

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 00
		Date of Issue 18/06/2021
PLASTIC CONTAINER FOR 125mm PRACTICE SHOT		HAPP/QA/SC/B/011
Rev no	Amendment	Date

DRAWING NO. : HAPP Drg. H OMA 125 1 185

RAW MATERIAL : 1. FOR SL.NO. 1,2,3&4 - HIGH DENSITY POLYTHENE TO SPEC JSS 9330-03 : 2014 (TYPE 2) IN NATURAL COLOUR .
2. FOR SL. No.6 (GASKET) – NEOPRENE RUBBER TO SPEC IND/ME/884 (PROV).
3. FOR SL. No 5 (CUSHION PAD) - SPONGE RUBBER TO SPEC: IND/ME/645

END USE : 125mm FSAPDS Practice Shot

TABLE A. INSPECTION CHECK TO BE CARRIED OUT FOR RAW MATERIAL BY THE FIRM.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE PARTS SHALL BE FREE FROM DAMAGES, BUBBLES, SURFACE IMPERFECTIONS, POROSITY, VOIDS DUE TO DUST INCLUSIONS & OTHER OBVIOUS DEFECTS LIKELY TO IMPAIR THEIR USEFULNESS OR LIFE	100 %
2	DIMENSIONS	AS PER DRAWING	100 %
3	DROP TEST	AS PER SPECIFICATION JSG 0102	AS PER JSG 0102
4	PROPERTIES	AS PER JSS 9330-03:2014 CLAUSE 7.4 TEST REQUIREMENTS (a) Chemical Requirements (b) Physical Requirements	TWO SAMPLES FOR EACH LOT
5	PACKING	PACKING SLIP INDICATING SOURCE CODE, MATERIAL GRADE LOT NO. AND QTY.	FOR EACH CONSIGNMENT

NOTE:

- FIRM SHOULD OFFER THE FOLLOWING DOCUMENTS ALONG WITH ADVANCE SAMPLE..
 - THE RAW MATERIAL PROPERTIES CHEMICAL, MECHANICAL AND OTHER TEST CERTIFICATES DULY TESTED FROM NABL ACCREDITED OR GOVT. APPROVED/ GOVT. APPROVED / P.S.U LAB AND RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE.
 - DIMENSIONAL INSPECTION REPORT FROM SUPPLIER.
- THE FIRM SHOULD SUPPLY 5 NOS AS ADVANCE SAMPLE FOR INSPECTION OF VARIOUS PARAMETERS. BULK PRODUCTION / SUPPLY SHOULD BE DONE ON RECEIVING CLEARANCE FROM HAPP.

TABLE B. INSPECTION CHECK TO BE CARRIED OUT ON RECEIPT AT FACTORY.

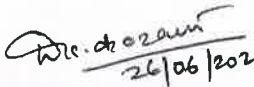
SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE PARTS SHALL BE FREE FROM DAMAGES, BUBBLES, SURFACE IMPERFECTIONS, POROSITY, VOIDS DUE TO DUST INCLUSIONS & OTHER OBVIOUS DEFECTS LIKELY TO IMPAIR THEIR USEFULNESS OR LIFE	100%
2	DIMENSIONS	AS PER DRAWING	
3	TEST REPORT	VERIFICATION OF TC SUPPLIED BY FIRM	
4	DROP TEST	AS PER SPECIFICATION JSG 0102	
5	PACKING	PACKING SLIP INDICATING SOURCE CODE, MATERIAL GRADE , LOT NO. AND QTY.	100%


ISSUED BY
STANDARD CELL
MR No: 210126 dt: 13/8/21
DATE: 16/8/21 SIGNATURE:

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 00
		Date of Issue 18/06/2021
PLASTIC CONTAINER FOR 125mm PRACTICE SHOT		HAPP/QA/SC/B/011
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**TABLE C. FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED ALONG WITH
EACH SUPPLY OF RAW MATERIAL.**

