

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 03
		Date of Issue 11/04/2017
DIAPHRAGM	HAPP/QA/SC/ZI/019	

DRAWING NO. : NASK 1071/4

MATERIAL SPECN : STEEL AS PER IS 2856-87 GR. 2 (NORMALISED)

END USE : FOR NOZZLE PLATE ASSY OF RGB 60.

A. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES FOR RAW MATERIAL BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE FREE FROM SHARP EDGES, CRACK, BEND, MISMATCH, SURFACE IMPERFECTION AND OTHER INJURIOUS DEFECTS	100%
2.	DIMENSIONS	AS PER DRAWING.	
3.	CHEMICAL COMPOSITION (%)	C - 0.30 Max Mn - 1.00 Max P - 0.040 Max S - 0.045 Max Si - 0.60 Max	ONE SAMPLE PER HEAT
4.	MECHANICAL PROPERTIES	UTS : 485 - 655 Mpa YS : 250 Mpa.Min E : 20% Min. IMPACT TEST : 20 Min (CHARPY V-NOTCH)	

NOTE :

1. THE RAW MATERIAL SAMPLES / TEST SPECIMENS FOR EACH HEAT SHALL BE SELECTED FROM BULK AT FIRM'S PREMISES BY NAI REP. AND FORWARDED TO NEARBY NABL ACCREDITED OR GOVT. APPROVED LABORATORY FOR TESTING.
2. MANUFACTURING OF COMPONENT SHOULD BE DONE ONLY AFTER GETTING RAW MATERIAL CLEARANCE FROM NAI AND SHOULD BE MANUFACTURED AS PER THE MANUFACTURING QUALITY PLAN OF NAI.

**B. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES BY NAI.
(FINISHED PRODUCT STAGE)**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE FREE FROM SHARP EDGES, CRACK, BEND, MISMATCH, SURFACE IMPERFECTION AND OTHER INJURIOUS DEFECTS	100 %
2	DIMENSIONS	AS PER DRAWING.	
3	BLOW HOLE TEST	BLOW HOLES TO BE INSPECTED AS PER IS:5530 - 1969	100 %
4	PROTECTIVE FINISH	AS PER DRAWING	100 %
5	PACKING	SUITABLY PACKED TO AVOID TRANSIT DAMAGES AND SECURELY TIED WITH METAL / PLASTIC TAG.PACKING SLIP SHOULD SPECIFY HAPP SUPPLY ORDER NO. QUANTITY IN NOS. AND PRODUCER'S NAME OR CODE.THE MATERIAL SHOULD BE FREE FROM CORROSION. (APPLY RUST PREVENT OIL)	100%

3. 100 % LOT SHALL BE INSPECTED BY NAI REP. / INSPECTORS AT FIRM'S PREMISES.
- 4.. MATERIAL TO BE DESPATCHED TO HAPP ONLY AFTER GETTING CLEARANCE FROM NAI.
5. THE FIRM HAS TO DESPATCH THE MATERIAL/COMPONENT ALONG WITH NAI I-NOTE ONLY.

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C. INSPECTION CHECK TO BE CARRIED OUT AT HAPP AFTER RECEIPT BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	WORKMANSHIP (VISUAL)	THE MATERIAL SHALL BE FREE FROM SHARP EDGES, CRACK, BEND, MISMATCH, SURFACE IMPERFECTION AND OTHER INJURIOUS DEFECTS	100 %
2	DIMENSIONS	AS PER DRAWING.	
3	PACKING	SUITABLY PACKED TO AVOID TRANSIT DAMAGES AND SECURELY TIED WITH METAL / PLASTIC TAG. PACKING SLIP SHOULD SPECIFY HAPP SUPPLY ORDER NO. QUANTITY IN NOS. AND PRODUCER'S NAME OR CODE. THE MATERIAL SHOULD BE FREE FROM CORROSION. (APPLY RUST PREVENT OIL)	100 %

D. VERIFICATION OF INSPECTION DOCUMENTS.

FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED WITH EACH SUPPLY.

SL. NO.	INSPECTION DOCUMENTS
1.	THE RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE, DETAILS OF HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS ETC.
2.	THE CHEMICAL AND MECHANICAL TEST CERTIFICATES FROM NABL ACCREDITED OR GOVT. APPROVED LAB.
3.	DIMENSION REPORT INCLUDING VISUAL.
4.	PACKING SLIP DETAILS.
5.	GUARANTEE / WARRANTY CERTIFICATE OF SUPPLIER.
6.	NAI - I-NOTE.

6. MATERIAL/COMPONENT WILL BE CLEARED/ACCEPTED BASED ON NAI I-NOTE/CLEARANCE CERTIFICATE ONLY.
7. MATERIAL HAS TO BE REPLACED 100% BY THE FIRM IN CASE OF ANY DAMAGES DURING INSPECTION AT HAPP, TRICHY.

Mithlesh Chandra
MITHLESH CHANDRA
 AWM / ASSY
 MEMBER / MI COMMITTEE

D. Bhaskar Rao
D. BHASKAR RAO
 WM / E
 MEMBER / MI COMMITTEE

T. Prabhu
T. PRABHU
 JT. GM / QA
 CHAIRMAN / MI COMMITTEE