

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
		Rev No :
		Date of Issue 18/08/2021
44P 30041*2 (TRANSIT CASE)		OFT/MI/AMR/30041
Rev.No	Amendment	Date

MATERIAL

Sl.No	Description	Qty	Material Specification
1	Moulded Box Base	1	LLDPE – LL 36RA045 UV
2	Moulded Box Lid	1	LLDPE – LL 36RA045 UV
3	Latch	5	SS 202-ASTM E 1086 (94)
4	Pad Lock	2	SS 202-ASTM E 1086 (94)
5	Hinge	5	SS 202-ASTM E 1086 (94)
6	Handle	4	SS 202-ASTM E 1086 (94)
7	Gasket	1	Natural Rubber
8	Chain with Cover/Wire Rope	2	SS 202-ASTM E 1086 (94)
9	Soft Rest	1	Poly Urethane Foam.
10	Foam	9	XLPE-ASTM C 177, D 2240, JIS K 6767

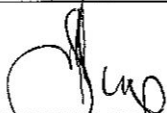
CONDITION OF SUPPLY : FULLY FINISHED WITH FIRM'S MATERIAL.
 END USE : 14.5/20 mm AMR.

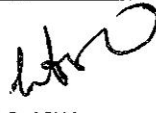
INSPECTION CHECK TO BE CARRIED OUT


Table 'A'

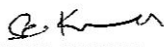
SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	i) The component shall be free from defects such as scale, burrs and any other harmful defects. For Plastic: The material shall consist of granules of uniform appearance and of substantially uniform size and shape suitable for processing by injection moulding or extrusion. It shall be substantially free from foreign matter. ii) All components should be assembled in right manner as per drawing.	100%
2.	Dimension	100% Dimension to check as per drawing. Drawing and the dimensions given for cushion and LLDPE are for Guidance only. Manufacturer should refer the sample box available at OFT before quoting tender.	
3.	Colour	Olive Green.	
4.	Chemical Composition	As per material specification given above including Trace Elements.	
5.	Mechanical Properties	1. Tensile Strength 2. Elongation 3. Impact Strength (As per Specification Standards)	One sample Per Heat

6.	Tests	For Plastics: 1. Melting Point 2. Viscosity Number 3. Water Content 4. Density at 23°C 5. Tensile Stress at Yield 6. Elongation at break 7. Carbon black content 8. Resistance to heat aging 9. Ash Content.		
		Other Tests:		
		SI No.	TEST NAME	TEST SPECIFICATION
		1.	Packing Test	All the stores shall be kept in the box. Box shall be closed and open. No fouling is permitted.
		2.	Water Spray Test (K-JSS 0253-01)	Water sprayed at a Pressure of 2.5 +/- 0.35 Kg/cm ² for all the four top corner at an angle of 45° from a distance of 2.5m, Test Duration- 15 Minutes.
		3.	Vibration Test (MIL-STD-810F)	Random Vibration : Vertical axis 10Hz-500Hz, 0.0762g/Hz. Test Duration – 15 Minutes.
		4.	Dry Heat Test (JSS 0253-01)	The Transit Case is Exposed to a temperature of 75°C ± 2°C with relative humidity of 40% for 48 Hours.
		5.	Bump Test (JSS 0253-01)	Bump Frequency – 5 Cycl/sec Displacement – 12.5mm Number of Bumps – 15,000 Bumps.
6.	Drop Test JSS-0253-01 (or) (MIL-STD-810F)	The Packing box containing the stores shall be drop tested from 1.4m height on 8 sides and 4 diagonal corners.		
7.	Damp Heat Test (JSS 0253-01)	Raise to 35°C during 31/2 Hrs & RH 95% min. Hold 35°C, RH 95% for 12 Hrs, cool to -20°C at RH 95% in 3 Hrs. Maintain -20°C, RH 95% for 5 Hrs for one cycle, Rate temperature changes > 15°C /Hr, Total 2 cycle five min. from the handle.		
7.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	Each Consignment	
8.	Marking	Markings on Transit Case are to be done by screen printing with white colour. Each Packing shall be legibly marked with manufacturer's identity , Qty, OFT Supply order No etc.,		


 U. MANGALASHAMY
 HOS/STD.CELL
 CHECKED


 L.S. ASHA
 HOS / QCM
 CHECKED


 V. RAVEENDAR
 JWM/STD.CELL
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 S. KRISHNA SWAMY
 JT.GM (QC and R&D)


 A.K SINGH
 AGM / (WP & MAINT)
 APPROVED



 G. DEVENDRANE
 AWM (QCM & HT)

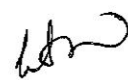
Note:

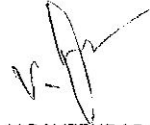
1. The Raw material/component/forging/casting to be tested by the firm on selection of the sample by the firm itself for chemical composition and mechanical properties in NABL accredited approved Lab as per Table 'A'.
2. The Firm has to check for the dimensions, visual defects, packing and marking as per Table 'A'. After completion of tests as per Note-1 as above, the Firm has to submit the following documents to OFT.
 - I. The Raw material certificate from the original manufacturer, Heat number, and quantity purchased and number of bars is to be mentioned in the inspection letter to OFT.
 - II. The Chemical and Mechanical test certificates from NABL accredited approved lab as per Table 'A'.
 - III. **Raw material sample minimum of 300mm should be supplied for cross verification along with the first supply of stores.**
 - IV. Dimensional reports including visual as per Table 'A'.
 - V. Guarantee / Warrantee certificate of supplier against the supply.
3. All the above Documents mentioned at Note No.2 above are to be forwarded to GM/OFT along with supply.
4. OFT shall verify all the documents as above and accord clearance to the firm for dispatch of the material to OFT if all documents are in order.
5. OFT/Trichy shall verify all the parameters as per Table 'A' and after satisfactory results, the material will be accepted /cleared accordingly.
6. Material has to be replaced 100% by the firm in case of non-conformity to specification as per Table-A, during inspection at OFT, Trichy.

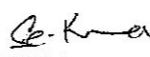
VERIFICATION OF INSPECTION DOCUMENTS

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 approved Lab.
3	Dimension report including visual.
4	Packing slip details.


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