

VAISHAL PATLIPUTRA DUGDH UTPADAK SAHKARI SANGH LIMITED

PATNA DAIRY PROJECT

Feeder Balancing Dairy Complex, Phulwarisharif, Patna-801505

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PDP:PUR:FBD 1183

DATE- 14.05.2025

Dear Sir,


We are interested in purchasing of the following items. In case you can supply the same, you may send your quotation in sealed cover addressed to the Managing Director address given above superscribing on the top of the envelop quotation for item to **SS 304, MILK CAN WITH LID** as to reach as on or before **30.05.2025**.

All rates must be F.O.R FBD Patna on door delivery basis.

S.No.	Item	Specification	Quantity
1	SS 304, MILK CAN WITH LID CAPACITY 40Ltr. +2% PUNCHING ON NECK & TOP OF LID VPDUSS LTD.	T.S AS PER ENCLOSED ATTACHMENT	400 can.

Thanking You

Yours faithfully


Dy. Manager(MM)

TECHNICAL SPECIFICATION OF 40 LTS. CAPACITY SS MILK CANS

1. FUNCTIONAL REQUIREMENTS:

Cans shall be used for collection and delivery of milk from milk producers to Dairy Co-operative Societies (DCS), transportation of milk from milk collection centres to Dairy Plants and for handling milk in the chilling centre / Dairy plants. The Milk Cans with lids shall be manufactured as per IS 16440 : 2016 with latest amendments.

2. DESIGN REQUIREMENTS:

Dimensions:

- Normal Capacity : 40 Litres + 2%
- Total height, mm (without lid) : 591 ± 4
- Internal Height, mm (without lid) : 567 ± 4
- External dia. at base, mm : 348 ± 3
- Internal dia. of body, mm : 342 ± 3
- Internal dia. at neck, mm : 200 ± 0.5
- Minimum hardness (Brinell hardness) : 200 BH for body, 150 BH for bottom.
- Minimum weight, Kg (Can plus lid) : 8.4 Kg
Can 7.2 Kg + Lid 1.2 kg (approx.)
- Maximum weight, Kg (Can plus lid) : 8.7 Kg

3. CAPACITY :

The rated capacity of the can shall be taken as the quantity of water measured, in litre, which fills the Can to the junction of the shoulder and the neck. This quantity shall be within a tolerance of +2 percent of the normal capacity.

4. MATERIAL OF CONSTRUCTION :

The Can body shall be fabricated from the sheet or coil of stainless steel having thickness of 1.2 ± 0.05 mm conforming to SS 304 grade of IS 5522. The handle shall be made from round bar of stainless steel of diameter 12 mm and the bottom ring shall be made from sheet or coil of stainless-steel having thickness of 2 mm conforming to SS 304 grade of IS 5522. The lid shall be fabricated from two stainless steel sheets of suitable thickness conforming to SS 304 grade of IS 5522.

After fabrication, minimum thickness for different parts of finished Cans shall be as below:

- Can Body : 1.0 mm.
- Can Bottom : 1.1 mm.
- Can Neck : 0.95 mm.
- Lid cup : 0.8 mm.
- Lid Saucer : 1.0 mm

5. WELDING :

The Can shall be welded by TIG or MIG process with argon as inert gas medium and only. AWS ER 308 L filler wire shall be used.

Review

Being a thin sheet material parent material fusion welding technique may be applied.

6. FINISH:

On visual examination there shall be no cracks, notching or porous patches in the welded surfaces and the surface adjacent to the weld. The weld surface shall be regular and even. All welded joints, inside surface and outside surface shall be finished smooth to minimum 150 grit or maximum Ra value 0.48 μm to provide a sanitary finish. The can surface including the taper neck portion should be wrinkle free. There should not be any sharp corner. All such corners shall have a minimum radius of curvature of 25 mm.

