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Cotton Exchange Building, 2nd Floor, Cotton Green, Mumbai - 400 033  
Telephone: 8657442944/45/46/47/48 Email: cai@caionline.in  
www.caionline.in

## Cotton Ginning, Fibre Attributes and Their Impact on Spinning

(Contd. from Issue No. 19, Dated 8th August, 2023)

### EXPERT'S Column



**Dr. P. K. Mandhyan**  
*Retired Head Mechanical  
Processing Division,  
ICAR-CIRCOT*

*Dr. P. K. Mandhyan was Principal Scientist (Technical Textiles) and Head Quality Evaluation and Improvement Division, ICAR-CICR, Mumbai. He has more than 35 years of experience in evaluation of textile fibres, yarns and fabrics and development of various value-added products from various natural fibres. He has contributed many research articles in national and international journals, popular articles, training manuals, reports, etc.*



**Shri. P. D. Mepani**  
*CEO,  
Shree Corporation*

*Shri. Pankaj Mepani, CEO, Shree Corporation, has more than four decades of rich and varied experience in the cotton industry, having worked in both trading and textile companies.*

*Currently, he is a Director of Cotton Association of India. He is also a Chairman of the Value Difference Committee and Daily Rates Committee, Cotton Association of India.*



**Dr. Sujata Saxena**  
*Principal Scientist (Organic Chemistry)  
& Head I/c, Chemical & Biochemical  
Processing Division, ICAR- CIRCOT,  
Mumbai.*

*Dr. Sujata Saxena has been associated with more than 25 research projects as Principal Investigator/ Co-Principal Investigator and has published numerous scientific papers, articles and book chapters and presented more than 20 papers at national and international conferences. She is Senior member, American Association of Textile Chemists and Colorists, USA and was a consultant in projects funded by UNDP and ICEF on development of application techniques for natural dyes on cotton.*

### Other Fibre Characteristics:

Length, fineness, maturity and strength are the four major physical properties of cotton fibres. However, cotton fibres are also associated with other characteristics like neps, lustre, colour and trash which are very important in deciding the quality of cotton. Nep is the fibre entanglement and forms a knot like structure in fibres. Trash or contamination is the foreign materials present in the lint. Both these characters viz. neps and trash disturb spinning performance and effect yarn quality. Lustre and colour of cotton are also important particularly for price fixing in the market.

and developments spread over several decades at different laboratories have led to designing of instruments capable of measuring various fibre properties simultaneously and quickly. High Volume Instrument popularly known as 'HVI' is one such instrument. It measures seven physical characteristics of cotton fibres viz. length, length uniformity, strength at 3.2 mm gauge, elongation, fineness, colour and trash percent.

In HVI various conventional instruments are integrated into a single electronics. The instrument is highly sophisticated, easy to operate and offers precise and reliable results. As a large number of samples can be tested in a short span of time,

Length		Length Uniformity	
Range of 2.5 % span length	Category	Range of UR %	Category
20.0 mm and below	Short	Below 42	Poor
20.5 mm - 24,5 mm	Medium	42-43	Fair
25.0 mm - 27.0 mm	Medium Long	44-45	Average
27.5 mm- -32,0 mm	Long	46-47	Good
32.5 mm and above	Extra long	Above 47	Excellent

Micronaire		Strength	
Range of Micronaire	Category	Range of Fibre Bundle Strength (g/t) at 3.2 mm gauge	Category
Below 3.0	Very fine	16 and below	Very low
3.0 - 3.9	Fine	17-20	Low
4.0 - 4.9	Average	21-24	Average
5.0 - 5.9	Coarse	25-28	Good
6.0 and above	Very coarse	29 and above	Very good

### Classification of Cotton on the Basis of Fibre Properties:

#### Developments in Measurement of Fibre Attributes

##### i. High Volume Instrument (HVI)

Conventional instruments used for measuring cotton fibre properties need considerable efforts and time to get complete fibre-test results. Research

the instrument is very useful in bale management studies and spinning process.

##### a. Application of HVI: Cotton Purchase - Bale Management

Bale management is a concept, a system and a control mechanism practiced by every spinning mill. In a modern spinning mill, each incoming

cotton bale is tested for fibre parameters on HVI. A typical bale management system performs evaluation of fibre properties, inventory/ware houses control and bale selection for preparation of daily mix consumption.

As HVI gives quick results, bale management becomes easier with the help of suitable software.