SL. NO.	INSPECTION DOCUMENTS
1	DIMENSIONAL INSPECTION REPORT FROM SUPPLIER.
2	TEST REPORTS FROM NABL ACCREDITED / GOVT. APPROVED / P.S.U LAB FOR TESTS MENTIONED TABLE NO. A.
3	PACKING SLIP DETAILS
4	GAURANTEE / WARRANTY CERTIFICATE
5	IN ADDITION TO THE ABOVE SOFT COPIES OF ALL THE CERTIFICATES MENTIONED IN TABLE – A SHALL BE SENT TO E-MAIL ID's. happqa.ofb@ofb.gov.in , mmhapp.ofb@ofb.gov.in
NOTE	EXPLICIT DEVIATION(S) IF ANY SUCH AS TYPOGRAPHICAL ERROR, VALUES, NUMERIC, OTHER PARAMETER, ETC IS/ARE FOUND IN MONITORING INSTRUCTION OF THE ABOVE STORES, THE RELEVANT STANDARD CONFORMING TO THE CONCERNED SPECIFICATIONS SHALL BE REFERRED TO CONFIRM THE PARAMETER


 26/06/2021
JAGVIMAL PHOGAAT
 WM / ASSY(USER SECTION)
 MEMBER / MI COMMITTEE


 28/06/21
SREENIVASA RAO BODALA
 DGM / PM
 MEMBER / MI COMMITTEE


 26/06/2021
SEINUNNOM JOSEPH KIPGEN
 DGM / QA
 MEMBER / MI COMMITTEE


 26/06/21
T.PRABHU
 JT.GM / QA
 CHAIRMAN / MI COMMITTEE

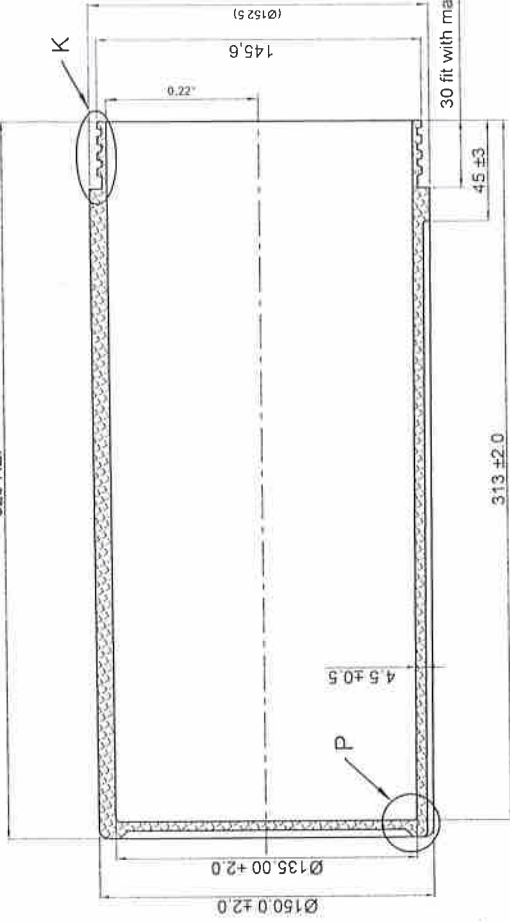
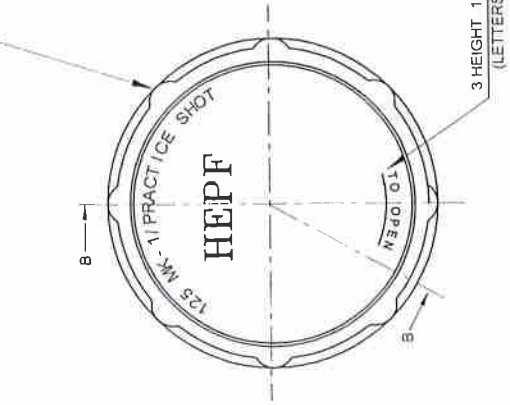


