## Manufacturing of Battery Case

<table>
<thead>
<tr>
<th>Name of Project</th>
<th>Facility for Manufacturing of Battery Case</th>
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<tr>
<td>Project Location</td>
<td>Gelapukhuri, Tinsukia, Assam</td>
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</table>
| Area Requirement | Land required:  
1,110 Gram Battery Box: 15,000-20,000 sq ft  
1,500 Gram Battery Box: 12,000-15,000 sq ft  
2,000 Gram Battery Box: 15,000-20,000 sq ft |
| Approx. Project cost | Total cost (Machinery and Mould):  
1,110 Gram Battery Box: ~INR 114-140 lakh  
1,500 Gram Battery Box: ~INR 124-150 lakh  
2,000 Gram Battery Box: ~INR 150-176 lakh |
| Project Scale | Capacity: Production capacity per day for 22 hours:  
1,110 Gram Battery Box: a. 1,760 pieces @45 seconds for 1 litre Battery case  
b. 3,168 pieces @25 seconds for single Battery Lid  
1,500 Gram Battery Box: a. 1,320@60 seconds for single Battery case  
b. 3,168 pieces @25 seconds for single Battery Lid  
2,000 Gram Battery Box: a. 1,056 pieces @75 seconds for single Battery case  
b. 3,168 pieces @25 seconds for single Battery Lid |
| Process | Manufacturing Process  
PP is fed into the hopper of the injection moulding machine  
The mould is held between the two platens which are kept closed by the locking pressure. Prior to mould closure, the metal insert is skilfully kept in the mould.  
The material which gets plasticized in the barrel is injected under higher pressure into the Mould which results in a moulded article i.e. Battery Lid with Metal Insert. On similar terms, a Battery Case is also manufactured, but with or without rim, depending upon the mould.  
The Battery Case is then finished by removing the injection feed etc.  
The second stage processing operations such as printing, labelling are carried out on the Battery housing. |
| Utilities |  
1,110 Gram Battery Box  
Electricity (connected Load): 150 KW  
Water: 100 litre/min.  
1,500 Gram Battery Box  
Electricity (connected Load): 155 KW  
Water: 100 litre/min  
2000 Gram Battery Box  
Electricity (connected Load): 165 KW  
Water: 100 litre/min  
Water will be circulated through fixed tank capacity is 15,000-20,000 liter |
| Manpower Requirement |  
1,110 Gram Battery Box - 13 workers  
1,500 Gram Battery Box - 13 workers  
2,000 Gram Battery Box - 13 workers |
| Nodal Agency | Assam Industrial Development Corporation (AIDC) |