For sale or purchase transaction in cotton market, the estimation of fibre properties is usually done by visual judgement by experts. Now a days, HVI system is widely used and known for quick measurement as it can be used for measurement of fibre properties of cottons kept in market for sale or purchase. As little quantity of lint is required and large number of samples can be tested on a daily basis, HVI system is useful to either purchaser or seller of cotton for evaluation of fibre properties.

#### ii. Advanced Fibre Information System (AFIS)

Advance Fibre Information System commonly known as (AFIS) is an important and useful test equipment particularly for small lint sample (4.0 gm) and it gives several fibre quality parameters. AFIS is mainly used for monitoring of fibre properties of in process materials collected from various stages of processing. L & M module gives length parameters such as average length, upper quartile length, short fibre index, length of longest 2.5% and 5% fibre by number, fibre fineness and fibre maturity. T-module measures trash %, micro dust and as total visible foreign matter in the lint, while N-module identifies and classified neps.

### Different Fibre Attributes and Its Effect on Spinning Potential

Spinning is basically a manufacturing technology. It deals with the study of the production of yarn. In spinning, a large quantity of individual unordered fibres of relatively short strengths are to be converted into linear and ordered product of very long length by using suitable machines and devices. The importance of specific fibre quality attributes and how changes in these attributes affect textile production are outlined below.

The following properties of fibres are taken into account while spinning -

- Length and short fibre content
- Uniformity
- Strength (tenacity)
- Linear Density (micronaire)
- Moisture percentage
- Neps (fibre and seed coat fragments)
- Trash (including its type)
- Stickiness
- Colour and grade
- Contamination

The importance of aforementioned fibre properties vary according to the spinning system used and the end product to be made.

#### Cotton Properties in Order of Preference

"Order of Preference"	Ring Spinning	Rotor Spinning
1	Length	Strength
2	Fineness	Fineness
3	Strength	Length
4	Maturity	Maturity

The general spinnability and dyeability of the fibres are governed by the above mentioned fibre properties. Several fibre quality indices or spinning potential indices, incorporating different fibre attributes by assigning different weightage, are available to estimate spinning potential of particular variety or mixing.

Apart from these fibre attributes, which are routinely measured, there are several other properties which are known to have a great impact on spinning or dyeing potential of the fibres. These properties are fibre elongation, fibre cross-sectional shape, surface and inter-fibre friction, wax content, crystalline structure, etc.

## Conclusion

For the fabric manufacturer the quality of the fibre is largely characterised by the quality of yarn they buy or are provided with, where good quality fibre translates to good quality yarn. However, the following fibre properties also have significance when appraising the finished fabric quality. These include: micronaire (maturity), trash, contamination, short fibre content (SFC), neps, colour and grade. The shade or absorbency difference within a lot of fabric is a major cause of rejection of the garments/ made ups, especially when meant for overseas markets.

It has been observed that the variation in micronaire value of baled cotton within a lot, is a major cause to this effect. Therefore, importance

of uniform micronaire value across the baled cotton lot cannot be undermined.

The kind of cotton the spinners need is “cotton of better grade at a reasonable price, with longer staple length, suitable fineness, stronger fibre strength and higher length uniformity index without honeydew and foreign matter contamination.”

Cotton Ever Be With Us

Source : CAI Centenary Special 2022

*(The views expressed in this column are of the authors and not that of Cotton Association of India)*

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## CAI retains its Cotton Crop Estimate for 2022-23 Season at 311.18 Lakh Bales

Cotton Association of India (CAI) has released its July estimate of the cotton crop for the season 2022-23 beginning from 1st October 2022. The CAI has retained its cotton crop estimate for the 2022-23 season at 311.18 lakh bales of 170 kgs. each (equivalent to 326.55 lakh running bales of 162 kgs. each). This estimate has been arrived at by the Crop Committee of the Association at its meeting held on 12th August 2023. Based on pressing numbers and input received from the members of all the 11 cotton growing state associations and other trade sources, the Committee estimated the cotton crop for the 2022-23 season and drew cotton balance sheet. The state-wise break-up of the cotton production and balance sheet for the season with the corresponding data for the previous crop year are given below.

The total cotton supply for the months of October 2022 to July 2023 is estimated at 332.30 lakh bales of 170 kgs. each (equivalent to 348.71 lakh running bales of 162 kgs. each), which consists of the arrivals of 296.80 lakh bales of 170 kgs. each (equivalent to 311.46 lakh running bales of 162 kgs. each), imports of 11.50 lakh

bales of 170 kgs. each (equivalent to 12.07 lakh running bales of 162 kgs. each) and the opening stock estimated by the CAI at 24 lakh bales of 170 kgs. each (equivalent to 25.19 lakh running bales of 162 kgs. each) at the beginning of the season.

