

MONITORING INSTRUCTION FOR INSPECTION

Issue No. 01
Rev. No. 06

Date of Issue
02.03.2020

DIAPHRAGM (ASSY ADAPTER)

HAPP/QA/SC/ZI/011

Rev no	Amendment	Date
6	Specification changed to IS 2856:1999 was IS 2856:1987	02.03.2020

DRAWING NO. : NASK 1068/7
 MATERIAL SPECN : STEEL AS PER IS 2856 : 1999 GR.3
 END USE : FOR ASSY ADAPTER OF OF RGB 60.

ISSUED BY
STANDARD CELL
 MRS 190230 dt. 24/12/19
 DATE: 12/3/20 SIGNATURE:

TABLE 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 MATERIAL SHALL BE CLEAN AND FREE FROM SHARP EDGES, INTERNAL FLAWS LIKE PIN HOLES, POROSITY, CRACKS & DISTORTION OR OTHER HARMFUL DEFECTS.	100%
2.	DIMENSIONS	AS PER DRAWING.	
3.	CHEMICAL COMPOSITION (%)	STEEL AS PER IS 2856 : 1999 GR.3	ONE SAMPLE PER HEAT
4.	MECHANICAL PROPERTIES		2 SAMPLES PER HEAT

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 LABORATORY FOR TESTING.
2. THE FIRM HAS TO CHECK FOR THE DIMENSIONS, VISUAL DEFECTS AND MARKING AS PER TABLE A. AFTER COMPLETION OF DIMENSIONAL, CHEMICAL AND MECHANICAL PROPERTIES, 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 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.

**TABLE 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 MATERIAL SHALL BE FREE FROM SHARP EDGES, CRACK, BEND, MISMATCH, SURFACE IMPERFECTION AND OTHER INJURIOUS DEFECTS	100 %
2	DIMENSIONS	AS PER DRAWING.	
3	RADIOGRAPHIC EXAMINATION	IS 12938	100%
4	PROTECTIVE FINISH	AS PER DRAWING	100 %
5	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. IN CASE OF BLOW HOLES, IT IS TO BE REPAIRED AS PER IS 5530
5. 100 % LOT SHALL BE INSPECTED BY NAI REP. / INSPECTORS AT FIRM'S PREMISES.

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6.. MATERIAL TO BE DESPATCHED TO HAPP ONLY AFTER GETTING CLEARANCE FROM NAI.

7. THE FIRM HAS TO DESPATCH THE MATERIAL/COMPONENT ALONG WITH NAI I-NOTE ONLY.

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

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE CLEAN AND FREE FROM SHARP EDGES, INTERNAL FLAWS LIKE PIN HOLES, POROSITY, CRACKS & DISTORTION OR OTHER HARMFUL 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 %


TABLE 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, MECHANICAL & RADIOGRAPHIC TEST CERTIFICATES FROM NABL ACCREDITED
3.	DIMENSION REPORT INCLUDING VISUAL.
4.	PACKING SLIP DETAILS.
5.	GUARANTEE / WARRANTY CERTIFICATE OF SUPPLIER.
6.	NAI - I-NOTE.
7.	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	IN CASE OF ANY DIFFERENCES, QAP & DRAWING SHALL PREVAIL

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.


D.BHASKAR RAO
WM / PM
MEMBER / MI COMMITTEE


M.RAMESH PARANI
AWM / R&D
CHAIRMAN / MI COMMITTEE

