

TEXTILE LEATHER

RAW MATERIAL –

WET SALTED COW HIDE WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 400%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING(BY PASTE)-

LIME - 7%

Na₂S – 1.2%

WATER - AS REQUIRED

MAKE A HOMOGENEOUS PASTE AND APPLY ON FLESH SIDE. Be⁰ SET ON 28⁰ OF THE PASTE.

PILE FOR OVER NIGHT FLESAH TO FLESH AND GRAIN TO GRAIN.

UNHAIRING-

DIRECT LIMING- WATER – 300%

LIME -6%

Na₂S- 1.5%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 24 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN

DELIMING – WATER- 200

$(\text{NH}_4)_2\text{SO}_4$ – 2%

RUN FOR 30MIN.

ADD+ BATING AGENT- 0.5%

RUN FOR 60MIN.

CHECK COMPLETE DELIMING BY PHENOLOPHTHALEIN INDICATOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 10MIN

PICKLING –

WATER – 100%

COMMON SALT- 6%

RUN FOR 15MIN.

ADD+ HCOOH (MASKING AGENT)- 0.5%

H_2SO_4 – 1%

RUN FOR 50MIN.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 4%

SODIUM FORMATE – 0.5%

DRUM IS RUN FOR 3HOURS.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

NaHCO_3 – 1.0%

NaCO_3 DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 60MIN. CHECK pH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMING MACHINE.

SPLITTING – BY SPLITTING MACHINE(AS REQUIRED)

SHAVING – BY SHAVING MACHINE AT THE THICKNESS OF 0.8mm

SHAVED WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON SHAVED WEIGHT.

NEUTRALIZATION –

WATER – 150%

NaHCO₃ – 1.5%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15MIN. FINALLY DRUM IS RUN FOR 90MIN.

CHECK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 4.8 . DRAIN/ WASH.

DYEING AND FAT-LIQUORING –

WATER – 150%

ACID DYE – 1.0%

DRUM IS RUN FOR 60MIN.

ADD+ ANIONIC FAT – 4%

NEOGIN – L.S.K.P. – 0.3%

CASTER OIL – 0.2%

GIVEN IN 2 FEED IN INTERVAL OF 10MIN AND FINALLY RUN FOR 50MIN.

ADD+ HCOOH – 0.5%

ACID DILUTEED WITH WATER IN RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15MIN AND FINALLY RUN FOR 30MIN.

DRAIN AND LEFT FOR OVER NIGHT.

SAMMING- BY SAMMING MACHINE

SATTING- BY SATTING MACHINE

DRYING – BY VACUME DRAYER

SAW-DUSTING -

STAKING- TOGGLING /TRIMMING

BUFFING –

CRUST WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON CRUST WEIGHT.

MILLING- MILLING FOR 2 HOURS.

FINISHING-

DYE- 2gm

WET EMULSION- 30gm

RASIN BINDER- 40gm

BINDER P.A. – 90gm

PRIMERY BINDER – 50gm

MIXED WELL AND APPLY BY CROSS SPRAY COAT FILL FULLY COMPLETELY.

FIXING-

HCHO – 1PART

WATER- 3PART

FULL CROSS SPARY COAT DRY FOR OVER NIGHT.

TOP COAT –

WATER – 1PART

CORIAL P.M.(BASF)- 2PART

DRIED AND PLANE PLATE WITH 75°C/180KG.

ROLLER LEATHER

RAW MATERIAL –

WET SALTED SHEEP SKIN ARE TAKEN WITHOUT ANY DEEP FLAYCUT AND GRAIN DEFECT.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 300%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING(BY PASTE)-

LIME- 6%

Na₂S – 1%

WATER- AS REQUIRED

MAKE A HOMOGENEOUS PASTE AND APPLY ON FLESH SIDE. Be⁰ SET ON 28⁰ OF THE PASTE.

PILE FOR OVER NIGHT FLESAH TO FLESH AND GRAIN TO GRAIN.

