

# AMULFED DAIRY , GANDHINAGAR

AFD:PUR:ENQ:2020:014

25.01.2020

Tender For Roto Gravure Toluene Free( TF) Printing Inks and Medium

Subject: - Tender enquiry for Roto-Gravure Printing Inks and medium

We invite your most competitive rates for supply of various Printing Inks and medium to our PFP unit subject to following:

(1) Specifications: As per Annexure 1

(2) Quantity:

Printing Ink (All colors): 1.5MT/Month  
Diluent : 5 MT/Month

(3) Contract Period: 01.03.2020 to 31.08.2020

(4) Terms and Conditions: Annexure-2.

(5) The quotation format is attached as per Annexure-3. Kindly send your quotation as per prescribed format only

(6) Sealed tenders super scribing on top left hand cover " AFD:PUR:ENQ:2020:014" should be clearly mentioned. Without this it is liable to rejection. It should reach to The General Manager, AmulFed Dairy, Near Indira bridge, Vill: Bhat, Dist: Gandhinagar-382428.

(7) Last Date of Tender Submission : 18.02.2020 before 16:00 hr

(8) This enquiry include 12 pages

Thanking You,  
Your's faithfully,

Purchase dept.

Enclosed: Annexure-1/2/3

**ANNEXURE-1**

## **SPECIFICATION OF PRINTING INK FOR ROTOGRAVURE SURFACE PRINTING ON WHITE OPAQUE MILK FILM MANUFACTURED FROM LDPE-LLDPE BLEND**

### **Scope:**

This specification prescribes the scope of printing ink specifications to be used for rotogravure surface printing on a white opaque milk film which is co-extruded made out of LDPE-LLDPE blend and its used is to pack milk for human consumption.

### **Substrate:**

Polyethylene white opaque film made out from LDPE-LLDPE blend having thickness of 50 / 60 /70/80/110 micron. The milk film contains medium grade slip additives and has one side segmented corona treatment having minimum 38 dyne /cm<sup>2</sup> surface tension.

### **Process:**

Film is printed on a Rotogravure printing machines having speed of maximum 200 meters/minutes where in chemical / electronic engraved cylinders are used.

### **General requirements:**

- 1) The ink shall be used for printing of polyethylene film by rotogravure surface printing. Ink shall conform to IS 5931:1970 and be permissible under PFA rules. Color and Ink used shall be approved for packaging of food material especially milk for human consumption and confirm to all applicable food and drugs regulations. The Ink and the resultant printing shall have good deep freeze, fat, scratch, scuff resistance, gloss, strength and opacity. The print shall be neat and clear in all respects.
- 2) PFP will use the Thinner 60-70% for reducing the viscosity of the Ink, Which is the combination of Ethyl Acetate & Ethyl Alcohol. Ink manufacturers are required to make ink in such a way that by adding the above reducer quantity viscosity of ink shall be between 16-20 sec.
- 3) The ink should be free from any abnormal smell and visual impurities and after printing, ink (which is made out from resin, pigments and solvents) must not contain or retain any smell on printed film in any how, if any rejection found due to above then supplier will be responsible for the same.
- 4) Ink must not migrate after printing and must not come into contact with the milk in any case.
- 5) Ink without COA (certificate of analysis) as per attached format will not be acceptable.
- 6) Before making the actual supply of inks, supplier must visit PFP if required and take details of standard shades and draw down samples of the same from PFP QA division.

### **Specification for Solvents:**

- 1) Reducer: Ethyl acetate (80%), Ethyl alcohol (20%)
- 2) Require GC Report in each & every supply along with COA.
- 3) Solvent should be Generic can be run with other vendor inks.

## **Specification for inks/medium:**

### **1) Materials:**

**Resin and Pigments:** Alcohol based Polyamide, Nitro cellulose or Polyurethane resin and organic pigments can be used for making ink which must be sourced from best supplier so that ink quality must remain best as per the requirements and end use.

**Solvents:** Ethyl Acetate(80%) & Ethyl Alcohol(20%) can be used for the manufacturing ink.

### **2) Solid content: It must be a minimum 32 % in all the inks listed in Annexure-1B and minimum 20 % for the medium.**

**3) Viscosity:** It must be minimum 25 second at room temp in all the inks and minimum 18 second for medium at room temp by B4 cup.

