

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 02
		Date of Issue 02.05.19
OBTURATOR		HAPP/QA/SC/G/033
Rev no	Amendment	Date
2	Type test details added for new source development as per guidelines from ARDE.Ref Ltr No:ARDE/1/1/10-TECH	05.04.19

**** SIX NUMBERS OF BANDS TAKEN FROM THE ANNEALED AND MACHINED BAND LOT AND MACHINED TO A THICKNESS OF 1.5 TO 2mm (SPECIMEN MACHINING PARAMETERS AS RECOMMENDED IN THE PARA14.7.5.1 OF SPEC. CQA(A) 0318A) AND STRIP TO BE CUT ALONG THE AXIS TO RENDER TENSILE SPECIMENS HAVING SHAPE SIMILAR TO ASTM D-638 TYPE IV AS SHOWN IN ANNEXURE - 1 SHALL BE CONTAINED FOR 72hrs AT 23±2°C AND RH 50% BEFORE TESTING**

IMPORTANT NOTES:

1. FIRM TO OFFER THE LOTS OF COMPLETELY MACHINED BANDS FOR INSPECTION AND TESTING
2. INSPECTION CALL LETTER SHALL BE CLEAR INDICATING QTY, LOT NO, SO NO & RAW MATERIAL BATCH USED / BALANCED AVAILABLE.
3. INSPECTION CALL LETTER SHALL BE ACCOMPANIED WITH TEST REPORTS AND CERTIFICATES FOR ALL THE INSPECTION / TESTS CARRIED OUT BY FIRM DURING RAW MATERIAL, MOULDED STAGE AND FINAL MACHINED STAGE (INCLUDING CERTIFICATE FOR CARRYING OUT 100% DIMENSIONAL INSPECTION & WARRANTY CERTIFICATES).

8.0 TABLE D INSPECTION CHECK TO BE CARRIED OUT ON RECEIPT AT FACTORY

SL. NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	MAJOR THE MATERIAL SHALL BE FREE FROM LAMINATION, CRACKS, BLOW HOLES, INCLUSIONS & ABSENCE OF CHAMFER. MINOR THE MATERIAL SHALL BE FREE FROM SHARP EDGES. SURFACE ROUGHNESS SHALL NOT EXCEED 1.6µm	100% AQL 0.25 FOR MAJOR AND 1.5 FOR MINOR /IL II AS PER DEF 131A
2	MARKING	AS PER DRAWING	AS PER DEF 131 A
3	PACKING	MACHINED BANDS ARE TO BE DELIVERED IN HERMETICALLY SEALED POLY BAGS/CONTAINERS HAVING PROPER IDENTIFICATION FOR BATCH/LOT NO. WHICH IN TURN PUT IN AN FIVE PLY CORRUGATED CARTON BOX TO ACCOMMODATE 10 NOS PER BAG SO AS TO PROVIDE AN EFFECTIVE PROTECTION FOR SEALED TUBE & BANDS FROM PHYSICAL DAMAGE, DIRT OR MOISTURE DURING TRANSIT	EACH CONSIGNMENT
4	DIMENSIONS	AS PER DRAWING	AQL 0.25 FOR MAJOR /1L-II AS PER DEF 131A


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9.0 TABLE F: TYPE TESTING SAMPLES FOR NEW SOURCES OF COMPONENT


The firm should supply 200 no's of Obturator sample for Application/Type test before bulk supply. Out of 200nos duly accepted Obturator assembled over 125mm FSAPDS DOP550, 24 nos will be proof tested. On satisfactory result clearance will be given for bulk production. If results are not satisfactory, double samples are to be tested and if the results are not meeting the requirements, the lot/batch shall be rejected.

10.0 TABLE G: .VERIFICATION OF ADEQUECY OF INSPECTION DOCUMENTS

SL. NO.	INSPECTION DOCUMENTS
1	PACKING SLIP DETAILS, INDICATING RAW MATERIAL, ORGINAL MANUFACTURERS CERTIFICATE, DETAILS OF HEAT NUMBER, SUPPLY ORDER, LOT NO, QTY & HT CONDITION
2	TEST CERTIFICATES FOR PHYSICAL, CHEMICAL, MECHANICAL FROM NABL ACCREDITD LAB OR GOVT APPROVED LABORATORY.
3	DIMENSION REPORT INCLUDING VISUAL
4	SHELF LIFE AND GUARANTEE / WARANTY CERTIFICATE OF SUPPLIER
6	IN ADDITION TO THE ABOVE SOFT COPIES OF ALL THE CERTIFICATES MENTIONED IN TABLE – A, B, C & D SHALL BE SENT TO E-MAIL ID'S. happqa.ofb@ofb.gov.in , mmhapp.ofb@ofb.gov.in
NOTE	1. ALL TEST REPORTS / CERTIFICATES MUST BE COUNTER SIGNED BY FIRM'S HEAD OF QUALITY AND SHOULD HAVE LINK TO HAPP SUPPLY ORDER NUMBER, QTY. IN EACH CASE 2. EXPLICITLY DEVIATION(S) IF ANY SUCH AS TYPOGRAPHICAL ERROR, VALUES, NUMERIC, OTHER PARAMETER, ETC IS/ARE FOUND IN MONITORING INSTRUCTION OF THE ABOVE STORES, CONFORMING TO THE RELEVANT STANDARDS AND SPEC: HAPP/QA/SPEC/008 REV-02 dtd:01.12.05.


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