UNHAIRING-

DIRECT LIMING- WATER – 200%

LIME -6%

Na₂S- 1%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 36 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN.

DELIMING –

WATER- 100%

(NH₄)₂SO₄ – 1%

RUN FOR 45MIN.

ADD+ BATING AGENT- 0.5%

RUN FOR 45MIN.

CHECK COMPLETE DELIMING BY PHENOLOPHTHALEIN INDICATOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 10MIN

VEGETABLE TANNING-

BY 4 SUSPENDER PIT WITH OAK BARK.

SUSPENDER	DAYS	BK ⁰	pH
1	2	6-7	5.5-5.2
2	2	7.5-8	5.2-5.0
3	2	10-12	5.0-4.5
4	2	12-14	4.5-4.0

CHECK CROSS PENETRATION AND HORSE-UP FOR TWO DAYS.

SAMMING – BY SAMMING MACHINE.

SHAVING – BY SHAVING MACHINE AT THE THICKNESS OF (0.6 TO 1.3)mm

SHAVED WEIGHT IS NOTED.

ALL PERSCENTAGE BASED ON SHAVED WEIGHT

BLEACHING-

WATER – 200%

OXALIC ACID – 1%

DRUM IS RUN FOR 45MIN.

STUFFING-

FISH OIL-6%

TALLOW- 4%

T.R.O. – 0.5%

MAKE A PASTE AND APPLY BY HAND AND HANGE-UP IN DRYING ROOM FOR 5DAYS.

USES-

ROLLER LEATHER ARE USED IN TEXTILE INDUSTRY.

PICKERS AND PICKING BAND LEATHER

RAW MATERIAL –

WET SALTED BUFF OR OX HIDE WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHTY IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 500%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING- WATER – 300%

LIME -6%

Na₂S- 1.5%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 2 DAYS..

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN.

DELIMING –

WATER-150%

(NH₄)₂SO₄ – 2%

RUN FOR 3 HOURS.

CHECK COMPLETE DELIMING BY PHENOLOPHTHALEIN INDICTOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 10MIN

PICKLING –

WATER – 100%

COMMON SALT- 8%

RUN FOR 15MIN.

ADD+ H₂SO₄ – 1%

RUN FOR 2HOURS.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 5%

 SODIUM FORMATE – 0.5%

DRUM IS RUN FOR 3HOURS.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

 NaHCO₃ – 1.5%

NaCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 90MIN. CHECK pH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMMING MACHINE.

SPLITING – BY SPLITING MACHINE(AS REQUIRED)

SHAVING – BY SHAVING MACHINE AT REQUIRED THICKNESS.

SHAVED WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON SHAVED WEIGHT.

NEUTRALIZATION –

 WATER – 150%

 A.K.M.(NEUTRALIZATION AGENT)- 1.5%

 NaHCO₃ – 1.5%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3FEED IN INTERVAL OF 15MIN.
FINALLY DRUM IS RUN FOR 90MIN.

CHEKCK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 4.8 . DRAIN/ WASH.

DYEING –

 WATER – 150%

 ACID DYE – 1.0%

DRUM IS RUN FOR 30MIN.

PRE-FAT –

T.R.O.- 2%

FISH OIL- 0.5%

SYNTHETIC OIL- 4%

SOFT SOAK – 0.5%

FIXING-

HCOOH- 0.5%

DRUM IS RUN 60MIN.

STUFFING-

WATER- 10%

FISH OIL- 6%

TALLOW- 6%

PARAFIN WAX- 1.25%

CITRIC ACID- 1%

AT 60° RUN FOR 2HOURS.

THE TEMPRETURE SHOULD BE MAINTAIN AT LAST MINIMUM 45°C DURING STUFFING.

CHECK STUFFING AND HANG- UP HOT-CAMBER.