**4) Particle size:** It should be less than 5 micron.

**5) Shade:** Should be match with standard reference sample/pantone No. or by draw down sample as per IS: 6931-1972.

**6) Opacity:** Should be match with standard reference sample/pantone No. or by draw down sample as per IS: 6931-1972.

**7) Strength:** Should be match with standard reference sample/pantone No. or by draw down and print sample as per IS: 6931-1972

### **8) Resistance:**

1. **Deep freeze resistance:** Ink must not be failed in deep freeze resistance test for 12 hrs. in deep freeze temp i.e. below 8<sup>o</sup>C.

2. **Fat resistance:** Ink must not be failed in fat resistance for minimum 12 hrs. in minimum 6.0 % fat milk at a temperature of about 8<sup>o</sup>C.

3. **Scratch resistance:** Ink must not be failed in scratch resistance test by finger nail.

4. **Scuff/Rubbing resistance:** Ink must not be failed in scuff resistance test as per IS: 6931-1972.

5. **Water Resistance:** Ink must not be failed in water resistance test as per IS: 6931-1972.

**9) Adhesion/tape test:** Ink must not be failed in tape/adhesion test.

**10) Gloss:** Ink must have a good gloss.

**11) Drying:** As per IS: 6931-1972.

**12) Dispersion:** Ink must have a good dispersion as per IS: 6931- 1972.

**13) Packing:** Printing ink must be packed in fresh, hygienic, strong leak proof drums of @ 20 kg capacity with proper sealing to avoid any adulteration of the ink. Drum must contain label with details like batch no./lot no., date of mfg., ink name, ink

code, hazardous information, solvent recommendation with usage ratio, ink supplier name with full address etc as per applicable standards.

**14) Shelf life:** Printing ink must have minimum 6 months self life.

**Procedure for New Vendor development of Ink:-**

1. As per given L\*A\*B Value Supplier need to send the shade card drawn in Felxo Proffer with 50% Reduction & on 300 LPI. Delta E needs to be come below 3 measures in Spectrometer.
2. If delta E comes below 3 then we will take machine trail of same.
3. When Ink Send for Machine Trail following documents require along with the Ink.
  - A. COA (As per attached format only)
  - B. MSDS of Ink
  - C. Gas Chromatography Report of Ink Supplied Ink. (Third party testing from any reputed NABL accredit laboratory)

**Procedure for New Vendor development of Solvents:-**

1. Supplier need to given sample of Solvents approximately 200 mL along with Gas Chromatography Report of same through reputed NABL accredit laboratory.
2. If found then we will take machine trail of same.
3. When Solvent Send for Machine Trail following documents require along with the Solvent.
  - A. COA
  - B. MSDS of Solvent
  - C. Gas Chromatography Report of Ink Supplied Ink. (Third party testing from any reputed NABL accredit laboratory)

**ANNEXURE 1A**  
**Certificate of Analysis**

<b>Document No.:</b>		<b>Date.:</b>		<b>Approved By:</b>	
<b>Customer Name:</b>	M/s AMULFED DAIRY(PACKAGING FILM PLANT)				
<b>Packing:</b>		<b>Quantity/Issue Date:</b>			

<b>Std.Sample No.:</b>		<b>Product:</b>	
<b>Date:</b>		<b>Product Code:</b>	
<b>Source:</b>		<b>Batch No./Insp No.</b>	

