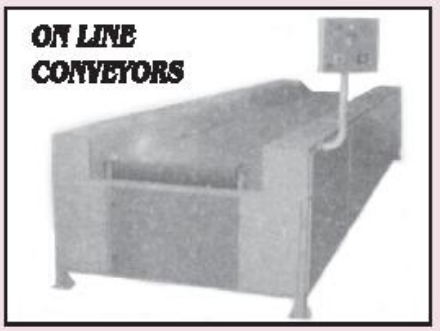

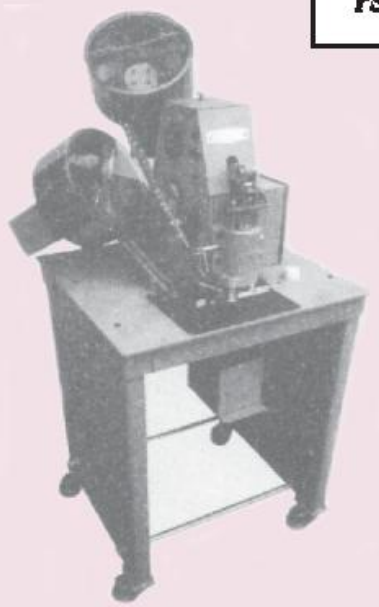

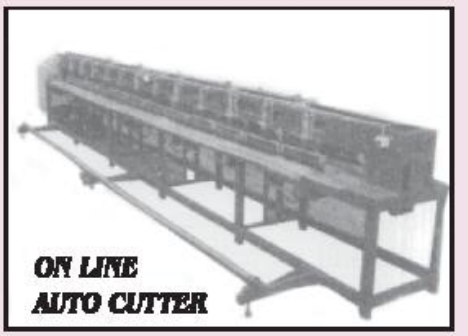

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- » Hydraulic Bale Press For Waste
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3.Reduction of mishandling
4.Improves quality of end product
5.Contains 2 hot air blower of 0.5HP with 7.5 KW heater with PID installed Electric Panel.

Machine Size (L X B X H) In MM	Mixing Capacity Kg / 15 min
1000 X 1000 X 1000	150

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5. Cutting length accuracy of machine is ±1mm.
6. Production capacity 20-35 bags per min depending on the sewing machine.

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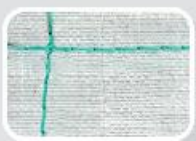

AS - 603 DR

- Single Needle - Plain Feed - Double Thread
- Double Locked Chain Stitch Sewing Machine

AS - 602 HR

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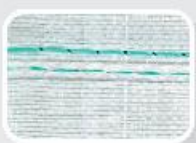
- Over seaming (Hiracle) Sewing Machine



AS - 606 UDDR

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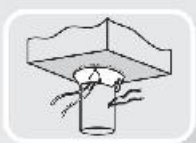

AS - 802 VMC

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FEATURES

- Choice of printing both sides in 5+1, 4+2, 3+3 colour combinations.
- A turret un-winder with facility to run the machine without stopping, while loading fabric rolls and unloading empty core
- A surface winder, with provision to run the machine without stopping, while changing the wound fabric roll and placing fresh core.
- An Edge Guiding System, with Ultrasonic Edge Sensor and Electric Actuator.
- Chamber Doctor Blade System, with Ink Circulation System, shall be offered for all the stations, in lieu of Ink Roller System (Option)
- Ceramic Anilox rollers with cells arranged at 200 to 300 lpi, with Special Mountings for Quick Changing (Option)
- Tension Control System.
- Page registration control adjustable manually to move the print drum radially.
- Print drum Axial adjustment required using a hand wheel to adjust the printing
- location axially marginally. (for about 30 to 40 mm)
- Hot air blower system, for drying the ink.
- Main motor with VFD and control panel to have all the controls in a HMI panel, with running hours meter and Energy meter.
- The working width shall be 850mm and the machine speed shall be 100m/min, with a maximum repeat length of 1200mm. The Stereo Roller Mountings shall be with quick release provisions, to facilitate easy changing of Stereo Cylinders.
- Two Air Shafts to mount 75mm cores for the Unwinding side and Two Air Shafts of the same core size, for the Winding Side shall also be provided (Option)
- 1 Ton Electric Rope Hoist, mainly for lifting print drums on both sides.
- Static Discharge Provision & Corona Treater to provide up to 42 Dynes Treatment (Option)

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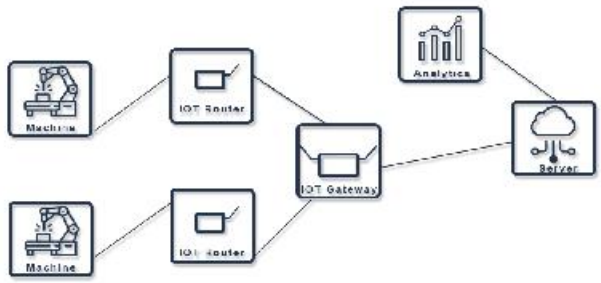


