

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 01
		Date of Issue 02/02/16
TRANSIT PLUG WITH WASHER		HAPP/QA/SC/E/004

HAPP DRAWING NO. : C ITV 081 1 040 REV.1

SAMPLING SPECIFICATION : DEF 131 A

A **INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES :**

NOT APPLICABLE

B **INSPECTION CHECK TO BE CARRIED OUT ON RECEIPT AT FACTORY.**

SL. NO.	CHARACTERITICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	VISUAL	EACH PLUG TO BE FREE FROM DAMAGES AND OTHER MOLDING / VISUAL DEFECTS.	AQL - 1.5 / IL CLASS II G
2	MARKING	EACH PART TO BE EMBOSSED WITH YEAR OF MANUFACTURE MANUFACTURER'S INITIAL OR RECOGNISED TRADEMARK AND LOT NO	EACH CONSIGNMENT
3	RAW MATERIAL	FOR PLUG - PLUG (OLIVE GREEN) MOULDED PLASTIC POWDER (PHENOLIC) GRADE "T" TO SPECN. JSS 1097 (AMENDED TO DATE) CORRESPONDING TO A MINIMUM IMPACT STRENGTH OF 0.27 JOULES & A MINIMUM TENSILE STRENGTH OF 34.47 M Pa. (OR) PLOYSTYRENE MOULDING PLASTIC AMMUNITION TYPE 'B' TO SPECN. NO. JSS 9330-01 (AMENDED TO DATE) FOR WASHER - LOW DENSITY POLYTHENE TO SPECN. JSS 9330-03-1995 TYPE I.	1 SAMPLE / CONSIGNMENT.
4	DIMENSIONS	AS PER DRAWING	AQL 1.5 / IL. S3

C. **VERIFICATION OF INSPECTION DOCUMENTS.**

FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED BY SUPPLIER .

SL. NO.	INSPECTION DOCUMENTS
1	TEST REPORTS FROM NABL ACCREDITED LAB OR GOVT. APPROVED LABORATORY FOR RAW MATERIAL (SUCH AS MECHANICAL, CHEMICAL ETC.)
2	PACKING SLIP DETAILS
3	GAURANTEE / WARRANTY CERTIFICATE OF SUPPLIER.
4	DIMENSIONAL INSPECTION REPORT OF SUPPLIER.
5	DECLARATION IN FIRM'S LETTER HEAD HAVING DETAILS OF RAW MATERIAL PURCHASED QTY., SOURCE, EXPECTED YIELD FROM PURCHASED QTY. ETC. TO BE ENCLOSED (FOR EACH HEAT SEPARATELY)