No	Tests	Specifications	Results	Method
1	Adhesion	It must not be failed		By Scotch Tape
2	Deep Freeze Resistance	At below 8° C for 12 hrs in milk & water		Putting sample in deep freeze temp.(12 hrs)
3	Dispersion In Microns	Below 5 Microns		Hegmann Gauge As per IS :6931-1972
4	Drying	It must be passed as per standard		As per IS :6931-1972
5	Gloss	As per standard		Visual
6	% NVM (solid content)	minimum 32% for inks & Minimum 20% for the Medium		Putting sample in oven As per IS :6931-1972
7	Shade	As per PFP standards.		As per IS :6931-1972
8	Strength (for inks)	As per PFP standard sample (100%)		As per IS :6931-1972
9	Tack	It must not be failed		As per IS :6931-1972
10	Viscosity in sec.	Minimum 25 sec for inks & 18 sec for medium		by FCB4 at room. temp.
11	Fat Resistance	At below 8° C for 12hrs in 6% fat		Putting sample in 6.0% fat milk at freezer temp.(12 hrs)
12	Resistance to Rubbing/scratch	It must not be failed		As per IS :6931-1972
13	Smell	Ink must not have any obnoxious smell		Panel of 4%
14	Water Resistance	It must not be failed		As per IS :6931-1972
15	Opacity	Should be matched as per standard		As per IS :6931-1972
16	Solvent Retention Limit	Nil		

Note: Printing Ink & Medium is manufactured, In general As per the requirement stipulated in IS 15495-2004 on "Printing Ink for Food Packing- Code of Practice". These are safe for printing of Film having indirect contact to Food stuff.

	<b>Proposed By:</b>	<b>Reviewed By:</b>	<b>Approved By:</b>
<b>Name:</b>			
<b>Designation:</b>			
<b>Sign:</b>			

## ANNEXURE 1B

SR.NO	RUNNING INK SHADES NAME
1	ROTO INK, AMUL RED (P199C)
2	ROTO INK, BLUE (P3005C)
3	ROTO INK, AMUL SHAKTI GREEN
4	ROTO INK, NORMAL D.F YELLOW
5	ROTO INK, D.K. RED -P 187 C
6	ROTO INK, AMUL BLACK (P447 C)
7	ROTO INK, PANTONE 104 C YELLOW
8	ROTO INK SUGAM VIOLET
9	ROTO INK MAGENTA
10	ROTO INK, CLT BROWN (P721C)
11	ROTO INK, SUMUL VIOLET
12	ROTO INK, SAGAR BLUE
13	ROTO INK, AMUL GREEN 368 C
14	ROTO INK, AMUL ORANGE
15	ROTO INK, AMULFED DAIRY ORANGE
16	ROTO INK, AMUL SPECIAL ORANGE
17	ROTO INK, UTTAM GOLDEN YELLOW
18	ROTO INK, YELLOW 602 C
19	ROTO INK, AMUL SUMUL BROWN
20	ROTO INK, AMUL PURPLE (P682 C )
21	ROTO INK, MODFLEX BLUE
22	ROTO INK, UTTAM SHAKTI OARANGE
23	ROTO INK, AMUL 124 C YELLOW
24	ROTO INK, AMUL WHITE
26	TOLUENE FREE DILUENT

**Note: Before making the actual supply of inks, supplier must visit PFP if required and take details of standard shades and draw down samples of the same from PFP QA division.**

**ADDITION AND SUBSTRATION IN SHADE ARE POSSIBLE IN ADDITION TO ABOVE LISTED SHADES DURING THE MID OF THE CONTRACT.**

## ANNEXURE- 2

### **GENERAL TERMS AND CONDITIONS FOR SUPPLY OF PRINTING INKS:**

1.0 Detailed specifications are given in the enclosed Annexure 1. All supplies shall be strictly as per the enclosed specifications only.

#### QUANTITY:

2.1 The estimated requirement during the period is specified along with the specifications and is an estimate only.

The quantity which we may buy from you will depend upon your rates as well as your past performance.

2.3 The quantity for which we may approve your rates shall be subject to +/- 20% variation to take care of changes in normal consumption. This quantity variation will be allowed on approved rates only.

#### 3.0 RATES:

The rates must be quoted in the format enclosed at Annexure-3. The rates you may quote shall be on firm price basis.

In case there is any increase/decrease in excise duty or other Government levies on finished products till goods are supplied/installed, they will come into effect as per government notifications.

In case of any increase/decrease in excise duty due to your company's turnover, no increase would be applicable.

While submitting your rates, please give us the exact break-up of your purchase price of raw material as on date of submission of your quotation and also submit copy of your invoice of your raw material suppliers for our reference. Please take into consideration the net of CENVAT rate while calculating raw material prices.