BUFFER AND CHECK STRAP LEATHER

RAW MATERIAL –

DRY SALTED COW HIDE WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 400%

WETTING AGENT- 0.5%

PRESERVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING(BY PASTE)-

LIME- 8%

Na₂S – 1.5%

WATER- AS REQUIRE

HYPO- 1%

MAKE A HOMOGENEOUS PASTE AND APPLY ON FLESH SIDE. Be⁰ SET ON 28⁰ OF THE PASTE.

PILE FOR OVER NIGHT FLESAH TO FLESH AND GRAIN TO GRAIN.

UNHAIRING-

DIRECT LIMING-

WATER – 200%

LIME -8%

Na₂S- 1.5%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 24 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 30MIN.

DELIMING –

WATER- 100%

$(\text{NH}_4)_2\text{SO}_4$ – 1.5%

RUN FOR 3HOURS.

CHECK COMPLETE DELIMING BY PHENOLOPHTHALEIN INDICATOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 10MIN

PICKLING –

WATER – 100%

COMMON SALT- 8%

RUN FOR 15MIN.

ADD+ H_2SO_4 – 1.2%

RUN FOR 2HOURS.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 8%

SODIUM FORMATE – 0.5%

DRUM IS RUN FOR 90MIN.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

NaHCO_3 – 1.5%

NaCO_3 DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 60MIN. CHECK pH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMING MACHINE.

SPLITTING – BY SPLITTING MACHINE(AS REQUIRED)

SHAVING – BY SHAVING MACHINE AT REQUIRED WEIGHT.

SHAVED WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON SHAVED WEIGHT.

NRUTRALIZATION –

WATER – 100%

NaHCO₃ – 1.5%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3FEED IN INTERVAL OF 15MIN.
FINALLY DRUM IS RUN FOR 90MIN.

CHEKCK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 4.8 TO 5.0 DRAIN/ WASH.

FAT-LIQURING –

WATER- 100%

S.F.O.- 4%

CASTOR OIL- 1%

V.T. OIL- 1%

DRUM IS RUN FOR 60MIN.

ADD+ HCOOH- 0.5%

HCOOH DILUTED WITH WATER IN RATIO OF 1:10 AND TAKEN IN 3 FEED IN INTERVAL OF 15 MIN.
FINALLY DRUM IS RUN FOR 30MIN.

DRAIN/ PILE FOR OVER NIGHT.

SAMMING- BY SAMMING MACHINE.

SETTING- BY SETTING MACHINE.

STUFFING-

FISH OIL- 1PART

TALLOW – 1PART

MAKE A PASTE AND APPLY ON BOTH SIDE BY HAND& BRUSH AND HANG-UP IN DRYING CHEMBER.

NEXT DAY, CHECK PENETRATION OF PASTE IN BOTH SIDE.

THEN

SAWDUSTING-

OIL SEAL LEATHER

RAW MATERIAL –

WET SALTED BUFF HIDE WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 500%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING- WATER – 300%

LIME -6%

Na₂S- 2.0%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 24 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN.

DELIMING –

WATER- 300%

$(\text{NH}_4)_2\text{SO}_4$ – 1.5%

RUN FOR 3 HOURS.

CHECK COMPLETE DELIMING BY PHENOLOPHTHALEIN INDICATOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 30MIN

PICKLING –

WATER – 100%

COMMON SALT- 7%

RUN FOR 15MIN.

ADD+ H_2SO_4 – 1%

RUN FOR 2 HOURS.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 6%

SODIUM FORMATE – 1%

DRUM IS RUN FOR 4HOURS.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

NaHCO₃ – 1.5%

NaCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 60MIN. CHECK pH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMMING MACHINE.

SPLITING – BY SPLITING MACHINE(AS REQUIRED)

SHAVING – BY SHAVING MACHINE AT REQUIRED THICKNESS.

SHAVED WEIGHT IS NOTED.

ALL PER5CENTAGE BASED ON SHAVED WEIGHT.

NEUTRALIZATION –

WATER – 150%

NaHCO₃ – 1.5%

A.K.M.- 1%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3FEED IN INTERVAL OF 15MIN.
FINALLY DRUM IS RUN FOR 2HOURS.