Further, the CAI has estimated cotton consumption for the months of October 2022 to July 2023 at 265 lakh bales of 170 kgs. each (equivalent to 278.09 lakh running bales of 162 kgs. each) while the export shipments upto 31st July 2023 are estimated by the CAI at 14.00 lakh bales of 170 kgs. each (equivalent to 14.69 lakh running bales of 162 kgs. each). Stock at the end of July 2023 is estimated at 53.30 lakh bales of 170 kgs. each (equivalent to 55.93 lakh running bales of 162 kgs. each) including 28 lakh bales of 170 kgs. each (equivalent to 29.38 lakh running bales of 162 kgs. each) with textile mills and the remaining 25.30 lakh bales of 170 kgs. each (equivalent to 26.55 lakh running bales of 162 kgs. each) with the CCI, Maharashtra Federation and others (MNCs, traders, ginners, etc.) including cotton sold but not delivered.

The CAI has retained its total cotton supply estimate till end of the cotton season 2022-23



i.e. upto 30th September 2023 at the same level as estimated earlier i.e. at 350.18 lakh bales of 170 kgs. each (equivalent to 367.47 lakh running bales of 162 kgs. each). The total cotton supply consists of the opening stock of 24 lakh bales of 170 kgs. each (equivalent to 25.19 lakh running bales of 162 kgs. each) at the beginning of the cotton season on 1st October 2022, crop for the season estimated at 311.18 lakh bales of 170 kgs. each (equivalent to 326.55 lakh running bales of 162 kgs. each) (based on pressing figures) and the imports for the season estimated by the CAI at 15 lakh bales of 170 kgs. each (equivalent to 15.74 lakh running bales of 162 kgs. each). The import estimated by the CAI for the corresponding year 2021-22 was at 14 lakh bales of 170 kgs. each (equivalent to 14.69 lakh running bales of 162 kgs. each).

The domestic consumption for the season is also estimated at the same level as estimated previously i.e. at 311 lakh bales of 170 kgs. each (equivalent to 326.36 lakh running bales of 162 kgs. each). The exports for the season have also been retained at 16 lakh bales of 170 kgs. each (equivalent to 16.79 lakh running bales of 162 kgs. each).

The exports estimate for the previous cotton season 2021-22 was 43 lakh bales of 170 kgs. each (equivalent to 45.12 lakh running bales of 162 kgs. each). The carry-over stock is estimated at 23.18 lakh bales of 170 kgs. each (equivalent to 24.32 lakh running bales of 162 kgs. each).

### Highlights of Deliberations held by the CAI Crop Committee on 12th August 2023

The Crop Committee of the Cotton Association of India (CAI) held its meeting on Saturday, the 12th August 2023, which was attended by 20 members representing various cotton growing regions of the country. The Committee arrived at its July estimate of the cotton crop for 2022-23 season and drew the estimated cotton balance sheet based on the data available from various trade sources, upcountry associations and other stakeholders.

The following are the highlights of the deliberations held at this meeting: -

#### 1. Consumption

The CAI has estimated cotton consumption for the current crop year 2022-23 at 311.00 lakh

bales of 170 kgs. each (equivalent to 326.36 lakh running bales of 162 kgs. each). The previous year's consumption estimate was 318 lakh bales of 170 kgs. each (equivalent to 333.70 lakh running bales of 162 kgs. each).

Upto 31st July 2023, the consumption is estimated at 265 lakh bales of 170 kgs. each (equivalent to 278.09 lakh running bales of 162 kgs. each).

#### 2. Production

The CAI has retained its production estimate for 2022-23 season at the same level as estimated previously i.e. at 311.18 lakh bales of 170 kgs. each (equivalent to 326.55 lakh running bales of 162 kgs. each).

