

<b>MONITORING INSTRUCTION FOR INSPECTION</b>		Issue No. 01 Rev. No. 05
		Date of Issue 26/08/2017
<b>LINER</b>		<b>HAPP/QA/SC/ZI/001</b>

**DRAWING NO.** : NASK 1062/3  
**RAW MATERIAL** : SINGLE PIECE METHOD: (DEEP DRAWING)  
**STEEL AS PER IS : 513 – 2008 EDD GR.CR4**  
**END USE** : **HEAD ROCKET ASSEMBLY 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 CLEAN AND FREE FROM SHARP EDGES, INTERNAL FLAWS LIKE PIN HOLES, POROSITY, CRACKS & DISTORTION OR OTHER HARMFUL DEFECTS.	100%
2	DIMENSIONS	AS PER DRAWING	
3	CHEMICAL COMPOSITION (%)	IS:513 EDD GR.CR4	ONE SAMPLE PER HEAT
		C - 0.08 Max. Mn - 0.40 Max. P - 0.02 Max S - 0.03 Max	
4	MECHANICAL TEST	UTS - 350 Mpa Max. YS - 210 Mpa Max. E - 36 % Min. HARDNESS - 50 HRB Max	

**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. THE FIRM HAS TO CHECK FOR THE DIMENSIONS, VISUAL DEFECTS AND MARKING AS PER TABLE A. AFTER COMPLETION OF DIMENSIONAL, CHEMICAL AND MECHANICAL PROPERTIES, THE FIRM HAS TO SUBMIT/FORWARD THE FOLLOWING DOCUMENTS TO NAI/TRICHY WITH A COPY TO HAPP.
  - I. THE RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE, DETAILS OF HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS ARE TO BE SUBMITTED.
  - II. THE CHEMICAL AND MECHANICAL TEST CERTIFICATES FROM NABL ACCREDITED OR GOVT. APPROVED LAB AS PER TABLE A.
  - III. DIMENSION REPORT INCLUDING VISUAL AS PER TABLE A.
  - IV. GUARANTEE/WARRANTEE CERTIFICATE OF ORIGINAL MANUFACTURER.
3. 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.
4. MANUFACTURING OF COMPONENT SHOULD BE DONE ONLY AFTER GETTING RAW MATERIAL CLEARANCE FROM NAI AND SHOULD BE MANUFACTURED AS PER THE DRAWING NASK 1062/3 NOTE NOS. 4,5,9,10 &11 AND AS PER THE MANUFACTURING QUALITY PLAN OF LINER (EXCEPT LEAK TEST)AND INSPECTION REPORT NOTE NOS.3,4 & 6.
5. IN DRAWING (NASK1062/3) NOTE NO:07 IS NOT APPLICABLE TO MANUFACTURE/SUPPLIER

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

SL. NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	DIMENSIONS	AS PER DRAWING	100 %
2	VISUAL	THE COMPONENT SHALL BE FREE FROM INTERNAL CRACK, FLAWS & DISTORTION ETC.	

7. 100 % LOT SHALL BE INSPECTED BY NAI REP. / INSPECTORS AT FIRM'S PREMISES.

8. THE FIRM HAS TO DESPATCH THE MATERIAL/COMPONENT ALONG WITH NAI I-NOTE ONLY.

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

SL. NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	VISUAL	THE COMPONENT SHALL BE FREE FROM INTERNAL CRACK, FLAWS & DISTORTION ETC.	100%
2	DIMENSIONS	AS PER DRAWING.	
3	PACKING	PACKING OF THE MATERIAL SHOULD BE DONE IN SUCH A MANNER TO AVOID CORROSION AND DAMAGE IN HANDLING AND TRANSIT.	EACH CONSIGNMENT
4	MARKING	EACH PACKING SHOULD BE LEGIBLY MARKED WITH MANUFACTURER'S IDENTITY, QUANTITY, HEAT NUMBER AND HAPP SUPPLY ORDER NUMBER ETC.	
5	VERIFICATION OF DOCUMENTS	1. NAI - I-NOTE	

**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

9. MATERIAL/COMPONENT WILL BE CLEARED/ACCEPTED BASED ON NAI I-NOTE/CLEARANCE CERTIFICATE ONLY.

10. MATERIAL HAS TO BE REPLACED 100% BY THE FIRM IN CASE OF ANY DAMAGES DURING INSPECTION AT HAPP, TRICHY.

*Kiranp*  
*Alt-wm/p*  
**SOURABH NEGE**  
 WM / P  
 MEMBER / MI COMMITTEE

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

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