CHEKCK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 5.2 TO 5.5 , DRAIN/ WASH.

RETANNING-

WATER- 20%

OS POWDER- 3%

R₇ – 3%

FISH OIL- 2%

DRUM IS RUN FOR 45MIN

ADD+ QUEBRACHO- 3%

MEMOSA- 3%

GS POWDER (LOCAL)- 3%

GS POWDER (BRAZILE)- 3%

WATTLE – 3%

DRUM IS RUN FOR 3HOURS. CHECK PENETRATION BYN CROSS SECTION.

FAT-LIQURING –

ADD+ SYNTHETIC OIL- 3%

 S.P. – 3%

 FISH OIL- 2%

ADD+ HCOOH – 1.5%

ACID DILUTEED WITH WATER IN RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15MIN AND FINALLY RUN FOR 60MIN.

DRAIN AND LEFT FOR OVER NIGHT.

PILE FOR OVER NIGHT.

SAMMING- BY SAMMING MACHINE

SATting- BY SATting MACHINE

DRYING – BY VACUME DRAYER

MULISHA –

PLATING- SUPERFINE PLATE AT 60°C/150KG

BUFFING & SNUFFING – THIS LEATHER SNUFF FROM 400 NUMBER OF EMERY PAPER(LIGHTLY).

GAS METER / DIAFROM LEATHER

RAW MATERIAL –

WET SALTED SHEEP SKIN (HEAVY) OR COW CALF SKIN WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 300%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING(BY PASTE)-

LIME-7%

Na₂S- 1%

WATER- AS REQUIRED

MAKE A HOMOGENEOUS PASTE AND APPLY ON FLESH SIDE. Be⁰ SET ON 28⁰ OF THE PASTE.

PILE FOR OVER NIGHT FLESAH TO FLESH AND GRAIN TO GRAIN.

UNHAIRING-

DIRECT LIMING-

WATER – 300%

LIME -6%

Na₂S- 1%

HOULING AND REPLACING TWICE IN A DAY. LEFT FOR 24 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN.

DELIMING –

WATER- 300%

(NH₄)₂SO₄ – 1.0%

RUN FOR 2 HOURS.

CHECK COMPLETE DELIMING BY PHENOLPHTHELEIN INDICATOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 30MIN

PICKLING –

WATER – 100%

COMMON SALT- 7%

RUN FOR 15MIN.

ADD+ H₂SO₄ – 1%

RUN FOR 60MIN.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 6%

RUN FOR 60MIN.

ADD+ SODIUM FORMATE – 1%

DRUM IS RUN FOR 60MIN.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

NaHCO₃ – 1.0%

NaCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 90MIN. CHECK _{PH} 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMMING MACHINE.

SHAVING – BY SHAVING MACHINE AT REQUIRED THICKNESS.

SHAVED WEIGHT IS NOTED.

ALL PERSCENTAGE BASED ON SHAVED WEIGHT.

NEUTRALIZATION –

WATER – 150%

NaHCO₃ – 1.5%

A.K.M.- 1%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3FEED IN INTERVAL OF 15MIN.
FINALLY DRUM IS RUN FOR 60MIN.

CHEKCK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 5.2 TO 5.5 , DRAIN/ WASH.

RETANNING-

WATER- 100%

REL-1 – R.E. – 2%

FISH OIL- 2%

DRUM IS RUN FOR 90MIN

ADD+ GS POWDER - 2%

WATTLE – 3%

OS POWDER- 3%

DRUM IS RUN FVOR 30MIN. CHECK PENETRATION BY CROSS SECTION.

FAT-LIQURING –

ADD+ SYNTHETIC OIL- 3%

FISH OIL- 2%

VT. OIL- 2%

DRUM IS RUN FOR 90MIN.

ADD+ HCOOH – 1.5%

ACID DILUTEED WITH WATER IN RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15MIN AND FINALLY RUN FOR 45MIN.