The CAI Crop Committee has estimated crop figures based on the cotton pressing numbers and arrivals concerning various states based on the input received in Crop Committee meeting from the members of the following Associations: -

Sr. No.	State	Members / Associations
1	Punjab	Indian Cotton Association Ltd. (ICAL)
2	Haryana	Indian Cotton Association Ltd. (ICAL)
3	Rajasthan	Indian Cotton Association Ltd. (ICAL)
4	Gujarat	GUJCOT Trade Association
5	Maharashtra	Indian Commodities.Com Maharashtra Cotton Ginners Association
6	Madhya Pradesh	Madhyanchal Cotton Ginners & Traders Association
7	Telangana	Telangana Cotton Millers & Traders Welfare Association
8	Andhra Pradesh	AP Brokers and Ginners
9	Karnataka	Karnataka Cotton Association
10	Tamil Nadu	Tamil Nadu Cotton Association
11	Orissa	Odissa Cotton Association

The Committee members will have a close watch on the cotton pressing numbers and arrivals in the subsequent months and if any addition or reduction is required to be made in the production estimate, the same will be made in the CAI report.

### 3. Imports

The estimate of cotton imports into India is estimated at 15 lakh bales of 170 kgs. each (equivalent to 15.74 lakh running bales of 162 kgs. each) which is more by 1 lakh bales than the import estimate of 14 lakh bales of 170 kgs. each (equivalent to 14.69 lakh running bales of 162 kgs. each) for the previous crop year 2021-22.

Upto 31st July 2023, about 11.50 lakh bales of 170 kgs. each (equivalent to 12.07 lakh running bales of 162 kgs. each) are estimated to have arrived the Indian Ports.

### 4. Exports

The Committee has retained its cotton exports estimate at 16 lakh bales of 170 kgs. each (equivalent

to 16.79 lakh running bales of 162 kgs. each) which is less by 27 lakh bales of 170 kgs. each (equivalent to 28.33 lakh running bales of 162 kgs. each) than the exports estimate of 43.00 lakh bales of 170 kgs. each (equivalent to 45.12 lakh running bales of 162 kgs. each) for the crop year 2021-22.

Upto 31st July 2023, about 14.00 lakh bales of 170 kgs. each (equivalent to 14.69 lakh running bales of 162 kgs. each) are estimated to have been shipped.

### 5. Arrivals

Indian cotton arrivals during the months of October 2022 to July 2023 are estimated at 296.80 lakh bales of 170 kgs. each (equivalent to 311.46 lakh running bales of 162 kgs. each).

### 6. Closing Stock as on 30<sup>th</sup> September 2023

Closing stock as on 30th September 2023 is estimated by the Committee at 23.18 lakh bales of 170 kgs. each (equivalent to 24.32 lakh running bales of 162 kgs. each).

#### CAI's Estimates of Cotton Crop for the Season 2022-23 and 2021-22

(in lakh bales of 170 kg.)

State	Production Estimate*				Pressed Cotton Bales as on 31st July 2023	
	2022-23		2021-22		2022-23	
	In running b/s of 162 Kgs. each	In lakh b/s of 170 Kgs. each	In running b/s of 162 Kgs. each	In lakh b/s of 170 Kgs. each	In running b/s of 162 Kgs. each	In lakh b/s of 170 Kgs. each
Punjab	2.62	2.50	8.92	8.50	2.56	2.44
Haryana	11.54	11.00	16.90	16.10	9.48	9.03
Upper Rajasthan	18.89	18.00	16.10	15.34	18.36	17.50
Lower Rajasthan	11.28	10.75	10.84	10.33	10.92	10.41
<b>Total North Zone</b>	<b>44.34</b>	<b>42.25</b>	<b>52.75</b>	<b>50.27</b>	<b>41.32</b>	<b>39.38</b>
Gujarat	96.54	92.00	77.96	74.29	93.59	89.19
Maharashtra	83.95	80.00	75.56	72.00	79.05	75.33
Madhya Pradesh	20.46	19.50	20.99	20.00	19.15	18.25
<b>Total Central Zone</b>	<b>200.96</b>	<b>191.50</b>	<b>174.50</b>	<b>166.29</b>	<b>191.80</b>	<b>182.77</b>
Telangana	31.48	30.00	37.15	35.40	30.66	29.22
Andhra Pradesh	15.74	15.00	15.74	15.00	14.85	14.15
Karnataka	22.04	21.00	21.25	20.25	21.83	20.80
Tamil Nadu	5.25	5.00	7.21	6.87	4.51	4.30
<b>Total South Zone</b>	<b>74.51</b>	<b>71.00</b>	<b>81.35</b>	<b>77.52</b>	<b>71.85</b>	<b>68.47</b>
Orissa	3.60	3.43	2.18	2.08	3.60	3.43
Others	3.15	3.00	3.15	3.00	2.89	2.75
<b>Total</b>	<b>326.55</b>	<b>311.18</b>	<b>313.93</b>	<b>299.16</b>	<b>311.46</b>	<b>296.80</b>

\* Including loose

**The Balance Sheet drawn by the Association for 2022-23 and 2021-22 is reproduced below: -**

(in lakh bales of 170 kg.)