#### 4.0 EXCISE DUTY AND TAXES:

4.1 Please specify the percentage of excise duty and/or taxes that will be applicable on your supplies and amount.

4.2 In case you have any specific exemption on taxes, please do specify.

## CAPACITY:

5.1 While submitting your offer, please mention your monthly capacity and maximum quantity that you are in a position to supply on monthly basis.

5.2 Please also mention list of lab equipments that you have for testing raw materials and finished products.

## DELIVERY:

6.1 The material are to be supplied directly to our PFP Stores situated at PFP, Sector 25, Gandhinagar-382044.

6.2 The weight of the material received at the stores will be considered as final.

## 7.0 INVOICING AND DESPATCH ADVICE:

7.1 Invoices are to be prepared in the name of Packaging Film unit, AmulFed Dairy ( A unit of GCMMF Ltd.) and be sent to us directly for payment. Invoices should carry purchase order numbers, PAN number and TIN number without fail and separate delivery challans should accompany each supply to enable us to make payment.

7.2 Please ensure that invoices are prepared as per approved price break up only, specifying rate of excise and sales tax whenever applicable.

## 8.0 QUALITY:

The material must conform to our specifications in all respects. The supply not conforming to our specifications will be rejected at your cost and risk.

In case materials are found sub-standard at our stores, on receipt of the same, we reserve the right to reject the material outrightly. Labour charges if any will also be recovered from you. We reserve the right to send your material for testing at any laboratory of our choice and in case the result is found unsatisfactory we reserve the right to take any action as deemed fit.

Please note that the quality of your material should remain as per our specifications until such time that our product is packed and despatched to market. Any deterioration in the quality of our product packed stored in your material attributable to you will be to your account. Acceptance by our QC department and release of payments as such shall not absolve supplier of his responsibility towards the same.

If the material found not as per our specifications and requirement and circumstances arise to use such material to continue our production then we reserve our right to make deemed fit deductions from the outstanding bills or security deposit which supplier



has to agree and needs to give written confirmation / sign MOM from the authorised representative of the Company.

Ink supplier should be responsible for the adhesion of printing matters on the milk film till it reaches to the customer.

#### 9.0 PAYMENT:

9.1 Payment will be released within 30 days by Demand Draft/Cheque/ Electronic Transfer, from the date of supply or invoice whichever is later and if material is found as per our specification. In case any deductions are required to be made for late supplies or quality related issues or spoilage of our product while using your material then your Company is required to give a written confirmation for the same. Only after getting proper confirmation for the required deductions payment will be released which please note.

DD charges shall be borne by the supplier.

#### 10.0 EARNEST MONEY DEPOSIT (EMD) AND SECURITY DEPOSITE:

10.1 You will have to deposit Rs. 75000/- by demand draft drawn in favour of AmulFed Dairy (A unit of GCMMF LTD.) payable at Ahmedabad of any Nationalized Bank only towards EMD and the same must accompany the quotation. In case your quotation is not accepted the deposit will be refunded within a month from the date of finalisation. EMD will carry no interest.

Your also make RTGS payment in below mention bank accounts:

**BANK NAME : HDFC BANK**

**ACCOUNT NAME : AMULFED DAIRY(A UNIT OF GCMMF LTD)**

**A/C NO : 00060310001593**

**BRANCH : NAVRANGPURA**

**IFSE CODE : HDFC0000006**

**You will have to deposit additional Rs 75000/- as Security Deposit in case the contract is awarded to you. In this case also you may submit the demand Draft or make RTGS payment.**

10.2 Quotation received without EMD shall not be considered and shall be rejected summarily.

10.3 In case we find that you have given any misleading information with regard to your infrastructure as mentioned in your data on firm form, we may forfeit your EMD and also delete your name from our list of approved suppliers.

10.4 In case you fail to arrange supply as per the requirement of us and terms and conditions laid down here, the EMD deposit will be forfeited fully. Otherwise on completion of supply, the deposit will be refunded within 30 days provided there are no outstanding dues to be recovered from you.

