

## REFERENCE

<b>MONITORING INSTRUCTION FOR INSPECTION</b>		Issue No. 01 Rev. No. 05
		Date of Issue 17/11/15
<b>PLUG REAR</b>	<b>HAPP/QA/SC/E/007</b>	

HAPP DRAWING NO. : C PLG 081 1 030 REV 0  
 RAW MATL. SPECN : BS 970 PART-3 1991 GR. 070 M20  
 SAMPLING SPECIFICATION : MIL-STD-105 OR ANSI ASQC Z 1.4  
 CONDITION OF SUPPLY : NORMALISED OR BRIGHT FINISHED  
 ( OTHER THAN COLD DRAWN )  
 END USE : 81 MM BOMB BODY

**A. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES BY FIRM REP.**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE FREE FROM THREAD DAMAGES SURFACE FINISH SHALL NOT EXCEED 3.2 Ra ALL OVER..	AQL 1.5 / IL S3
2	PACKING	SUITABLY PACKED IN POLY BAGS TO AVOID TRANSIT DAMAGES. EACH POLY BAG SHOULD HAVE PACKING SLIP INDICATING HAPP SUPPLY ORDER NO., RAW MATERIAL HEAT NO., LOT NO. QUANTITY (IN NOS. ) AND PRODUCER'S NAME OR CODE.	EACH CONSIGNMENT
3	CHEMICAL COMPOSITION (% OF RAW MATERIAL)	CARBON - <b>0.16 to 0.24</b> MANGANESE - <b>0.50 TO 0.90.</b> PHOSPHORUS - <b>0.050 MAX.</b> SULPHUR - <b>0.050 MAX.</b>	ONE SAMPLE FOR EACH HEAT / CAST
4	MECHANICAL PROPERTIES OF RAW MATERIAL	UTS - 430 M Pa Min.. YIELD STRENGTH - 215 M Pa Min. % ELONGATION - 21 % Min.	1 SAMPLE / HEAT OR CAST
5	HARDNESS OF RAW MATERIAL	126 TO 179 HB .	2 SAMPLE / HEAT
6	DIMENSIONS	AS PER DRAWING	AQL 1.5 / IL S3

**Note :**

1. Self inspection report ( including dimensions), Raw material Test report duly tested from NABL accredited OR Govt. approved Laboratory for tests mentioned at Sl. No. 3, 4 & 5 is to be submitted along with EACH SUPPLY.

VETTED  
  
 D.O. / Standard Cell  


## REFERENCE


<b>MONITORING INSTRUCTION FOR INSPECTION</b>		Issue No. 01 Rev. No. 05
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**B. INSPECTION CHECK TO BE CARRIED OUT ON RECEIPT AT HAPP BY HAPP REP**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL )	THE COMPONENT SHALL BE FREE FROM THREAD DAMAGES SURFACE FINISH SHALL NOT EXCEED 3.2 Ra ALL OVER..	AQL 1.5 / IL S3
2	PACKING	SUITABLY PACKED IN POLY BAGS TO AVOID TRANSIT DAMAGES. EACH POLY BAG SHOULD HAVE PACKING SLIP INDICATING HAPP SUPPLY ORDER NO., RAW MATERIAL HEAT NO., LOT NO. QUANTITY (IN NOS. ) AND PRODUCER'S NAME OR CODE.	EACH CONSIGNMENT
3	CHEMICAL COMPOSITION (%)OF RAW MATERIAL	CARBON - <b>0.16 to 0.24</b> MANGANESE - <b>0.50 TO 0.90.</b> PHOSPHORUS - <b>0.050 MAX.</b> SULPHUR - <b>0.050 MAX.</b>	ONE SAMPLE FOR EACH HEAT / CAST
4	HARDNESS OF RAW MATERIAL	126 TO 179 HB .	2 SAMPLES / HEAT
5	DIMENSIONS	<b>AS PER DRAWING</b>	AQL 1.5 / IL S3
6	FITMENT TRAIL	<b>SHOULD NOT BE ANY LEAKAGE</b>	<b>20 NOS PER CONSIGNMENT</b>
7	VERIFICATION OF INSPECTION DOCUMENTS	<ol style="list-style-type: none"> <li>1. FIRM'S SELF INSPECTION REPORT FOR DIMENSIONS</li> <li>2. RAW MATERIAL TEST REPORT FROM NABL LAB. FOR CHEMICAL, MECH. PROPERTIES AND HARDNESS.</li> <li>3. GAURANTEE / WARRANTY CERTIFICATE OF SUPPLIER</li> </ol>	

ALL TEST REPORTS / CERTIFICATES MUST BE COUNTER SIGNED BY FIRM'S HEAD OF QUALITY AND SHOULD HAVE LINK TO HAPP SUPPLY ORDER NO. AND QTY. IN EACH CASE.

**VETTED**  
  
 D.O. / Standard Cell 19/11  
  
 17/11

