


**SCOPE OF WORK FOR DE-PLATING & ZINC PLATING FOLLOWED BY  
CHROMATISING ON 30 MM CARTRIDGE CASE FOR BMP-II FOR  
REQUISITION NO:1631000266 Dt.22.06.2016.**

1. The contractor shall collect 3 lots of the cartridge cases (components), each lot consists of 10000 cartridge cases, from Metal and Steel factory (MSF) at a time after depositing the requisite bank guarantee and shall deliver back the whole 3 lots to MSF under his own arrangements within one month from the date of lifting.
2. Normally material is packed in corrugated Packing Boxes sealed in polythene bags and each box contains 30 Nos. of Cartg. Cases. Firm shall collect the material from MSF after opening the corrugated boxes at MSF. Firm shall deliver the duly plated cartridge cases in returnable Steel Boxes. Each cartridge case after plating will be packed in a polyethylene bag before putting the material in steel boxes to avoid damage to plating during transportation and handling.
3. Components supplied by MSF will be Zn-Plated followed by Chromate passivation. Firm will remove the existing Zinc-plating & Chromate Layer from the components. Components thus cleaned will be polished thoroughly on outside and inside both surfaces so that they are free from Scratches, Pits and Dents, white & Black Patches etc.
4. After polishing, components will be subjected to Zn-plating followed by Chromate Passivation (Zn-Coating Thickness: Outside Surface – 18 microns (Min) & Inside Surface 10 microns (Min)). At any point of the components, thickness must not exceed 40 micron.
5. Chromate passivation shall be iridescent yellow colored. 100% Cartridge Cases after Zinc Plating and Chromate passivation will be subjected to heating at 190 to 210 deg C for 1 hour.
6. (a) The components on receipt at MSF will be inspected by quality assurance (QA), MSF for visual defects (Pitting, fold, scale, die marks etc) & Zn-coating thickness.  
(b) Lots cleared in inspection as mentioned in clause 6(a) will be subjected to corrosion testing. 5 Nos. of components from each lot will be randomly selected for corrosion testing as per the procedure laid out by MSF ( 96 hours by dip test method, if required testing QAP can be shared with the firm after placement of order). If any of the components out of these five nos. fails in corrosion, whole lot will be rejected & firm will have to rectify the Lot free of cost. No additional cost including transportation or handling will be borne by MSF for such rework.
7. Firm will submit Bank Guarantee @ Rs.100/- per Cartridge Case towards lifting of the material issued to them.
8. Supply Order quantity must be completed in maximum of 06 months from the date of placement of supply order.

  
DGM/CC

  
AWM/CC

  
JWM/CCS