

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 01
		Date of Issue 27.02.2020
STEEL ROD Ø150mm		HAPP/QA/SC/ZI/089
Rev no	Amendment	Date
1	Supply condition : added .BS 970 PT-3:91 was BS 970 PT-1:83	27.02.2020

SPECIFICATION : BS 970 (PT-3):91 GR.817M40 (En 24)

CONDITION OF SUPPLY: HARDENED AND TEMPERED

END USE : NOZZLE PLATE - A/S ROCKET RGB 60 EMPTY

TABLE A. RAW MATERIAL INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES BY THE FIRM.

SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE CLEAN AND FREE FROM SHARP EDGES, POROSITY, CRACKS, DISTORTION AND ANY OTHER HARMFUL DEFECTS.	100 %
2	OUTER DIAMETER	150 MM +2.0 / - 0.0 MM	AS PER NAI SPEC A31 B
3	LENGTH	1 METRE OR ITS MULTIPLES	
4	CHEMICAL COMPOSITION (%)	BS 970 - PT 3:91 GRADE 817M40 ✓	1 SAMPLE PER HEAT
5	MECHANICAL TESTING	BS 970 - PT 3:91 GRADE 817M40 (HARDENED AND TEMPERED 'T' CONDITION)	2 SAMPLES PER HEAT
6	MARKING	EACH BAR SHALL BE LEGIBLY STAMPED WITH MANUFACTURER'S IDENTITY & HEAT NUMBER.	EACH CONSIGNMENT
7	PACKING	PACKING OF THE MATERIAL SHALL BE DONE IN SUCH A MANNER TO AVOID CORROSION AND DAMAGE IN HANDLING AND TRANSIT.	

NOTE:

1. THE RAW MATERIAL SAMPLES / TEST SPECIMENS FOR EACH HEAT SHALL BE SELECTED FROM BULK AT FIRM'S PREMISES BY NAI/HAPP 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 FORWARD THE FOLLOWING DOCUMENTS TO NAI/TRICHY.
 - I. THE RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE, HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS ARE TO BE MENTIONED IN THE INSPECTION LETTER TO NAI/TRICHY.
 - II. THE CHEMICAL MECHANICAL AND ULTRASONIC TEST CERTIFICATES FROM NABL ACCREDITED LAB AS PER TABLE A
 - III. DIMENSION REPORT INCLUDING VISUAL AS PER TABLE A.
3. ALL THE ABOVE DOCUMENTS ARE TO BE FORWARDED TO NAI/TRICHY WITH A COPY TO GM/HAPP.
4. THE NAI/TRICHY SHALL VERIFY ALL THE DOCUMENTS AS ABOVE AND ACCORD CLEARANCE FOR DISPATCH OF THE MATERIAL TO HAPP IF ALL DOCUMENTS ARE IN ORDER.
5. MATERIAL HAS TO BE DESPATCHED TO HAPP ONLY AFTER DUE SUBMISSION OF ALL RELATED DOCUMENTS AS DETAILED IN TABLE A AND AFTER GETTING CLEARANCE FROM NAI/TRICHY.



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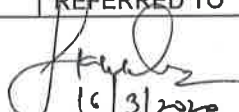
TABLE B.INSPECTION CHECK TO BE CARRIED OUT AT HAPP BY NAI/TRICHY AFTER RECEIPT.


SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE CLEAN AND FREE FROM SHARP EDGES, POROSITY, CRACKS, DISTORTION AND ANY OTHER HARMFUL DEFECTS.	100 %
2	OUTER DIAMETER	150 MM +2.0 / - 0.0 MM	AS PER NAI SPEC A31 B
3	LENGTH	1 METRE OR ITS MULTIPLES	
4	CHEMICAL COMPOSITION(%)	BS 970 - PT 3:91 GRADE 817M40	1 SAMPLE PER HEAT
5	MECHANICAL TESTING	BS 970 - PT 3:91 GRADE 817M40 (HARDENED AND TEMPERED 'T' CONDITION)	2 SAMPLES PER HEAT
6	MARKING	EACH BAR SHALL BE LEGIBLY STAMPED WITH MANUFACTURER'S IDENTITY & HE AT NUMBER.	EACH CONSIGNMENT
7	PACKING	PACKING OF THE MATERIAL SHALL BE DONE IN SUCH A MANNER TO AVOID CORROSION AND DAMAGE IN HANDLING AND TRANSIT.	


1. THE NAI/TRICHY SHALL VERIFY ALL THE PARAMETERS AS ABOVE AND AFTER SATISFACTORY RESULTS, NAI/TRICHY SHALL ISSUE I-NOTE FOR THE MATERIAL RECEIVED.
2. MATERIAL/COMPONENT WILL BE CLEARED/ACCEPTED BASED ON NAI I-NOTE/CLEARANCE CERTIFICATE ONLY.
3. MATERIAL HAS TO BE REPLACED 100% BY THE FIRM IN CASE OF NON CONFORMITY TO SPECIFICATION AS PER TABLE A, NOTE AND TABLE B DURING NAI INSPECTION AT HAPP, TRICHY.

TABLE C. 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 AND MECHANICAL & ULTRASONIC TEST CERTIFICATES FROM NABL ACCREDITED
3	DIMENSION REPORT INCLUDING VISUAL, REPORT
4	PACKING SLIP DETAILS
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	1.IN CASE OF ANY DIFFERENCES, QAP & DRAWING SHALL PREVAIL 2. 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 SPECIFICATION BS 970 (PT- 3)- 91 SHALL BE REFERRED TO CONFIRM THE PARAMETER


 16/3/2020
AKHILESH GAUR
 AWM / P
 MEMBER / MI COMMITTEE


 16/3/2020
M.RAMESH PRASAD
 AWM / R&D
 CHAIRMAN / MI COMMITTEE


D.BHASKAR RAO
 WM / PM
 MEMBER/MI COMMITTEE
 SIGNATURE: