

<b>MONITORING INSTRUCTION FOR INSPECTION</b>		Issue No. 01 Rev. No. 00
		Date of Issue 18.01.18
<b>TRACER NUT (ASSY)</b>		<b>HAPP/QA/SC/H/07</b>

DRAWING NO. : 1006 13 21 00 02 000 00TA

END USE : 120mm FSAPDS MK-II

REFERENCE DOCUMENT : QAP No - DRDO-ARDE-DOA-TOT-239-2017 ISS:1 DT:22.09.17.

**INSPECTION REPRESENTATIVES AND LOCATION:**

- INSPECTION WILL BE DONE BY REPRESENTATIVE OF HAPP (OR) ARDE (OR) BOTH.
- TESTS WILL BE CARRIED OUT AT FIRM'S PREMISES (OR) AT CQA (ME).

FOR SUB COMPONENTS DRAWING NO. AND RAW MATERIAL SPECIFICATION ARE SHOWN BELOW.

SL NO	COMPONENT	DRWG NO	QTY
1	TRACER PLUG	1006 13 21 00 02 001 00TA (REF: C OTP 125 4 801 2)	1
2	BRASS WASHER	1006 13 21 00 02 002 00TA (REF: C WAS 125 4 800 3)	1

**A. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES FOR RAW MATERIAL FOR PART-1 & PART-2**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE						
1.	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE CLEAN, SMOOTH AND FREE FROM SHARP EDGES, POROSITY, CRACKS OR OTHER DEFECTS.	100%						
2.	CHEMICAL COMPOSITION (%)	<b>AS PER QAP DOC NO :DRDO-ARDE-DOA-TOT-239-2017 ISS:1 DT:22.09.17,</b> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>COMPONENT</th> <th>RESPECTIVE CLAUSE IN QAP</th> </tr> </thead> <tbody> <tr> <td>TRACER PLUG</td> <td>3</td> </tr> <tr> <td>BRASS WASHER</td> <td>3</td> </tr> </tbody> </table>	COMPONENT	RESPECTIVE CLAUSE IN QAP	TRACER PLUG	3	BRASS WASHER	3	AS PER QAP
COMPONENT	RESPECTIVE CLAUSE IN QAP								
TRACER PLUG	3								
BRASS WASHER	3								
3.	MECHANICAL PROPERTIES								

**ISSUED BY**  
**STANDARD CELL**  
 MPSNO: 170157, DT: 05/01/18  
 DATE: 30/1 SIGNATURE: *[Signature]*

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**B. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES (COMPONENT STAGE)  
FOR PART-1 & PART - 2**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE						
1.	WORKMANSHIP VISUAL)	THE COMPONENT SHALL BE FREE FROM DAMAGES, CRACKS OR OTHER DEFECTS.	100%						
2.	DIMENSIONS	<b>AS PER QAP DOC NO :DRDO-ARDE-DOA-TOT-239-2017 ISS:1 DT:22.09.17,</b> <table border="1" style="width: 100%; margin-top: 5px;"> <thead> <tr> <th>COMPONENT</th> <th>RESPECTIVE CLAUSE IN QAP</th> </tr> </thead> <tbody> <tr> <td>TRACER PLUG</td> <td>6.2</td> </tr> <tr> <td>BRASS WASHER</td> <td>6.2</td> </tr> </tbody> </table>	COMPONENT	RESPECTIVE CLAUSE IN QAP	TRACER PLUG	6.2	BRASS WASHER	6.2	AS PER QAP
COMPONENT	RESPECTIVE CLAUSE IN QAP								
TRACER PLUG	6.2								
BRASS WASHER	6.2								
3	FITMENT TRIALS	TO BE SUBJECTED TO FITMENT WITH MATTING PART / GAUGE.	100 %						
4	FINSHED COATING	<b>AS PER QAP DOC NO :DRDO-ARDE-DOA-TOT-239-2017 ISS:1 DT:22.09.17,</b> <table border="1" style="width: 100%; margin-top: 5px;"> <thead> <tr> <th>COMPONENT</th> <th>RESPECTIVE CLAUSE IN QAP</th> </tr> </thead> <tbody> <tr> <td>TRACER PLUG</td> <td>6.3</td> </tr> <tr> <td>BRASS WASHER</td> <td>6.3</td> </tr> </tbody> </table>	COMPONENT	RESPECTIVE CLAUSE IN QAP	TRACER PLUG	6.3	BRASS WASHER	6.3	AS PER QAP
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TRACER PLUG	6.3								
BRASS WASHER	6.3								
5	PRESSURE TEST	<b>AS PER QAP DOC NO :DRDO-ARDE-DOA-TOT-239-2017 ISS:1 DT:22.09.17,</b> <table border="1" style="width: 100%; margin-top: 5px;"> <thead> <tr> <th>COMPONENT/ASSY</th> <th>RESPECTIVE CLAUSE IN QAP</th> </tr> </thead> <tbody> <tr> <td>TRACER NUT</td> <td>6.3</td> </tr> </tbody> </table>	COMPONENT/ASSY	RESPECTIVE CLAUSE IN QAP	TRACER NUT	6.3	AS PER QAP		
COMPONENT/ASSY	RESPECTIVE CLAUSE IN QAP								
TRACER NUT	6.3								
6	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%						

**C. 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.

*Mithlesh*  
**MITHLESH CHANDRA**  
AWM / ASSY  
MEMBER / MI COMMITTEE

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

**ISSUED BY  
STANDARD CELL**  
MPS NO: 170157, Dt: 05/01/18  
DATE: 20/1 SIGNATURE:

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