

(4)

<b>MONITORING INSTRUCTION FOR RAW MATERIAL INSPECTION</b>		Issue No. 01 Rev. No. 04
		Date of Issue 21/02/2015
VARNISH APC 221 GRADE 1 SPECIAL	HAPP/QA/SC/E/008	

DRAWING / SPECIFICATION : STOVING SCHEDULE : COLOUR OF VARNISH FILM : AFTER STOVING : END USE :	JSS 8010-28 1997. REVISION NO. 1 170° C ± 5 DEG C FOR 90 ± 5 MINUTES BROWN  FOR 81 MM BB & NOSE ADAPTOR – 125 MM HE
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**A. INSPECTION CHECK TO BE CARRIED OUT BY FIRM.**

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	TEST METHOD
1.	GENERAL MATERIAL/FINISH	AS PER PARA 3 OF JSS 8010-28 : 1997 REVN. NO.1	NA
2	VISUAL	THE MATERIAL SHOULD BE FREE FROM DAMAGES	VISUAL
3 ***	CONSISTENCY	SMOOTH & UNIFORM APPLICABLE BY SPRAYING	AS PER IS 101 PARA 7.4
4 ***	FINISH OF STOVED FILM	SMOOTH, HARD, FIRMLY ADHERENT WITHOUT SAGGING OR WRINKLING	
5 ***	FLEXIBILITY	NO VISIBLE DAMAGE OR DETACHMENT OF FILM	AS PER IS 197 METHOD NO.11
6 ***	STRIPPING TEST	TO PASS THE TEST	AS PER IS 197 METHOD NO.12
7	FLASH POINT	30°C MIN	AS PER IS 197 METHOD NO.13
8	VOLATILE MATTER (AT 110 °C FOR 3 HOURS)	50 % MAX. BY MASS	AS PER IS 197 METHOD NO.15
9	ASH ON INCINERATION	0.50 % MAX. BY MASS	AS PER IS 197 METHOD NO.16
10 ***	PROTECTION AGAINST CORROSION	TO PASS THE TEST AFTER 500 HOURS OF EXPOSURE	AS PER IS 101 METHOD NO.18
11 ***	RESISTANCE TO WATER AT 60 °C	TO PASS THE TEST	AS PER IS 101 METHOD NO.23

<b>ISSUED BY STANDARD CELL</b>	
For 405)mm	
DATE:	SIGNATURE:

VETTED  
*only 28/2/15*  
D.O. / STANDARD CELL

*25/2*

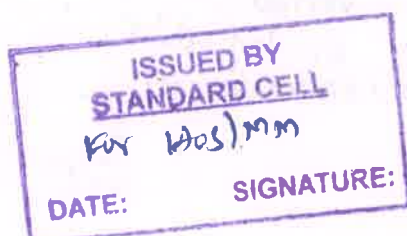
12	WATER SOLUBLE CHLORIDES	0.01 % MAX. BY MASS ( CALCULATED AS SODIUM CHLORIDE ON TOTAL SOLIDS)	AS PER APPENDIX 'A' TO JSS SPECN.
13	COMPATIBILITY WITH EXPLOSIVES	TO PASS THE TEST AS PER APPENDIX 'B' OF THE SPECN	TO BE CARRIED OUT BY FIRM AT CQA(ME) OR ANY REPUTED LAB.
14	VISCOSITY	TO SUIT TO THE SPRAYING APPLICATION	FORD CUP No. 4 AT 27°C
15	KEEPING QUALITIES	MUST RETAIN ORIGINAL PROPERTIES FOR A PERIOD OF NOT LESS THAN 12 MONTHS FROM THE DATE OF RECEIPT AT HAPP.	WARRANTY CERTIFICATE TO BE FURNISHED.
16	MARKING	AS PER PARA 11.1, 11.2 & 11.3 OF JSS 8010-28 : 1997 REVN. NO.1 ( INCLUDING BATCH NO.)	

\*\*\* - TESTING TO BE CARRIED OUT OR COMMENCED ON STOVED FILM PREPARED AS PER STOVING SHEDULE AND AFTER KEEPING FOR 24 HRS. AT ROOM TEMPERATURE.

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

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLING
1	VISUAL	PACKING SHOULD BE FREE FROM DAMAGES.	FOR EACH CONSIGNMENT
2	PROPER IDENTIFICATION	FOR MANUFACTURING MONTH, YEAR, <b>BATCH</b> NO., QTY. SOURCE CODE AND SHELF LIFE.	FOR EACH CONSIGNMENT
3.	INSPECTION DOCUMENTS	AS PER TABLE "A" ABOVE.	FOR EACH CONSIGNMENT
4	APPLICATION TRIAL	THE VARNISH SAMPLES FROM THE BULK SUPPLY SHALL BE TESTED AT HAPP FOR THE SALT SPRAY TEST AS PER SPECIFICATION JSS- 01 :1994 CLAUSE 17.5.2 FOR 72 HOURS TO PROVE RESISTANCE AGAINST CORROSION .ACCEPTANCE OF THE VARNISH OF THE MATERIAL WILL BE GIVEN ONLY AFTER SUCCESSFUL COMPLETION OF THE APPLICATION TRIAL.	
5	VERIFICATION OF THE DOCUMENTS.	<ol style="list-style-type: none"> <li>1. TEST CERTIFICATE OF EACH BATCH AS PER SL. NO. 1 TO 15 OF TABLE A ( AS APPLICABLE) DULY TESTED AND CERTIFIED BY NABL ACCREDITED LAB OR GOVT. APPROVED LAB OR ANY REPUTED LABS.</li> <li>2. SHELF LIFE CERTIFICATE INDICATING DATE OF MANUFACTURE AND DATE OF EXPIRY FOR EACH BATCH / LOT.</li> </ol>	

\* - NOTE: HAPP SUPPLY ORDER NO. & QTY. MUST BE MENTIONED CLEARLY IN ALL ABOVE INSPECTION DOCUMENTS.



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