

<b>MONITORING INSTRUCTION FOR INSPECTION</b>	Issue No. 01 Rev. No. 01
	Date of Issue 23/04/2018
<b>REAR RUBBER SEAL</b>	<b>HAPP/QA/SC/G/034</b>

**DRAWING NO. : C RRS 125 6 602 0**

**SPECIFICATION : SILICON RUBBER TO SPEC.  
DTD 818 CLASS "L" - 3.**

**END USE : 125 MM FSAPDS DOP 550 mm**

**A** INSPECTION BY HAPP REPRESENTATIVE IN PRESENCE OF BOTH AT TWO STAGES VIZ. COMPOUND STAGE AS WELL AS CURED RUBBER SEAL PART STAGE.

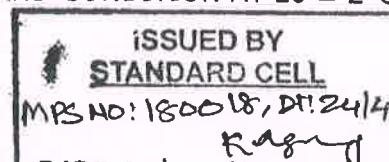
TESTS WILL BE CARRIED OUT 1. FIRM'S PREMISES

**STAGE 1: ON COMPOUNDED RUBBER STOCK**

COMPOSITION SHALL ESSENTIALLY CONSIST OF SILICONE RUBBER GUM FULLY COMPOUNDED WITH A SUITABLE VULCANISING AGENT AND FILLER. CUT SAMPLES FROM TWO TEST SPECIMENS ( 10 INCH & 3 INCH SQUARE RESPECTIVELY ) AS PER DTD 818 SPECIFICATION TO BE TAKEN FROM SUITABLY CURED SHEETS AND TO BE TESTED AS PER TABLE BELOW.

SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	REMARKS
1	HARDNESS	60 +/- 5 SHORE "A"	FOR EACH BATCH OF COMPOUND
2	TENSILE STRENGTH	700 lb / sq. in ( MIN)	(ON TYPE D TEST PIECES)
3	ELONGATION AT BREAK	200 % Min.	
4	SPECIFIC GRAVITY AT 20 ° C .	NOMINAL ± 0.05 g / cc.	AS PER PROCEDURE A
5	BRITTLINESS TEMPERATURE ( FLEXIBILITY AT LOW TEMPERATURE)	-55 ° C MAX. ( SHOULD PASS WHEN TESTED AS PER ASTM D 746 - 55 T PROCEDURE B )	(AS PER APPENDIX II )
6	RESISTANCE TO DRY HEAT	1. CHANGE IN HARDNESS = 10 B.S. DEGREES (MAX) 2. TENSILE STRENGTH DETERIORATION=25 %( MAX) 3. ELONGATION AT BREAK DETORIORATION=50%(MAX)	(AS PER APPENDIX III ) ****

\*\*\*\* - NOTE : TYPE D DUMB-BELL TEST PIECES ARE TO BE SUSPENDED FOR 14 DAYS IN AN AIR OVEN AT 200 ± 5 ° C AND THEN ALLOWED TO COOL AND CONDITION AT 20 ± 2°C FOR 24 HRS. BEFORE TESTING.



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**STAGE 2 :TESTS TO BE CARRIED OUT ON CURED RUBBER PART.**

SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	REMARKS
1	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.	ON 10 % SAMPLES
2	DIMENSIONS AND MASS	AS PER HAPP DRAWING <b>C RRS 125 6 602 0</b>	30 NOS. / LOT
3	SPECIFIC GRAVITY AT 20 ° C	NOMINAL ± 0.05 g / cc.	FOR EACH LOT
4	HARDNESS	60 +/- 5 SHORE "A"	(ON TYPE D OR TYPE C TEST PIECES)
5	TENSILE STRENGTH (ON TYPE D TEST PIECES)	700 lb / sq. in ( Min)	
6	ELONGATION AT BREAK	200 % (Min)	
7	PROPER PACKING	SHOULD BE PACKED IN POLY BAGS WITH PACKING SLIP INDICATING LOT NO. SOURCE, SUPPLY ORDER NO. & QTY.	FOR EACH CONSIGNMENT
8	MARKING	CONTRACTOR'S INITIAL OR RECOGNISED TRADE MARK AND PART NO. <b>125 MM FSAPDS DOP 550</b> ,DATE OF MANUFACTURE (MONTH & YEAR) AND LOT NO. ARE TO BE SCREEN PRINTED (WITH 3 MM SIZE LETTERS) AS PER DRG.	

<b>ISSUED BY</b> <b>STANDARD CELL</b> MPS NO: 180018, DT: 24/4 DATE: 25/4 SIGNATURE: <i>R. Ag...</i>
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**B. INSPECTION CHECK TO BE CARRIED OUT ON RECEIPT AT HAPP.**

SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	SAMPLING
1	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.	10 %
2	PROPER PACKING	SHOULD BE PACKED IN POLY BAGS WITH PACKING SLIP INDICATING LOT NO. SOURCE, SUPPLY ORDER NO. & QTY.	FOR EACH CONSIGNMENT
3	MARKING	CONTRACTOR'S INITIAL OR RECOGNISED TRADE MARK AND PART NO. <b>125 MM FSAPDS DOP 550</b> , DATE OF MANUFACTURE (MONTH & YEAR) AND LOT NO. ARE TO BE SCREEN PRINTED (WITH 3 MM SIZE LETTERS) AS PER DRG.	FOR EACH CONSIGNMENT

**C. VERIFICATION OF ADEQUECY OF INSPECTION DOCUMENTS.**

SL. NO.	INSPECTION DOCUMENTS
1	FIRM'S MATERIAL TEST CERTIFICATES WITH LOT / BATCH NO. & QTY.
2	FIRM'S DIMENSIONAL & VISUAL INSPECTION REPORT
3	PACKING SLIP INDICATING LOT / BATCH NO. & QTY. DETAILS
4	INSPECTION / ACCEPTANCE DOCUMENTS ISSUED BY HAPP.
5	IN ADDTION TO THE ABOVE SOFT COPIES OF ALL THE CERTIFICATES MENTIONED IN TABLE - B SLNO 1,2,3&4 SHALL BE SENT TO E-MAIL ID's. <a href="mailto:happqa.ofb@ofb.gov.in">happqa.ofb@ofb.gov.in</a> , <a href="mailto:mmhapp.ofb@ofb.gov.in">mmhapp.ofb@ofb.gov.in</a>

*Mithlesh Chandra*  
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 AWM / ASSY  
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*D. Bhaskar Rao*  
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**ISSUED BY**  
**STANDARD CELL**  
 MFS NO: 180018, Dt. 24/4  
**DATE: 25/4** SIGNATURE: *R. Raju*