

<h1 style="text-align: center;">QUALITY MONITORING INSTRUCTION FOR INSPECTION</h1>		Issue No : 01
		Rev No:
		Date of Issue / /2021
TEND-2661 (HOUSING LAUNCHER) For 33P 1104		OFT/MI/MSL/33P 1104
Rev.No	Amendment	Date

MATERIAL SPECIFICATION : AL 7075 with T6 Condition.
 CONDITION OF SUPPLY : 95% Finished with Firm's Material.
 END USE : 38mm MSL.
INSPECTION CHECK TO BE CARRIED OUT

Table 'A'

SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The blank shall be free from defects such as rust, scale, burrs and any other harmful defects.	100%
2.	Dimension	100% Dimension check as per drawing.	
3.	Chemical Composition (%)	<u>AL 7075 with T6 Condition.</u> Cr = 0.18-0.28 Si = 0.40 (Max) Cu = 1.20 -2.00 Ti = 0.20 (Max) Mg = 2.10-2.90 Zr+Ti = 0.25 (Max) Zn = 5.10-6.10 other Elements each = 0.05 (Max) Fe = 0.50 (Max) Other Elements Total=0.15 (Max) Mn = 0.30 (Max) Al = Remainder	One Sample Per Heat
4.	Mechanical Properties	<u>AL 7075 with T6 Condition.</u> Tensile Strength = 540 MPa (Min) 0.2% Proof Stress = 485 MPa (Min) Elongation = 7% (Min)	One Sample Per Heat
5.	Other Tests	1. Ultrasonic Test as per Specification Standard. 2. Etching Test as per Specification Standard. 3. Magnetic Particle Test as per Specification Standard.	One Sample Per Heat
6.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	Each Consignment
7.	Marking	Each Packing shall be legibly marked with manufacturer's identity, Qty, Heat No, OFT Supply order No etc.,	

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