7. HEAT TREATMENT AND PASSIVATION:

The Can and Can lid shall be heat treated to relieve the stress developed during deep drawing and spinning. Thereafter complete surface shall be passivated with standard Passivation solution to enhance corrosion resistance of the base material and welded surface.

8. MARKING:

Each can shall be marked legibly and permanently with at least following particulars:

- (a) Manufacturer's name or initial or trade-mark, if any;
- (b) Rated capacity of the can, in litre;
- (c) Buyer's logo or identification mark;
- (d) Batch or code number and year of manufacture;
- (e) Material of construction AISI304 grade;
- (f) Capacity mark on inside surface of the can.

9. TEST & CERTIFICATION:

The following tests (As per IS 16440:2016 with latest amendments) shall be carried out on the Can & lid by the Supplier:

- (a) Conformity of the material of construction of Milk Can along with its lid to AISI - 304 grade (Stainless Steel - food Grade) with its chemical composition.
- (b) Joints & Surface finish check.
- (c) Pressure test for leakage / bulging.
- (d) Drop test at rated capacity.
- (e) Body construction,
- (f) Hardness test,
- (g) Weight of Can with lid & its capacity in litre.
- (h) All parameters of dimension & thickness of whole body along with lid.
- (i) Certification (test report) for welding i.e. Can has been welded by TIG or MIG process and ground smooth.
- (j) The bidder shall furnish the hard copy of original & single test reports along with laboratory sealed sample of Milk Can & lid for all above test confirming the results of the test conducted as per IS 16440 : 2016 with latest amendments by Central Gov't lab. or NABL accredited laboratory.

