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| <b>MONITORING INSTRUCTION FOR INSPECTION</b> | Issue No. 01<br>Rev. No. 02 |
|  | Date of Issue<br>15/02/2017 |
| <b>PLASTIC CONTAINER</b>                     | <b>HAPP/QA/SC/C/012</b>     |

DRAWING NO. : HAPP Drg. H OMA 120 1 054 REV 2

RAW MATERIAL : 1. FOR SL.NO. 1,2,4,5 & 7 - HIGH DENSITY POLYTHENE TO SPEC JSS 9330-03 : 2007 (TYPE 2) IN NATURAL COLOUR ,  
2. FOR SL. No.3 ( GASKET ) – NEOPRENE RUBBER TO SPEC IND/ME/884 ( PROV ).  
3. FOR SL. No.6 (CUSHION PAD TOP ) –SPONGE RUBBER TO SPEC IND/ME/645 ( PROV ).

END USE : 120 MM FSAPDS

**A. INSPECTION CHECK TO BE CARRIED OUT FOR RAW MATERIAL BY THE FIRM.**

| SL. NO.                               | CHARACTERISTICS      | SPECIFICATION / REQUIREMENT  |                              |                 | SAMPLE SIZE               |
|---------------------------------------|----------------------|--|------------------------------|-----------------|---------------------------|
| 1                                     | WORKMANSHIP (VISUAL) | THE PARTS SHALL BE FREE FROM DAMAGES, BUBBLES, SURFACE IMPERFECTIONS, POROSITY, VOIDS DUE TO DUST INCLUSIONS & OTHER OBVIOUS DEFECTS LIKELY TO IMPAIR THEIR USEFULNESS OR LIFE |                              |                 | 100 %                     |
| 2                                     | DIMENSIONS           | AS PER DRAWING   |                              |                 | 100 %                     |
| 3                                     | DROP TEST            | AS PER SPECIFICATION JSG 0102  |                              |                 | AS PER JSG 0102           |
| 4                                     | PROPERTIES           | Test parameters  | Test Method                  | Specified value | TWO SAMPLES FOR EACH HEAT |
|                                       |                      | Melt flow index (190°C /2.16 Kg )  | ASTM D 1238                  | 8± 20%          |                           |
|                                       |                      | Density g/cc   | ASTM D -1505                 | 0.955 to 0.959  |                           |
|                                       |                      | Yield stress ( MPa)  | ASTM D -638                  | 23Mpa(Min)      |                           |
|                                       |                      | Elongation at yield %  |                              | 10% ( Min)      |                           |
|                                       |                      | Ash %  | IS 1060( Part - 1)           | 0.05%(Max)      |                           |
|                                       |                      | pH of water Extract  | IS 1060( Part - 1) Method 10 | 5 to 8          |                           |
|                                       |                      | Water soluble matter %   | Appendix- A                  | 0.2 ( Max)      |                           |
|                                       |                      | Water soluble chlorides as NaCl %  | IS 1060( Part - 2) Method 17 | 0.05 ( Max )    |                           |
|                                       |                      | Water soluble Sulphate as Na <sub>2</sub> SO <sub>4</sub> %  | IS 1060( Part - 2) Method 18 | 0.1 ( Max)      |                           |
|                                       |                      | Solubility in Toluene at 80°C ±3°C   | Appendix- B                  | Insoluble       |                           |
|                                       |                      | Impact strength notched mj/ mm <sup>2</sup>  | ASTM D – 256                 | 2.7 ( Min )     |                           |
|                                       |                      | Solubility in Ethy 1 Acetate acetone at 25 ± 1°C   | Appendix- D                  | Insoluble       |                           |
| Effect of organic solvent below 80° C | Appendix- E          | Should be resistant  |                              |                 |                           |
| 5                                     | PACKING              | PACKING SLIP INDICATING SOURCE CODE, MATERIAL GRADE , LOT NO. AND QTY.   |                              |                 | FOR EACH CONSIGNMENT      |

**NOTE: 1**

FIRM SHOULD OFFER THE FOLLOWING DOCUMENTS ALONG WITH ADVANCE SAMPLE..

1. THE RAW MATERIAL PROPERTIES CHEMICAL, MECHANICAL AND OTHER TEST CERTIFICATES DULY TESTED FROM NABL ACCREDITED OR GOVT. APPROVED LAB AND RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE. (HEAT NO. & PURCHASED QTY )

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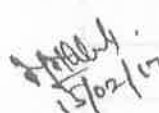
2. DIMENSIONAL INSPECTION REPORT FROM SUPPLIER.
3. THE FIRM SHOULD SUPPLY 5 NOS AS ADVANCE SAMPLE FOR INSPECTION OF VARIOUS PARAMETERS. BULK PRODUCTION / SUPPLY SHOULD BE EFFECTED ON RECEIVING CLEARANCE FROM HAPP.


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


| SL. NO. | CHARACTERISTICS      | SPECIFICATION / REQUIREMENT  | SAMPLE SIZE |
|---------|----------------------|--|-------------|
| 1       | WORKMANSHIP (VISUAL) | THE PARTS SHALL BE FREE FROM DAMAGES, BUBBLES, SURFACE IMPERFECTIONS, POROSITY, VOIDS DUE TO DUST INCLUSIONS & OTHER OBVIOUS DEFECTS LIKELY TO IMPAIR THEIR USEFULNESS OR LIFE | DEF 131     |
| 2       | DIMENSIONS           | AS PER DRAWING   | DEF 131     |
| 3       | DROP TEST            | AS PER SPECIFICATION JSG 0102  | DEF 131     |
| 4       | PACKING              | PACKING SLIP INDICATING SOURCE CODE, MATERIAL GRADE . LOT NO. AND QTY.   | DEF 131     |

**C. FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED ALONG WITH EACH SUPPLY OF RAW MATERIAL.**

| SL. NO. | INSPECTION DOCUMENTS  |
|---------|---|
| 1       | DIMENSIONAL INSPECTION REPORT FROM SUPPLIER.  |
| 2       | TEST REPORTS FROM NABL ACCREDITED LAB OR GOVT. APPROVED LABORATORY FOR TESTS MENTIONED TABLE NO. A. |
| 3       | PACKING SLIP DETAILS ( INDICATING HEAT NO. & QTY. ETC)  |
| 4       | GAURANTEE / WARRANTY CERTIFICATE  |

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

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

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