

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 02
		Date of Issue 07/04/2017
GASKET	HAPP/QA/SC/ZI/020	

DRAWING NO. : NASK 1071/5
MATERIAL SPECN : NEOPRENE RUBBER AS PER IND/ME/678
END USE : FOR ASSY NOZZLE PLATE OF RGB 60.

A. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES FOR RAW MATERIAL BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE FREE FROM DAMAGES, CRACK, SURFACE IMPERFECTION AND OTHER MOULDING / INJURIOUS DEFECTS	100%
2.	DIMENSIONS	AS PER DRAWING.	
3.	RAW MATERIAL	NEOPRENE RUBBER AS PER IND/ME/678	TWO SAMPLE PER LOT /BATCH OF RAW MATERIAL

NOTE :

1. THE RAW MATERIAL SAMPLES / TEST SPECIMENS FOR EACH HEAT SHALL BE SELECTED FROM BULK AT FIRM'S PREMISES BY **NAI REP.** AND FORWARDED TO NEARBY NABL ACCREDITED OR GOVT. APPROVED LABORATORY FOR TESTING.
2. THE FIRM HAS TO CHECK FOR THE DIMENSIONS, VISUAL DEFECTS AS PER **TABLE A.** AFTER CHECKING, THE FIRM HAS TO SUBMIT/FORWARD THE FOLLOWING DOCUMENTS TO **NAI/TRICHY** WITH A COPY TO **HAPP.**
 - I. THE RAW MATERIAL **ORIGINAL MANUFACTURER'S CERTIFICATE**, DETAILS OF **HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS** ARE TO BE SUBMITTED.
 - II. THE **CHEMICAL AND MECHANICAL TEST CERTIFICATES** FROM NABL ACCREDITED OR GOVT. APPROVED LAB AS PER **TABLE A.**
 - III. **DIMENSION REPORT INCLUDING VISUAL** AS PER **TABLE A.**
 - IV. **GUARANTEE/WARRANTEE CERTIFICATE** OF ORIGINAL MANUFACTURER.
3. MANUFACTURING OF COMPONENT SHOULD BE DONE ONLY AFTER GETTING RAW MATERIAL CLEARANCE FROM **NAI** AND SHOULD BE MANUFACTURED AS PER THE MANUFACTURING QUALITY PLAN OF **NAI.**

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**B. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES BY NAI.
(FINISHED PRODUCT STAGE)**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE FREE FROM DAMAGES, CRACK, SURFACE IMPERFECTION AND OTHER MOULDING / INJURIOUS DEFECTS	100 %
2	DIMENSIONS	AS PER DRAWING.	
3	FITMENT	SHALL BE SATISFACTORY TO SPECIMEN SAMPLE OF MATTING PART OR GAUGE	30 SAMPLES / LOT
4	PACKING	SUITABLY PACKED TO AVOID TRANSIT DAMAGES AND SECURELY TIED WITH METAL / PLASTIC TAG. PACKING SLIP SHOULD SPECIFY HAPP SUPPLY ORDER NO. QUANTITY IN NOS. AND PRODUCER'S NAME OR CODE. THE MATERIAL SHOULD BE FREE FROM CORROSION. (APPLY RUST PREVENT OIL)	100%

4. 100 % LOT SHALL BE INSPECTED BY NAI REP. / INSPECTORS AT FIRM'S PREMISES.
5. MATERIAL TO BE DESPATCHED TO HAPP ONLY AFTER GETTING CLEARANCE FROM NAI.
6. THE FIRM HAS TO DESPATCH THE MATERIAL/COMPONENT ALONG WITH NAI I-NOTE ONLY.

C. INSPECTION CHECK TO BE CARRIED OUT AT HAPP AFTER RECEIPT BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE FREE FROM DAMAGES, CRACK, SURFACE IMPERFECTION AND OTHER MOULDING / INJURIOUS DEFECTS	100 %
2	DIMENSIONS	AS PER DRAWING.	
3	PACKING	SUITABLY PACKED TO AVOID TRANSIT DAMAGES AND SECURELY TIED WITH METAL / PLASTIC TAG. PACKING SLIP SHOULD SPECIFY HAPP SUPPLY ORDER NO. QUANTITY IN NOS. AND PRODUCER'S NAME OR CODE. THE MATERIAL SHOULD BE FREE FROM CORROSION. (APPLY RUST PREVENT OIL)	100 %

D. VERIFICATION OF INSPECTION DOCUMENTS.

FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED WITH EACH SUPPLY.

SL. NO.	INSPECTION DOCUMENTS
1.	THE RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE , DETAILS OF HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS ETC.
2.	THE CHEMICAL AND MECHANICAL TEST CERTIFICATES FROM NABL ACCREDITED OR GOVT. APPROVED LAB.
3.	DIMENSION REPORT INCLUDING VISUAL.
4.	PACKING SLIP DETAILS.
5.	GUARANTEE / WARRANTY CERTIFICATE OF SUPPLIER.
6.	NAI - I-NOTE.

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7. MATERIAL/COMPONENT WILL BE CLEARED/ACCEPTED BASED ON NAI I-NOTE/CLEARANCE CERTIFICATE ONLY.
8. MATERIAL HAS TO BE REPLACED 100% BY THE FIRM IN CASE OF ANY DAMAGES DURING INSPECTION AT HAPP, TRICHY.

Mithlesh
MITHLESH CHANDRA
 AWM / ASSY
 MEMBER / MI COMMITTEE

D. Bhaskar RAO
D. BHASKAR RAO
 WM / E
 MEMBER / MI COMMITTEE

T. Prabhu
T. PRABHU
 JT.GM / QA
 CHAIRMAN / MI COMMITTEE