SHAPE & DIMENSION OF SS 304 MILK CANS

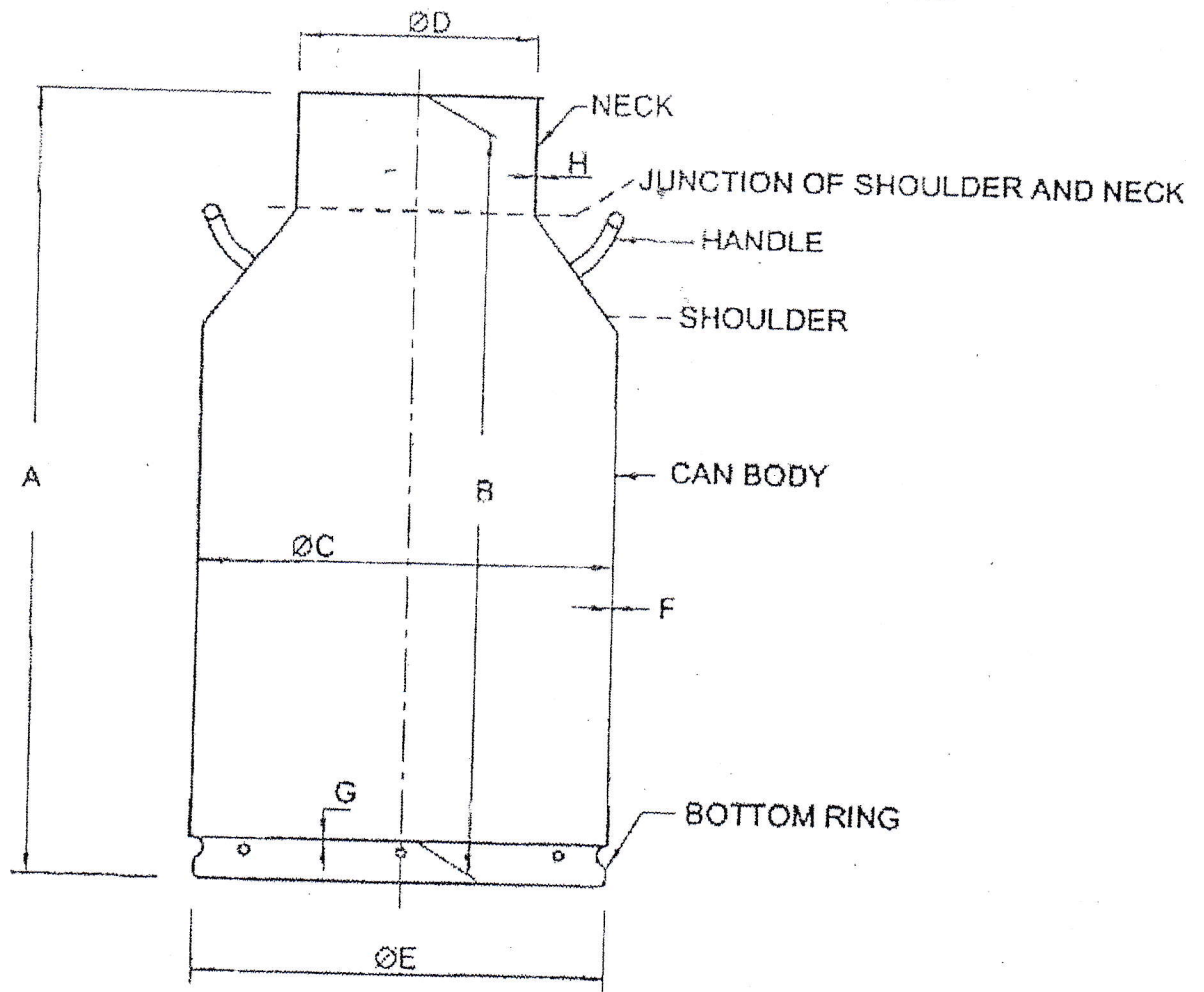


FIG 1 TYPICAL STAINLESS STEEL MILK CAN — TRANSPORT TYPE (20, 30, 40 AND 50 LITRE)

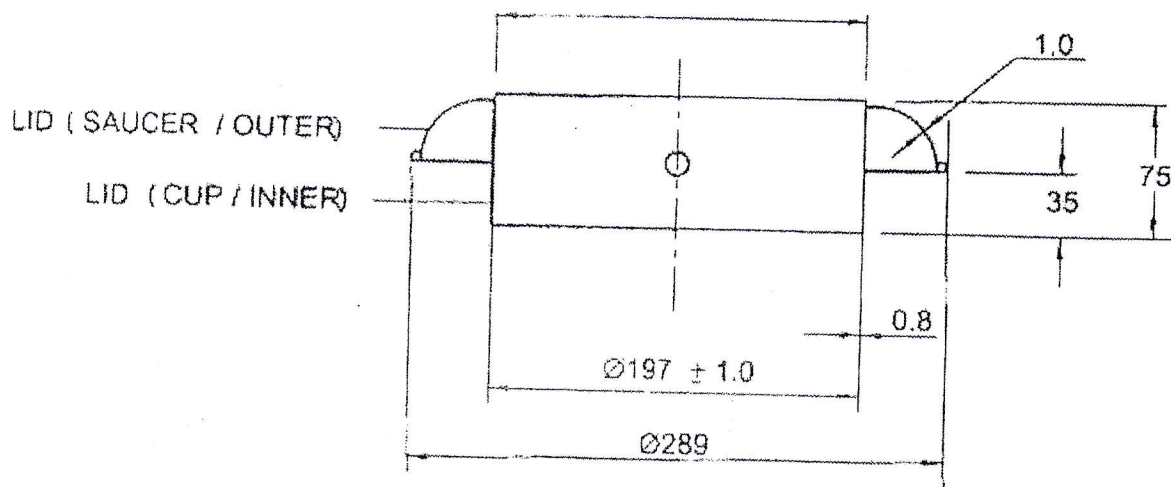


FIG 2 LID FOR STAINLESS STEEL MILK CAN — TRANSPORT TYPE (20, 30, 40 AND 50 LITRE)

A = Total height (without lid).
 B = Internal Height (without lid).
 C = Internal dia. of body.

D = Internal dia. at neck.

E = External dia. at base.

F = Can Bottom thickness.

E = Can Body thickness.