

QUALITY MONITORING INSTRUCTION (QMI) FOR INSPECTION (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 24 /06/ 2021
Drg . No.	Y17411A-00								OFT/QMI/SRCG/ RM/Y17411A-00
Nomenclature	BASE, CASTING								
Material Specification	Al. Alloy A357.0 T6 PER AMS-A-21180 CL 12. AMS-STD-2175 CLASS 4 GRADE D.HEAT TREATMENT ACC.TO AMS STD 2771-T6								
Nomenclature	Charateristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by QAE(N), Chennai or by Nominated Agency (Review/Witness)	Remarks
BASE, CASTING (Raw material)	Conditions of Supply (Heat Treatment)	Non Critical	Mechanical Lab analysis	100%	As per Specification / As per Contract / Drawing.	As per Specification / As per Contract / Drawing.	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
	Dimensional Tolerances	Non Critical	Measuring Instruments	100%			Firm Inspection report	W	
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	
	Chemical properties	Non Critical	Chemical Lab analysis	One sample per heat	As per Contract / Drawing (if applicable)	As per Contract / Drawing (if applicable)	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	Mechanical properties	Non Critical	Mechanical Lab analysis				Test report from NABL lab	R	
	Test Piece Hardness	Non Critical	Mechanical Lab analysis				Test report from NABL lab	R	
	NMIR & MACRO	Non Critical	Mechanical Lab analysis				Test report from NABL lab	R	

**Note** 1. Packing: The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.  
2. Marking: Each Packing shall be legibly marked with manufacturer's identity , Qty, Heat No, OFT Supply order No etc.  
3. Raw material sample minimum of 300mm should be supplied for cross verification along with the first supply of stores.  
4. Parameters mentioned in Drawing/Contract shall prevail over parameters in Specifications in case of any difference.