

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
		Rev No :
33P 3014 (HOUSING TRIGGER MECHANISM)		Date of Issue / /2021
		OFT/MI/MSL/33P 3014
Rev.No	Amendment	Date


MATERIAL SPECIFICATION : AL 7075 with T6 Condition.
CONDITION OF SUPPLY : Full Finished with Firm's Material.
END USE : 38mm MSL.

INSPECTION CHECK TO BE CARRIED OUT

SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	Table 'A' SAMPLE SIZE
1.	Visual	The blank shall be free from defects such as rust, scale, burrs and any other harmful defects.	100%
2.	Dimension	100% Dimension check as per drawing.	
3.	Chemical Composition (%)	<u>AL 7075 with T6 Condition.</u> Cr = 0.18-0.28 Si = 0.40 (Max) Cu = 1.20 -2.00 Ti = 0.20 (Max) Mg = 2.10-2.90 Zr+Ti = 0.25 (Max) Zn = 5.10-6.10 other Elements each = 0.05 (Max) Fe = 0.50 (Max) Other Elements Total=0.15 (Max) Mn = 0.30 (Max) Al = Remainder	One Sample Per Heat
4.	Mechanical Properties	<u>AL 7075 with T6 Condition.</u> Tensile Strength = 540 MPa (Min) 0.2% Proof Stress = 485 MPa (Min) Elongation = 7% (Min)	One Sample Per Heat
5.	Other Tests	1. Ultrasonic Test as per Specification Standard. 2. Etching Test as per Specification Standard. 3. Magnetic Particle Test as per Specification Standard.	One Sample Per Heat
6.	Protective Finish	Hard Anodic Coating except Threaded portion to IS: 6057 – 1988. Coating Thickness 0.05mm-0.075mm.	Each Consignment
7.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	
8.	Marking	Each Packing shall be legibly marked with manufacturer's identity , Qty, Heat No, OFT Supply order No etc.,	

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