In case we find that you have given any misleading information with regard to your machinery infrastructure as mentioned in your data on firm, we may forfeit your EMD and also delete your name from our list of approved suppliers.

## 12.0 INSPECTION OF GOODS IN PROCESS & YOUR MATERIAL PURCHASE DOCUMENTS:

12.1 We reserve our right to depute our representatives for inspection of materials while the same are under manufacture and dispatch. To facilitate inspections as and when necessary, you will be required to give prior intimation as to when you are likely to start manufacturing of materials. In case during such inspection the result is found dissatisfactory, we reserve the right to take whatever action is necessary to protect our interests.

## 13.0 PENALTY:

13.1 In case of your failure to supply the materials as per the contract, you will have to compensate the loss to us may sustain by way of procuring the material from other sources at higher prices, in addition to forfeiting your security deposit.

13.2 We reserve our right to reject quotations received with counter conditions.

14.0 We reserve our right to reject your offer in full or in part without assigning any reason thereof. Your offer should remain valid up to 60 days from the date of opening of quotation.

## CLEANLINESS AND HYGIENE:

The material supplied by you will be used directly in food products for human consumption. It is therefore essential that the material conforms to food grade standards and hygienic quality. Towards this, it is essential that your factory premises and its surroundings where the material is produced/manufactured is maintained in utmost clean and hygienic conditions from dirt/dust/insects/flies etc. You are therefore requested to ensure absolute cleanliness and hygiene to avoid any chances of contamination. The consequences of supplies not conforming to desired hygienic parameters will fall entirely on the suppliers.

16.0 We reserve the right to extend/reduce the contract period by 30 days at approved rates, terms & conditions depending upon our requirement.

17.0 ISO: Since it has become highly necessary to deal with the parties having ISO registration, please let us know as to whether you are registered with ISO. If so, please enclose a copy of the certificate of ISO registration along with your offer. If not, please let us know in writing when you will get the ISO registration to enable us to consider the same while evaluating the offers.

#### 18.0 COMPUTER/E-MAIL FACILITY:

Since it has become highly necessary to deal with the parties having Computer/E-mail facility for effective and fast communication, please let us know whether you have the E-mail facility along with your offer in the DOF form enclosed. If not, please let us know in writing when you will arrange the E-mail facility to enable us to consider the same while evaluating the offers. In absence of this facility, it is likely that we may not consider your offer.

#### 19.0 BUSINESS DEALINGS:-

You are required to mention the full name of your authorized Company representative with designation and phone/ mobile numbers with email ID his signature proof who will make necessary business dealings with us on behalf of your Company. The person shall be authorized to attend meetings and sign MOM if required. Separate authorization letter needs must accompany the quotation made on letter head which must be signed by the MD.

#### 20.0 JURISDICTION:

20.1 In case of any dispute arising out of this contract, jurisdiction will be Ahmedabad.

AMULFED DAIRY, GANDHINAGAR  
PURCHASE DIVISON

ANNEXURE: 3

DUE DATE: 18.02.2020

NAME OF SUPPLIER:

Sr. No	Particulars	Printing Ink (All color)	Ink Solvent	Diluent/
	Approx qty (MT)	9 MT	30 MT	
1	Ex.-factory basic price			
2	Packing and forwarding			
3	Amount of Excise Applicable @ %			
4	Amount of CST/VAT Applicable @ %			
5	Insurance Charges			
6	Freight Charges			
7	Landed price incl. Of Packing & forwarding Excise, freight & taxes			

\*Quantity is only indicative, may vary +/- 20%  
(Above all rates are in Rs./kg)

Date:

AUTHORISED SIGNATORY &  
SEAL OF COMPANY.

AMULFED DAIRY, GANDHINAGAR  
PURCHASE DIVISON

ANNEXURE: 3A

NAME OF SUPPLIER :

Price Justification sheet: Ink Costing Sheet

Particular	Price (Rs/kg)	% composition
ETHYL ALCOHAL		
ETHYL ACETATE		
ETHOXY PROPANOL		
METHOXY PROPANOL		
IPA		
N-Propyl Acetate		
Pigment		
Other Additive		
Total RM Cost		
Conversion Cost		
Plant overhead		
Basic INK Cost		