Details	2022-23	2021-22
Opening Stock	24.00 *	71.84
Production	311.18	299.16
Imports	15.00	14.00
<b>Total Supply</b>	<b>350.18</b>	<b>385.00</b>
Mill Consumption	280.00	293.00
S.S.I. Consumption	15.00	19.00
Non-Textile Consumption	16.00	6.00
<b>Total Domestic Demand</b>	<b>311.00</b>	<b>318.00</b>
<b>Available Surplus</b>	<b>39.18</b>	<b>67.00</b>
Exports	16.00	43.00
<b>Closing Stock</b>	<b>23.18</b>	<b>24.00</b>

\* One time adjustment of 7.89 lakh bales made in the Opening Stock i.e. 24.00 lakh bales made at the CAI National Crop Committee meeting held on 10th July 2023.

**State-wise Cotton Stock as on 31st July 2023**

(in lakh bales of 170 kgs. each)

State	Cotton Stock
Punjab	0.10
Haryana	0.20
Rajasthan	0.75
<b>Total North Zone</b>	<b>1.05</b>
Gujarat	6.05
Maharashtra	11.00
Madhya Pradesh	2.00
<b>Total Central Zone</b>	<b>19.05</b>
Telangana	3.00
Andhra Pradesh	1.00
Karnataka	0.75
Tamil Nadu	
<b>Total South Zone</b>	<b>4.75</b>
Orissa	0.45
Others	
<b>GRAND TOTAL</b>	<b>25.30</b>

**Balance Sheet of 10 months i.e. from 1.10.2022 31.07.2023 for the season 2022-23**

Details	In lakh b/s of 170 kg.	In '000 Tons
Opening Stock as on 01.10.2022	24.00	408.00
Arrivals upto 31.07.2023	296.80	5045.60
Imports upto 31.07.2023	11.50	195.50
<b>Total available</b>	<b>332.30</b>	<b>5649.10</b>
Consumption	265.00	4505.00
Export Shipments upto 31.07.2023	14.00	238.00
Stock with Mills	28.00	476.00
Stock with CCI, Maha Fedn., MNCs, Ginners, Traders & Exporters	25.30	430.10
<b>Total</b>	<b>332.30</b>	<b>5649.10</b>