DRG: NO	REV
H OMA 125 1 185 1	1

1 BODY

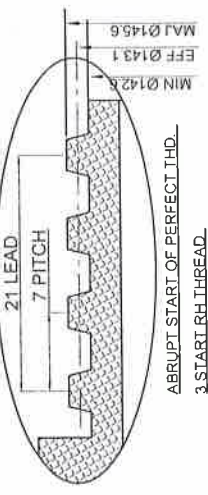
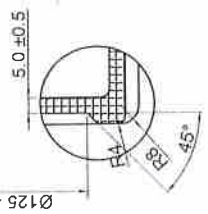
320 REF

8 RIBS EQUISPACED



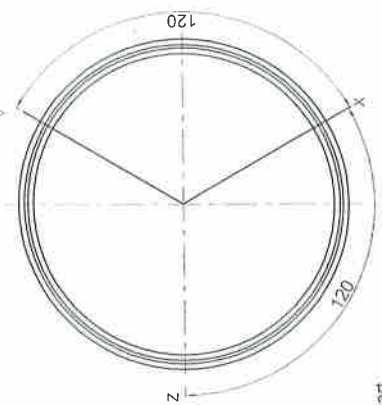
VIEW-P

VIEW-K



SECTION AT BB

3 START RH THREAD SHOWING AT XYZ



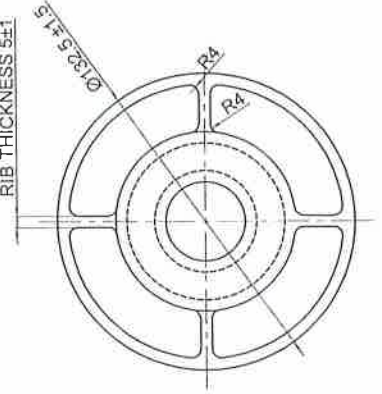
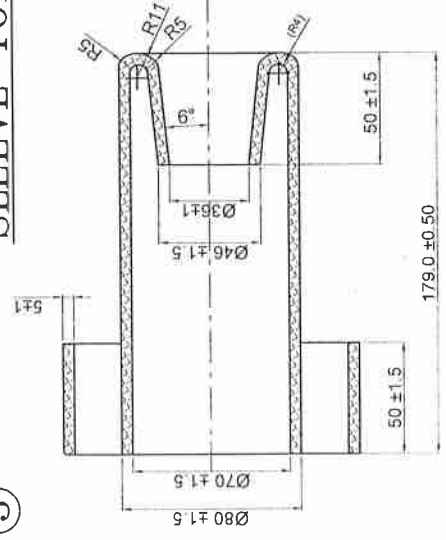
TRADE ACTION

6 GASKET



MBS No. 210136
 DATE: 20/11/21
 SIGNATURE: [Signature]
 dtd: 13/8/21

3 SLEEVE TOP

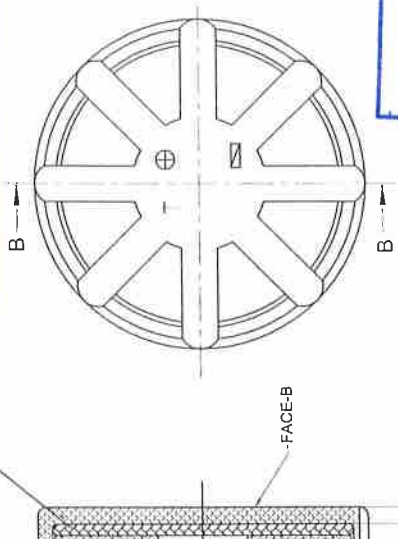


ALL DIMENSIONS ARE IN MM
 REMOVE ALL SHARP EDGES

LATEST REFERENCE	
DRAWN	[Signature]
CHECKD. USER SEC	[Signature]
CHECKD. HOS SC	[Signature]
DATE	18 11 21
ISSUE	ALTERATIONS
1 Dims & Tol amended for moulding & OFB emblem removed	
TITLE :	
CONTAINER FOR	
125mm FSAPDS PRACTICE SHOT	
HEAVY ALLOY PENETRATOR PROJECT	
TIRUCHIRAPALLI	
MATERIAL	
HEAT TREAT/GROUND	
SURFACE TREAT	
SUR. FINISH/COAT	
EST. MASS. PRO/FINAL	
DRG. NO.	H OMA 125 1 185 1
REV	2 OF 3
SHEET	1
DATE	18 11 21
SCALE	NTS
SECTION	9C
APPRD.	[Signature]