IOT

SENSE | MONITOR | ANALYSE

Connectivity

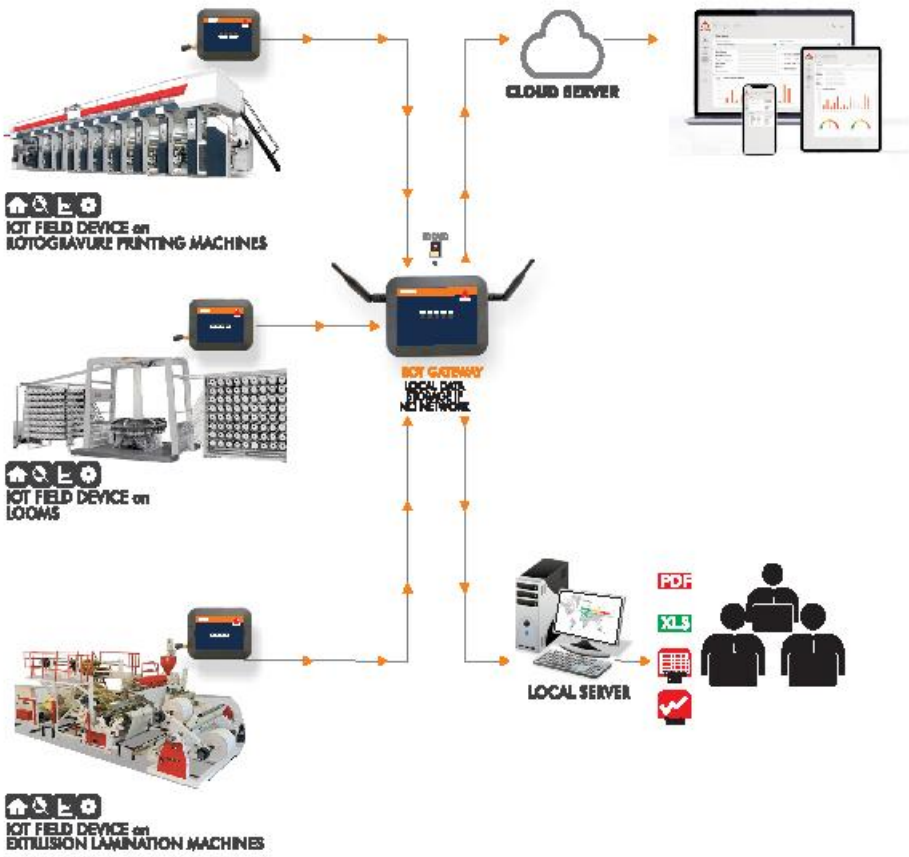
Allowing users to log and analyze key performance indicators such as OEE, Alteem's Dashboard Portal is at the heart of connected services. Showing historical data and generating reports, it allows users to gain insights to produce real operational improvements, and can be used remotely via laptops and smart phones.

Remote Monitoring

Remote Monitoring provides live data of all connected machines, including average speeds, production output, uptime, downtime, energy consumption, job planning, and much more. This data can then be used to improve operations and enhance productivity.

Downtime Monitoring

Downtime monitoring improves overall production efficiency by giving live and historical data of the machines to make sure they are performing as per the required capacities.



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420R		9.0 x 4.8
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440R		10.5 x 2.8
480R		13.5 x 7.5
65/0		6.5

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		11164005800	
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2.	NOVA8 / LSL8 36 BELTS / ACE8 / NOVA LENO4 LENO4 / LSL8 / LSL10 / LSL630 / NOVA8 NOVA10 / NOVA12 / NOVA81 / NOVA82	11158951500
		11401084000
3.	LSL8 36 BELTS / LENO4 / LSL8 / LSL6	11401184000
4.	LSL6 30 BELTS	----------
5.	LSL610	11158954200
6.	LSL610 / NOVA8 / NOVA10 / NOVA12 NOVA81 / NOVA82 / NOVA82	11158954300
7.	LSL610	11158954000
8.	LSL610	11158954100
9.	LSL620	11158957500
10.	LSL620	11401186000
11.	LSL620	11158956700
12.	LSL620	11401186000
13.	NOVA82	11401827000

S NO.	DEF. PULLEY	REF. NO.
1.	NOVA8 / ACE8 / NOVA LENO4 / NOVA8 NOVA10 / NOVA12 / NOVA81 / NOVA82 / NOVA82	11131611010
2.	NOVA8 / LSL8 36 / 30 BELTS / ACE8 / LENO4 NOVA LENO4 / LSL8 / LSL10 / LSL830 / NOVA8 NOVA10 / NOVA12 / NOVA81 / NOVA82	11131509920
3.	LSL6 36 BELTS	11158327200
		11130507200
4.	LSL6 30 BELTS / LSL620	11130507900
5.	LENO4 / LSL8 / LSL10 / LSL820	11158327200
6.	LSL610	11130546100
7.	LSL610	11131511010
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