UPCOUNTRY SPOT RATES (Rs./Qtl)													
Standard Descriptions with Basic Grade & Staple in Millimetres based on Upper Half Mean Length [ By law 66 (A) (a) (4) ]								Spot Rate (Upcountry) 2022-23 Crop August 2023					
Sr. No.	Growth	Grade Standard	Grade	Staple	Micronaire	Gravimetric Trash	Strength /GPT	7th	8th	9th	10th	11th	12th
1	P/H/R	ICS-101	Fine	Below 22mm	5.0 – 7.0	4%	15	17069 (60700)	17069 (60700)	17069 (60700)	17069 (60700)	17069 (60700)	17209 (61200)
2	P/H/R (SG)	ICS-201	Fine	Below 22mm	5.0 – 7.0	4.5%	15	17209 (61200)	17209 (61200)	17209 (61200)	17209 (61200)	17209 (61200)	17350 (61700)
3	GUJ	ICS-102	Fine	22mm	4.0 – 6.0	13%	20	13357 (47500)	13357 (47500)	13357 (47500)	13301 (47300)	13329 (47400)	13357 (47500)
4	KAR	ICS-103	Fine	22mm	4.5 – 6.0	6%	21	14116 (50200)	14116 (50200)	14116 (50200)	14060 (50000)	14088 (50100)	14116 (50200)
5	M/M (P)	ICS-104	Fine	23mm	4.5 – 7.0	4%	22	15410 (54800)	15410 (54800)	15410 (54800)	15410 (54800)	15522 (55200)	15607 (55500)
6	P/H/R (U) (SG)	ICS-202	Fine	27mm	3.5 – 4.9	4.5%	26	15719 (55900)	15832 (56300)	15888 (56500)	15888 (56500)	15944 (56700)	16028 (57000)
7	M/M(P)/ SA/TL	ICS-105	Fine	26mm	3.0 – 3.4	4%	25	-	-	-	-	-	-
8	P/H/R(U)	ICS-105	Fine	27mm	3.5 – 4.9	4%	26	15888 (56500)	16000 (56900)	16056 (57100)	16056 (57100)	16141 (57400)	16225 (57700)
9	M/M(P)/ SA/TL/G	ICS-105	Fine	27mm	3.0 – 3.4	4%	25	15241 (54200)	15241 (54200)	15241 (54200)	15185 (54000)	15325 (54500)	15466 (55000)
10	M/M(P)/ SA/TL	ICS-105	Fine	27mm	3.5 – 4.9	3.5%	26	15972 (56800)	16028 (57000)	16056 (57100)	16056 (57100)	16113 (57300)	16253 (57800)
11	P/H/R(U)	ICS-105	Fine	28mm	3.5 – 4.9	4%	27	16619 (59100)	16731 (59500)	16788 (59700)	16788 (59700)	16844 (59900)	16928 (60200)
12	M/M(P)	ICS-105	Fine	28mm	3.7 – 4.5	3.5%	27	16394 (58300)	16450 (58500)	16478 (58600)	16478 (58600)	16535 (58800)	16675 (59300)
13	SA/TL/K	ICS-105	Fine	28mm	3.7 – 4.5	3.5%	27	16450 (58500)	16506 (58700)	16535 (58800)	16535 (58800)	16591 (59000)	16731 (59500)
14	GUJ	ICS-105	Fine	28mm	3.7 – 4.5	3%	27	16563 (58900)	16563 (58900)	16563 (58900)	16563 (58900)	16647 (59200)	16816 (59800)
15	R(L)	ICS-105	Fine	29mm	3.7 – 4.5	3.5%	28	16591 (59000)	16647 (59200)	16731 (59500)	16731 (59500)	16816 (59800)	16872 (60000)
16	M/M(P)	ICS-105	Fine	29mm	3.7 – 4.5	3.5%	28	16731 (59500)	16788 (59700)	16816 (59800)	16816 (59800)	16872 (60000)	17013 (60500)
17	SA/TL/K	ICS-105	Fine	29mm	3.7 – 4.5	3%	28	16759 (59600)	16816 (59800)	16844 (59900)	16844 (59900)	16900 (60100)	17041 (60600)
18	GUJ	ICS-105	Fine	29mm	3.7 – 4.5	3%	28	16872 (60000)	16872 (60000)	16872 (60000)	16872 (60000)	16956 (60300)	17125 (60900)
19	M/M(P)	ICS-105	Fine	30mm	3.7 – 4.5	3.5%	29	16956 (60300)	17013 (60500)	17041 (60600)	17041 (60600)	17097 (60800)	17238 (61300)
20	SA/TL/K/O	ICS-105	Fine	30mm	3.7 – 4.5	3%	29	16984 (60400)	17041 (60600)	17069 (60700)	17069 (60700)	17125 (60900)	17266 (61400)
21	M/M(P)	ICS-105	Fine	31mm	3.7 – 4.5	3%	30	17097 (60800)	17153 (61000)	17181 (61100)	17181 (61100)	17238 (61300)	17378 (61800)
22	SA/TL/ K / TN/O	ICS-105	Fine	31mm	3.7 – 4.5	3%	30	17153 (61000)	17209 (61200)	17238 (61300)	17238 (61300)	17294 (61500)	17434 (62000)
23	SA/TL/K/ TN/O	ICS-106	Fine	32mm	3.5 – 4.2	3%	31	N.A. (N.A.)	N.A. (N.A.)	N.A. (N.A.)	N.A. (N.A.)	N.A. (N.A.)	N.A. (N.A.)
24	M/M(P)	ICS-107	Fine	34mm	2.8 - 3.7	4%	33	20246 (72000)	20246 (72000)	20246 (72000)	20106 (71500)	20106 (71500)	20106 (71500)
25	K/TN	ICS-107	Fine	34mm	2.8 - 3.7	3.5%	34	20528 (73000)	20528 (73000)	20528 (73000)	20387 (72500)	20387 (72500)	20387 (72500)
26	M/M(P)	ICS-107	Fine	35mm	2.8 - 3.7	4%	35	20949 (74500)	20949 (74500)	20949 (74500)	20809 (74000)	20668 (73500)	20668 (73500)
27	K/TN	ICS-107	Fine	35mm	2.8 - 3.7	3.5%	35	21231 (75500)	21231 (75500)	21231 (75500)	21090 (75000)	20949 (74500)	20949 (74500)

(Note: Figures in bracket indicate prices in Rs./Candy)