DRG. No
H OMA 125 1 185 1

TRADE ACTION



##512 +2.0
525+2

IMPORTANT NOTE: MANUFACTURER SHALL ENSURE ## THIS MARKED DIMENSION DURING FITMENT

ISSUED BY
STANDARD CC
MPSN: 20136 dt. 13/8/24
DATE: 20/11/24 SIGN: [Signature]

NOTES:

1. MATERIAL (FOR ITEM 1, 2, 3 & 4)
HIGH DENSITY POLYETHYLENE TO SPEC.. JSS 9330-03:2014 ORANGE COLOUR.
2. HARDNESS (FOR ITEM NO. 6): CLASS 'C2' 51 TO 55 NOT TO EXCEED HIGH LIMIT
3. ITEM NO. 6 TO BE FREE FROM FLASH ON SURFACE. PRESERVED IN TALC DUST.
TO BE APPLIED WITH SILICON GREASE BEFORE ASSEMBLY.
4. CONTAINER WITH SHOT SHALL CONFORM TO SPEC.. FOR DROP TEST-JSG 0102.
5. ITEM NO. 5 TO BE PASTED INSIDE BOTTOM OF THE ITEM NOS. 1 & 2 RESPECTIVELY
DRAFT ANGLE 0.25° UNLESS OTHERWISE SPECIFIED FOR MouldING PURPOSE
6. ALL SHARP EDGES TO BE ROUNDED OFF WITH R1
8. MARKING :-
"HEPF" AS SHOWN IN ITEM NO 2 (TO BE EMBOSSED IN 20 SIZE & 2 THICK AT FACE 'B')
FOLLOWING DETAILS ARE TO BE EMBOSSED IN FACE 'A' OF ITEM NO. 2

- ⊕ YEAR OF MANUFACTURING
+ 125mm PRACTICE SHOT
☑ MANUFACTURE'S INITIAL

TO BE EMBOSSED IN
SIZE 8mm X 1.2mm THICKNESS

SL.NO	DESCRIPTION	MATERIAL	QTY
6	GASKET	NEOPRENE RUBBER TO SPEC: IND/ME/864(PROV)	1
5	CUSHION PAD	SPONGE RUBBER TO SPEC: IND/ME/845	2
4	SLEEVE BOTTOM	NOTE - 1	1
3	SLEEVE TOP	NOTE - 1	1
2	BODY	NOTE - 1	1
1	LID	NOTE - 1	1

ALL DIMENSIONS ARE IN mm.
REMOVE ALL SHARP EDGES

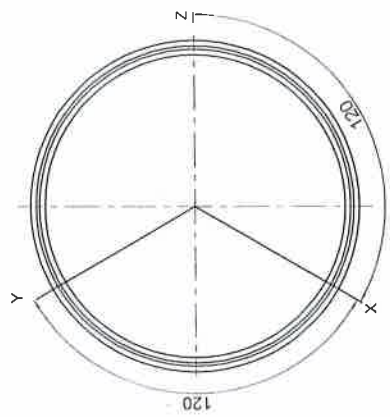
MATERIAL		LATEST REFERENCE	
HEAT TREAT/GROUND		DRAWN	
SURFACE TREAT		CHECKD	
SUR. FINISH/COAT		USER SEC	
EST.MASS PRO/FINAL		CHECKD.	18 11 21
		HOS SC	
		APPRD.	19/11
		DATE	18 6 21
		SCALE	NTS
		SECTION	SC
		DRG. NO.	H OMA 125 1 185 1
		REV	1