SAMMING- BY SAMMING MACHINE

SATting- BY SATting MACHINE

DRYING – BY VACUME DRAYER

MULISHA –

MESURING-

COMBING LEATHER

RAW MATERIAL –

WET SALTED COW HIDE(MEDIUM WEIGHT RANGE 12-15) WITHOUT ANY DEEP FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 300%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING.

LIMING(BY PASTE)-

LIME-8%

Na₂S- 1.5%

WATER- AS REQUIRED

MAKE A HOMOGENEOUS PASTE AND APPLY ON FLESH SIDE. Be⁰ SET ON 28⁰ OF THE PASTE.

PILE FOR OVER NIGHT FLESAH TO FLESH AND GRAIN TO GRAIN.

UNHAIRING-

DIRECT LIMING-

WATER – 200%

LIME -7%

Na₂S- 1%

HOULING AND REPLACING 5MIN IN EVERY 2HOURS. LEFT FOR 24 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 20MIN.

DELIMING –

WATER- 150%

(NH₄)₂SO₄ – 1.5%

RUN FOR 3 HOURS.

CHECK COMPLETE DELIMING BY PHENOLPHTHELEIN INDICTOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 30MIN

PICKLING –

WATER – 100%

COMMON SALT- 8%

RUN FOR 15MIN.

ADD+ H₂SO₄ – 1.5%

RUN FOR 60MIN.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 6%

RUN FOR 60MIN.

ADD+ ALUM SALT-4%

SODIUM FORMATE – 1%

DRUM IS RUN FOR 3HOURS.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

NaHCO₃ – 1.5%

NaCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 90MIN. CHECK PH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMMING MACHINE.

SHAVING – BY SHAVING MACHINE AT REQUIRED THICKNESS.

SHAVED WEIGHT IS NOTED.

ALL PERSCENTAGE BASED ON SHAVED WEIGHT.

WET-BACK-

WATER- 100%

WETTING AGENT- 0.2%

RUN FOR 30MIN.

NEUTRALIZATION –

WATER – 150%

NaHCO₃ – 1.5%

A.K.M.- 0.5%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN. FINALLY DRUM IS RUN FOR 2 HOURS.

CHECK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 4.5 TO 4.6 , DRAIN/ WASH.

FAT-LIQUORING –

WATER-80% AT 60°C

FISH OIL- 2%

DRUM IS RUN FOR 90 MIN.

ADD+ HCOOH – 0.5%

ACID DILUTED WITH WATER IN RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN AND FINALLY RUN FOR 30 MIN.

SAMMING- BY SAMMING MACHINE

SATTING- BY SATTING MACHINE

DRYING – BY VACUUM DRYER

DUBBING-

PARAFIN WAX- 2%

TALLOW- 3%

FISH OIL- 1.5%

MAKE A PASTE AND APPLY ON FLESH SIDE AND LEFT IN DEYING CHAMBER.

NEXT DAY, SLIKING IS DONE TO REMOVE EXCESS PRESENT ON FLESH SIDE.

USES-

COMBING LEATHER IS USED, TRANSMIT POWER SAME PART OF M/C OPERATION BY SMALL BELT.

PROPERTIES-

1-GOOD TENSILE STRENGTH.

2-STRETCH FREE

3-HEAT RESISTENCE

GILL BOX LEATHER

RAW MATERIAL –

WET SALTED BUFF HIDE(HEAVY AVERAGE WEIGHT 28-30KG) WITHOUT FLAYCUT ARE TAKEN.

RAW WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON RAW WEIGHT

SOAKING –

WATER- 400%

WETTIMG AGENT- 0.5%

PRESERTVATIVE- 0.2%

HOULING AND REPLACING TWICE IN A DAYS.

LEFT FOR OVER NIGHT. NEXT DAY CHECK PROPER SOAKING

LIMING-

WATER – 400%

LIME -10%

Na₂S- 2%

HOULING AND REPLACING 5MIN IN EVERY 2HOURS. LEFT FOR 48 HOURS.

NEXT DAY CHECK PROPER SWELLING AND PLUMPING.

