

**TCL Ghillie Suit Registration Products :**

S. No.	Product Name
1	IR Ghillie Suit (MHA)
2	Anti Visual Ghillie Suit (MHA)
3	Anti Thermal Ghillie Suits (MHA)
4	Anti Radar Ghillie Suit (MHA)

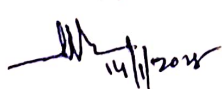
Technical particulars details as found to be satisfactory during physical visit of the Firm by Capacity Verification Team of the OEF Hazratpur.

**Manufacturing Process :**

S. No.	Process
1	<b>Raw Material Grinding:</b> Grind raw materials for camouflage paint using a Triple Roll Mill (Micronizer).
2	<b>Grind Fineness Check:</b> Verify grind fineness using a Grindometer.
3	<b>Paint Mixing:</b> Mix grinded raw materials with solvent using a Paint Mixer.
4	<b>Viscosity Check:</b> Measure paint viscosity using a Viscometer.
5	<b>Test Swatch Creation:</b> Apply paint to a swatch using a Bar Coater.
6	<b>Drying Process:</b> Dry coated swatch in a Hot Air Oven.
7	<b>IR Reflectance Testing:</b> Measure IR reflectance up to 1400nm using a UV2600i Spectrophotometer.
8	<b>Thermal Transmission Testing:</b> Evaluate thermal transmission using a FLIR Thermal Imaging Camera.
9	<b>Radar Attenuation Testing:</b> Test radar attenuation at DRDO Laboratory (test report to be provided ).
10	<b>Fabric Cutting:</b> Cut coated fabric into customized shapes using a Camouflage Shrimp Cut Machine.
11	<b>Ghillie Suit Fabrication:</b> Assemble Ghillie Suit using Sewing Machines as per Specification and Drawing requirements.
12	<b>Packaging Fabrication:</b> Create packaging bags using Sewing Machines.
13	<b>Final Product:</b> Ghillie/Sniper Suits are ready for dispatch.

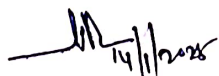
**Testing Process:**

S. No.	Process
1	<b>IR Reflectance Testing:</b> Measure IR reflectance up to 1400nm using a UV2600i Spectrophotometer.
2	<b>Thermal Transmission Testing:</b> Evaluate thermal transmission using a FLIR Thermal Imaging Camera.
3	<b>Radar Attenuation Testing:</b> Test radar attenuation at DRDO Laboratory (test report to be provided).
4	<b>Steel Scale 2 Feets &amp; 2 Meters , Measuring Tapes 10 &amp; 50 Meters</b> are required to be calibrated by NABL accredited labs )

 14/1/2025

**Plant & Machinery Required for Ghillie Suit**

<b>Monthly Production Capacity (MPC) Calculation with Plant and Machinery.</b>			
APPLIED ITEM FOR REGISTRATION WITH MPC	Sl. No	Name of Items	MPC ( Qnty )
	1	IR Ghillie Suit (MHA)	25 Nos
	2	Anti Visual Ghillie Suit (MHA)	25 Nos
	3	Anti Thermal Ghillie Suits (MHA)	25 Nos
	4	Anti Radar Ghillie Suit (MHA)	25 Nos
Sl.No	Name of Plant and Machinery and Accessories.		Quantity
01	Camouflage Net Shrimp Cutting Machine (Industrial)		01 nos
02	Camouflage Colour/Paint Mixer Making Machine (Industrial)		01 nos
03	Camouflage Paint Micronizer, Triple Roll Mill (Industrial)		01 nos
04	Camouflage Paint Foot Mounting Motor		01 nos
05	Camouflage Paint Grindometer (Hegman Gauge)		01 nos
06	Camouflage Paint Bar Coater		01 nos
07	Illuminated Magnifier		10 × 1
08	Gloss Meter		05 nos
09	Camouflage Big Bar Coater		01 nos
10	Hot Air Oven		05 nos
11	Industrial Sewing Machine		01 nos
12	UPS 5KV Online		01 nos
13	Fabric Cutting Machine		01 nos
14	Digital Multimeter		01 nos
15	Textile Eyeglass		01 nos
16	Viscometer (Liquid Flow Meter)		01 nos
17	Pocket Microscope		01 nos
18	UV 2600i Spectrophotometer		01 nos
19	FLIR Thermal Imaging Camera		01 nos
20	Laboratory Equipment. ( Stirrer, Beakers, Cylinders, Blade, Glass Test Tubes, Test Tube Stands, Flasks, Measuring Cylinders, Droppers & Gloves etc.)		





### Packaging Steps for Ghillie Suit:

1. **Clean and Dry the Suit:**  
The Ghillie suit is completely clean and dry before packaging.
2. **Waterproofing and Environmental Protection:**  
The suit is wrapped in a **waterproof bag** for additional protection from moisture, dirt, and environmental factors. This ensures the suit remains in optimal condition and preserves its performance characteristics.
3. **Cushioning for Protection:**  
To prevent compression and protect the suit from physical damage, we carefully wrap the suit with protective foam or bubble wrap. This cushioning helps maintain the shape and integrity of the suit during handling and transit.
4. **Final Packaging in Outer ST Bag:**  
The net is then securely wrapped in a final outer **ST (storage) bag**, which offers additional protection and ensures the net is fully sealed and protected during transit.

### Instructions for Ghillie Suit :

- **Clean and Dry the Suit:** Ensure the Ghillie suit is completely clean and dry before packaging. Dirt, moisture, and oils can affect the material's performance, especially with IR and thermal properties
- **Avoid Tight Compression:** The suit should not be compressed tightly, as this could damage the fibers, particularly those that contribute to the camouflage effect. It should be **loosely rolled or folded** with adequate space for air circulation.
- **Wrap in Protective Film:** If the Ghillie suit is sensitive to moisture or other environmental factors, wrap it in a **moisture-proof or waterproof plastic film**.
- **Place in Storage Bag:** Insert the wrapped Ghillie suit into a breathable fabric or protective storage bag that keeps it from getting crushed or exposed to harmful elements.

As per applicable Drawing and as per MoU and Required P&M for the Manufacturing of Ghillie suit is required to follow with Technical particulars details of OEF Hazratpur .

  
AWM/QA 11/1/2018  
QCO/OEF Hazratpur

  
JWM/QA  
DO/QA(OEFHz)

  
General Manager, 14.1