TITLE : CONTAINER FOR
125mm FSAPDS PRACTICE SHOT

HEAVY ALLOY PENETRATOR PROJECT
TIRUCHIRAPALLI

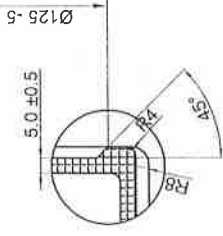
DRG. No	REV
H OMA 125 1 185 1	1

② LID

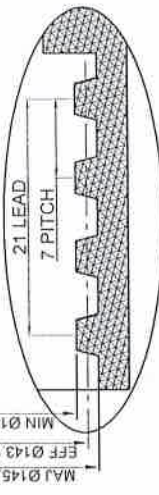


3 START RH THREAD SHOWING AT XYZ

VIEW-M

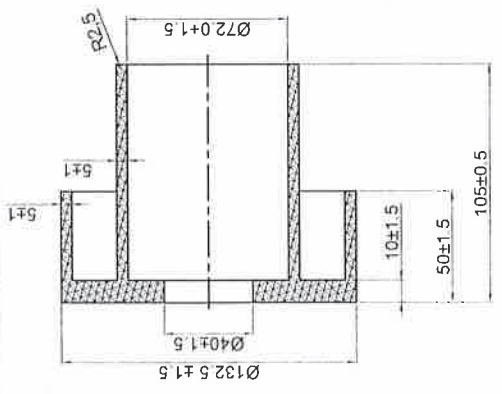


VIEW-N

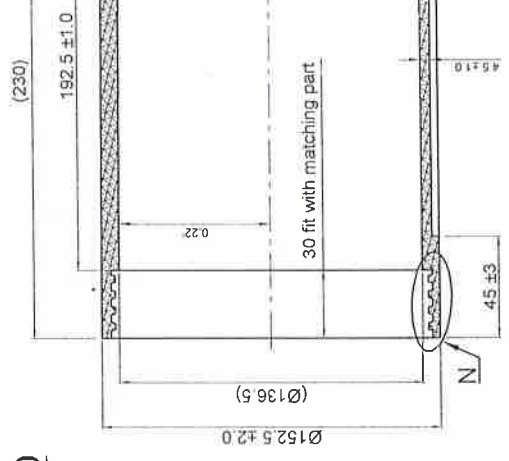
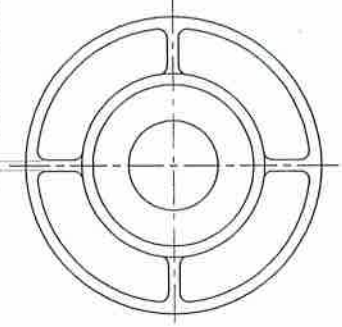


ABRUPT START OF PERFECT THD.
3 START RH THREAD.

④ SLEEVE BOTTOM



RIB THICKNESS 5±1



(230)

192.5 ± 1.0

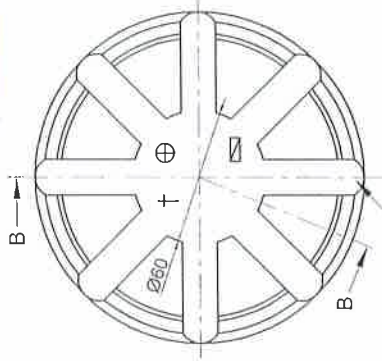
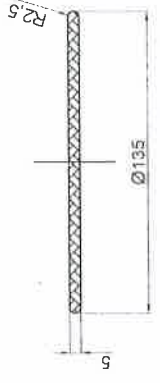
0.22

30 fit with matching part

45 ± 3

45 ± 10

⑤ CUSHION PAD (TOP & BOTTOM)