FLESHING – BY FLESHING MACHINE.

SCUDDING – BY SCUDD KNIFE.

PELT WEIGHT IS NOTED.

ALL PERCENTAGE BASED ON PELT WEIGHT.

WASHING- WASHING WITH RUNNING WATER FOR 30MIN.

DELIMING –

WATER- 200%

(NH₄)₂SO₄ – 2%

RUN FOR 3 HOURS.

CHECK COMPLETE DELIMING BY PHENOLPHTHELEIN INDICTOR.

pH SHOULD BE MAINTAIN 8.2 TO 8.5

WASHING – WASHING WITH RUNNING WATER FOR 30MIN

PICKLING –

WATER – 100%

COMMON SALT- 10%

RUN FOR 15MIN.

ADD+ H_2SO_4 – 1.75%

RUN FOR 2 HOURS.

ACID DILUTED WITH WATER IN THE RATIO OF 1:19 AND GIVEN IN 3 FEED IN INTERVAL OF 15 MIN.

CHECK COMPLETE PICKLING BY BROMO PHENOL BLUE INDICATOR.

pH SHOULD BE MAINTAIN 2.8 TO 3.0

CHROME TANNING-

DRAIN HALF PICKLE BATH

ADD+ B.C.S. – 8%

RUN FOR 90MIN.

ADD+ SODIUM FORMATE – 1%

DRUM IS RUN FOR 2HOURS.

CHECK CROSS SECTION.

BASIFICATION –

ADD+ WATER – 50%

$HCOONa$ - 0.5%

DRUM IS RUN FOR 30MIN.

$NaHCO_3$ – 1.5%

$NaCO_3$ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTYERVAL OF 15MIN.

FINALLY DRUM IS RUN FOR 60MIN. CHECK pH 3.8 TO 4.0 OR BOIL TEST.

AGEING – AGEING MINIMUM FOR 24 HOURS.

SAMMING – BY SAMMMING MACHINE.

SPLITING – BY SPLITING MACHINE(AS REQUIRED)

SHAVING – BY SHAVING MACHINE AT REQUIRED THICKNESS.

SHAVED WEIGHT IS NOTED.

ALL PERSCENTAGE BASED ON SHAVED WEIGHT.

WET-BACK-

WATER- 150%

WETTING AGENT- 0.2%

RUN FOR 45MIN.

RE-CHROMING-

WATER – 100%

B.C.S. – 2%

DRUM IS RUN FOR 45MIN.

NEUTRALIZATION –

WATER – 100%

NaHCO₃ – 1.5%

A.K.M.- 1%

NaHCO₃ DILUTED WITH WATER IN THE RATIO OF 1:10 AND GIVEN IN 3FEED IN INTERVAL OF 15MIN.
FINALLY DRUM IS RUN FOR 2HOURS.

CHEKCK COMPLETE NEUTRALIZATION BY BROMO CRESOL GREEN INDICATOR.

pH SHOULD BE MAINTAIN 4.8 TO 5.0 , DRAIN/ WASH.

RE-TANNING & FAT-LIQRING –

WATER-100%

OS POWDER- 2%

FISH OIL- 2%

DRUM IS RUN FOR 30MIN.

ADD+

WATTLE- 3%

GS POWDER- 2%

QUEBRACHO- 2%

DRUM IS RUN FOR 90MIN.

ADD+

FISH OIL- 2%

VT. OIL- 2%

SYNTHETIC FAT- 3%

DRUM IS RUN FOR 60MIN.

ADD+

TALLOW- 3%(DESOLVE IN HOT WATER)

SHOP- 0.5%

DRUM IS RUN FOR 60MIN.

FIXING-

HCOOH – 1.5%

ACID DILUTEED WITH WATER IN RATIO OF 1:10 AND GIVEN IN 3 FEED IN INTERVAL OF 15MIN AND FINALLY RUN FOR 45MIN.

DRAIN/PILE FOR AGEING.

SAMMING-

SETTING-

DRYING-

TRIMMING & MULISA-