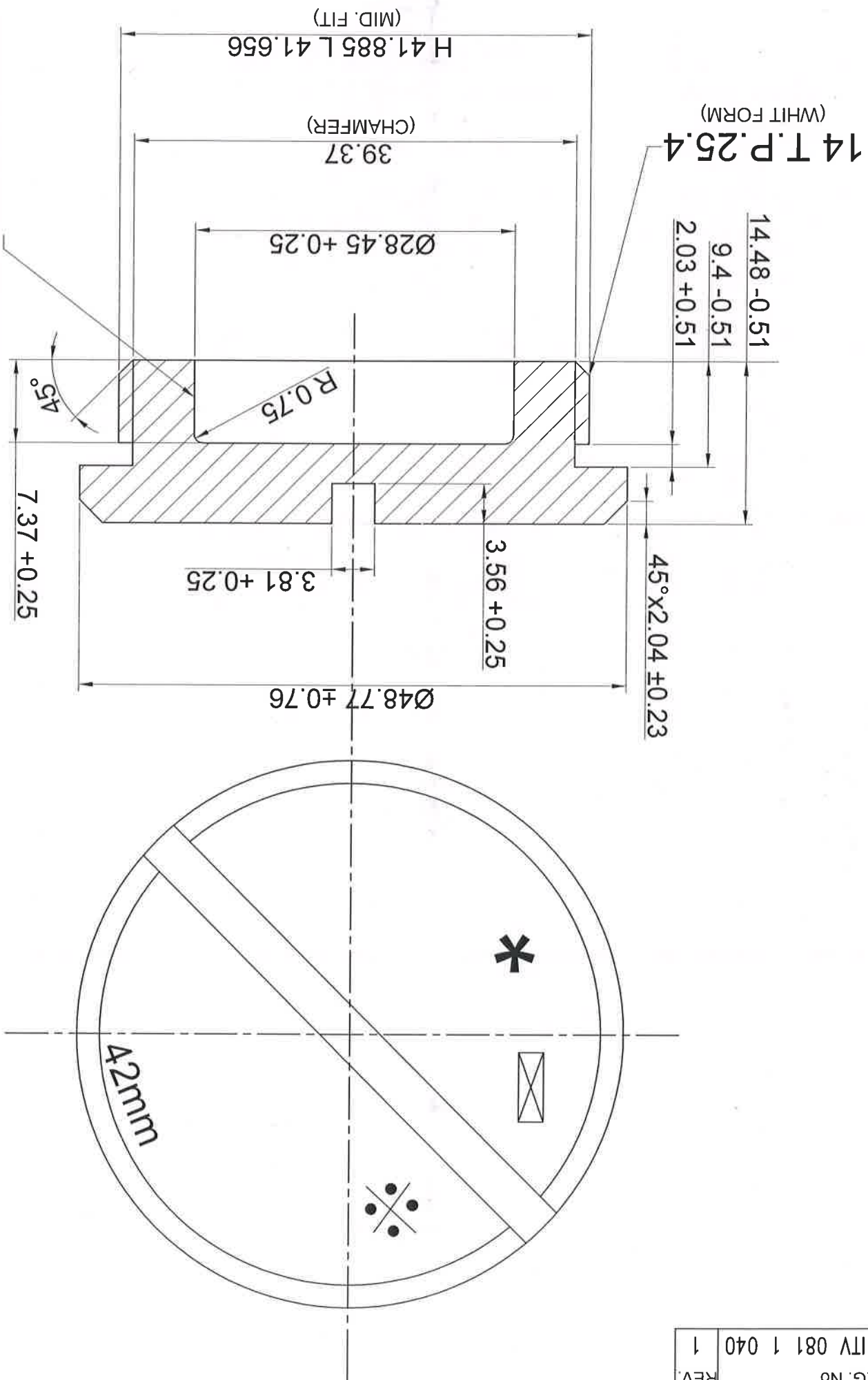
ALL TEST REPORTS / CERTIFICATES MUST BE COUNTER SIGNED BY FIRM'S HEAD OF QUALITY AND SHOULD HAVE LINK TO HAPP SUPPLY ORDER NUMBER, QTY. IN EACH CASE.

VETTED

DO / Standard Cell

Handwritten signature
 02/02/16
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RECESS SLIGHTLY TAPERED MAY BE
FORMED ALTERNATIVELY THE RECESS
MAY BE OMITTED IF DESIRED



TIRUCHIRAPALLI	
HEAVY ALLOY PENETRATOR PROJECT	
TRANSIT PLUG & WASHER 42mm A	
FOR 81mm BOMB BODY	
TITLE :	
ISSUE	ALTERATIONS
1	COLOUR OLIVE GREEN WAS ORANGE COLOUR IN THREAD WHIT FORM WAS WITH FCGM
	19.9.2015
	DATE

ARTERIAL:

PLUG (OLIVE GREEN)

MOLDED PLASTIC POWDER (PHENOLIC) GRADE 'T' TO SPECN JSS 1097 (AMENDED TO DATE) CORRESPONDING TO A MINIMUM TENSILE STRENGTH OF 34.47 Mpa OR POLYSTYRENE MOULDING PLASTIC AMMUNITION TYPE-B TO SPECN NO. JSS 9330-01 (AMENDED UP TO DATE)

MARKING TO BE EMBOSSED IN 5 TYPE

YEAR OF MANUFACTURE (eg 1365)	✱
CONTRACTORS INITIALS OR RECOGNISED TRADE MARK	✱
MARK AS APPLICABLE	✱

NOTES:

SCREW THREADS MAY ACCEPTED IF THE CRESTS ARE FLATTENED
ON DIAMETER TO AN EXTENT NOT EXCEEDING 0.5 ALLOWANCE GIVEN BELOW
0.075 TRUNCATION PERMITTED

WASHER:

LOW DENSITY POLYTHENE TO SPEC. JSS 9330-03-1995 TYPE-1
TO BE USED IN CONJUNCTION WITH A LOW DENSITY POLYTHENE WASHER
TO FOLLOWING DIMENSIONS

OUTER DIA : 48.26 +0.25
INTERNAL DIA : 39.37 +0.25
THICKNESS : H2.34 L1.83