8 RIBS EQUI-SPACED
ROUNDED OFF ON SIDES AND THE BOTTOM

ALL DIMENSIONS ARE IN mm.
REMOVE ALL SHARP EDGES

MATERIAL		LATEST REFERENCE :-
HEAT TREAT/GROUND		
SURFACE TREAT		
SUR. FINISH/COAT		
EST. MASS PRO/FINAL		
<p>TITLE : CONTAINER FOR 125mm FSAPDS PRACTICE SHOT HEAVY ALLOY PENETRATOR PROJECT TIRUCHIRAPALLI</p>		
DATE	18.11.21	SHEET
SCALE	4:6:21	3 OF 3
SECTION	NTS	SC
APPRD.		REV
CHECKD. USER SEC		DRG. NO:
DRAWN		H OMA 125 1 185 1

DATE: 20/11/21
SIGNATURE: [Signature]

TRADE ACTION

JSS 9330 - 03 : 2014
(Revision No. 3)

7.4 **Test Requirements.** Samples taken from any portion of the batch/lot/consignment of material shall conform to clause 3 and in addition shall conform to the test requirements shown in the following tables :-

(a) **Chemical Requirements.**

Sl. No.	Characteristic	Passing Standard			Test Method
		(Low Density)	(Linear Low Density)	(High Density)	
(a)	Ash, % by mass	Max. 0.05	0.5	0.05	IS 1060 (Part 1) Method 11
(b)	pH of water extract	Min. 5 Max. 8	5 8	5 8	IS 1060 (Part 1) Method 10
(c)	Water soluble matter, % by mass	Max. 0.2	0.2	0.2	Appendix 'A'
(d)	Water soluble chlorides calculated as Sodium Chloride, % by mass	Max. 0.05	0.05	0.05	IS 1060 (Part 2) Method 17
(e)	Water soluble sulphates, calculated as anhydrous Sodium sulphate, % by mass	Max. 0.1	0.1	0.1	IS 1060 (Part 2) Method 18
(f)	Solubility in Toluene at 80 °C ± 1 °C	Soluble	Partially Soluble	Insoluble	Appendix 'B'
(g)	Extractable matter in Toluene at 25 °C ± 1 °C, % by mass	Max. 6.0	6.0	---	Appendix 'C'
(h)	Solubility in Ethyl acetate, Acetone at 25 °C ± 1 °C	Insoluble	Insoluble	Insoluble	Appendix 'D'
(j)	Effect of organic solvents	Resistant below 60 °C	Resistant below 60 °C	Resistant below 80 °C	Appendix 'E'

(b) Physical Requirements.

Sl. No.	Characteristic	Passing Standard					Test Method
		(Low Density Type)		(Linear Low Density)	(High Density Type)		
		1	2		1	2	
(a)	Melt flow index	--	2 ± 20 %	2 ± 20 %	--	8 ± 20 %	ASTM - D 1238
(b)	Density g/ml Min. Max.	0.910 0.925	0.918 0.922	0.916 0.920	0.941 0.965	0.955 0.959	BS 2782 Pt 6 Method No. 620 A : 1991
(c)	Yield stress, MPa Min.	7	12	20	21	23	BS 2782 Pt 3 Method 320 A : 1976 (1986)
(d)	Elongation% at yield Min.	90	560	500	15	10	-- do --
(e)	Impact strength (Notched) in mJ/mm ² Min.	--	--	--	--	2.7	ASTM - D 256 Method A
*(f)	Melting temperature, °C Min. Max.	98 115	98 115	122 124	128 133	128 133	--
*(g)	Tensile modulus in MPa Min.	98	98	350	530	530	ASTM - D - 638
*(h)	Heat deflection temperature at 4.6 kg/cm ² load, °C Min.	60	60	68	83	83	ASTM - D - 648

Note.

(i) The tests mentioned at Sl. No. (f), (g) & (h) are for information only. The limits for the same will be finalized after generation of date.

(ii) The width of specimen for yield stress and elongation should be 6 mm and rate of traverse of the machine while testing should be 50 mm / minute.

