

<b>MONITORING INSTRUCTION FOR COMPONENT INSPECTION</b>	<b>Issue No. 01</b> <b>Rev. No. 02</b>
	<b>Date of Issue</b> 09/07/14
<b>BODY (ASSY. CENTRE CONTACT)</b>	<b>HAPP/QA/SC/ZI/012</b>

DRAWING NO. : HAPP Drg.. NO. C ROC 060 1 119 REV 0 DT. 25.07.09  
(NASK DRG 1068(8/1) DT.08.09.09)  
RAW MATL. : STEEL TO BS 970 ( PT- 1)- 1983 GRADE 080 M 40  
END USE : FOR ASSY ADAPTOR OF RGB 60 ROCKET.

**A.INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES BY NAI REP.**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE CLEAN, SMOOTH AND FREE FROM SHARP EDGES, POROSITY, CRACKS OR OTHER DEFECTS.	100 %
2	DIMENSIONS	AS PER DRAWING.	100 %
3	CHEMICAL COMPOSITION (IN %)	CARBON - 0.36 to 0.44 MANGANESE - 0.60 to 1.00 SULPHUR - ≤ 0.05 SILICON - 0.10 to 0.40 PHOSPHOROUS - ≤ 0.05	1 SAMPLE / HEAT
4	TENSILE TEST	TENSILE STRENGTH - 550 N/MM <sup>2</sup> MIN YIELD STRENGTH - 280 N/MM <sup>2</sup> MIN % ELONGATION - 16 % MIN CHARPY IMPACT TEST - 16 J MIN.	2 Samples / heat
5	HARDNESS	152 TO 207 HB	2 SAMPLES / LOT OR HEAT
6	PROTECTIVE FINISH.	AS PER DRAWING	100 %

**NOTE 1 :**

1. THE RAW MATERIAL TO BE OFFERED FOR INSPECTION ALONG WITH CHEMICAL, MECHANICAL AND OTHER TEST CERTIFICATES DULY TESTED FROM NABL ACCREDITED OR GOVT. APPROVED LAB AND RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE, HEAT NO., QTY, PURCHASED AND NO. OF BARS ARE TO BE MENTIONED IN THE INSPECTION CALL LETTER
2. THE RAW MATERIAL SAMPLES / TEST SPECIMENS FOR EACH HEAT SHALL BE SELECTED FROM BULK RAW MATERIAL AT FIRM'S PREMISES BY NAI REP. AND FORWARDED TO NEARBY NABL ACCREDITED OR GOVT. APPROVED LABORATORY FOR TESTING.
3. MANUFACTURE OF COMPONENT SHOULD BE DONE ONLY AFTER GETTING RAW MATERIAL CLEARANCE FROM NAI.

VETTED

*hdp*  
DO / Standard Cell

*S.K. 972*

**BODY (ASSY CENTRE CONTACT) ( RGB 60)**  
**TO MI NO. HAPP/QA/SC/ZI/012 ISS:1 REV:2 DATE 09/07/14**

**B INSPECTION CHECK TO BE CARRIED AT HAPP AFTER RECEIPT**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
<b>1</b>	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE CLEAN, SMOOTH AND FREE FROM SHARP EDGES, POROSITY, CRACKS OR OTHER DEFECTS.	WORKMANSHIP (VISUAL)
<b>2</b>	DIMENSIONS	AS PER DRAWING.	DIMENSIONS
<b>3</b>	VERIFICATION OF DOCUMENTS	NAI I- NOTE	

**NOTE 2 :**

1. 100 % LOT SHALL BE INSPECTED BY NAI REP. IN ASSOCIATION WITH FIRM REP. / INSPECTORS AT FIRM'S PREMISES.
2. THE RAW MATERIAL SAMPLES / TEST SPECIMENS SHALL BE SELECTED BY NAI REP. FROM BULK COMPONENTS AFTER MANUFACTURE AND FORWARDED TO NEARBY NABL ACCREDITED OR GOVT. APPROVED LABORATORY FOR TESTING.
3. MATERIAL TO BE DESPACHED TO HAPP ONLY AFTER GETTING CLEARANCE FROM NAI.

VETTED

*[Handwritten Signature]*

DO / Standard Cell

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