

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 05
		Date of Issue 12.02.2020
ASSEMBLY CENTRE CONTACT		HAPP/QA/SC/ZI/015
Rev no	Amondment	Date
5	Material amended as per standard BS 970 3:1991 which was BS 970-1:1983	12.02.2020

DRAWING NO. : NASK 1068/8

END USE : ASSEMBLY ADAPTER FOR RGB 60.

FOR SUB COMPONENTS RAW MATERIAL SPECIFICATION ARE SHOWN BELOW.

PART-1 BODY - STEEL TO SPEC BS 970(PT-3)-91GR.080M40.

PART-2 CONTACT - BRASS TO SPEC IS 4170 GR. Cu Zn 40.

PART-3 CONNECTOR - BRASS TO SPEC BS 2870 GR. CZ 108 'O' CONDITION.

TABLE A. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES FOR RAW MATERIAL FOR PART-1, PART-2 & PART-3 BY NAI.

SL. NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE CLEAN, SMOOTH AND FREE FROM FROM SHARP EDGES, POROSITY, CRACKS OR OTHER DEFECTS.	100%
2.	DIMENSIONS	PART-1 - AS PER DRAWING NO. NASK 1068/8/1 ✓ PART-2 - AS PER DRAWING NO. NASK 1068/8/2 ✓ PART-3 - AS PER DRAWING NO. NASK 1068/8/3 ✓	
3.	CHEMICAL COMPOSITION (%)	PART-1 - AS PER BS 970(PT-3)-91GR.080M40. PART-2 - AS PER IS 4170 GR. Cu Zn 40. PART-3 - AS PER BS 2870 GR. CZ 108 'O' CONDITION	ONE SAMPLE PER HEAT
4.	MECHANICAL PROPERTIES	PART-1 - AS PER BS 970(PT-3)-91GR.080M40. PART-2 - AS PER IS 4170 GR. Cu Zn 40. PART-3 - AS PER BS 2870 GR. CZ 108 'O' CONDITION	
5.	SURFACE FINISH.	PART-1 - AS PER DRAWING NO. NASK 1068/8/1 PART-2 - AS PER DRAWING NO. NASK 1068/8/2 PART-3 - AS PER DRAWING NO. NASK 1068/8/3	100 %

NOTE :

- 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 LABORATORY FOR TESTING.
- THE FIRM HAS TO CHECK FOR THE DIMENTIONS, VISUAL DEFECTS AND MARKING AS PER TABLE A. AFTER COMPLETION OF DIMENTIONAL, CHEMICAL AND MECHANICAL PROPERTIES, THE FIRM HAS TO SUBMIT/FORWARD THE FOLLOWING DOCUMENTS TO NAI/TRICHY WITH A COPY TO HAPP.
 - THE RAW MATERIAL ORIGINAL MANUFACTURER'S CERTIFICATE, DETAILS OF HEAT NUMBER, QUANTITY PURCHASED AND NUMBER OF BARS ARE TO BE SUBMITTED.
 - THE CHEMICAL AND MECHANICAL TEST CERTIFICATES FROM NABL ACCREDITED LAB AS PER TABLE A.
 - DIMENSION REPORT INCLUDING VISUAL AS PER TABLE A.
 - GUARANTEE/WARRANTEE CERTIFICATE OF ORIGINAL MANUFACTURER.
- MANUFACTURING OF COMPONENT SHOULD BE DONE ONLY AFTER GETTING RAW MATERIAL CLEARANCE FROM NAI.

TABLE B. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES (COMPONENT STAGE) FOR PART-1, PART-2 & PART-3 BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE COMPONENT SHALL BE FREE FROM DAMAGES, CRACKS OR OTHER DEFECTS..	100%
2.	DIMENSIONS	PART-1 - AS PER DRAWING NO. NASK 1068/8/1 PART-2 - AS PER DRAWING NO. NASK 1068/8/2 PART-3 - AS PER DRAWING NO. NASK 1068/8/3	

NPS 20190247 dt 24/12/19
7/2/20

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4. AFTER GETTING CLEARANCE FROM NAI, THE COMPONENT SHALL BE ASSEMBLED WITH PART NO. 1,2 & 3 ALONG WITH PHENOLIC MOULDING FIBRE GLASS GRADE SP 16 (PS CODE 514) AS SHOWN IN DRAWING.

TABLE C. INSPECTION CHECK TO BE CARRIED OUT AT FIRM'S PREMISES (ASSEMBLY STAGE) BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE ASSY. SHALL BE FREE FROM DAMAGES, CRACKS OR OTHER DEFECTS..	100%
2.	DIMENSIONS	AS PER DRAWING NO.NASK 168/8	

5. 100 % LOT SHALL BE INSPECTED BY NAI REP. / INSPECTORS AT FIRM'S PREMISES.
6. THE FIRM HAS TO DESPATCH THE MATERIAL/COMPONENT ALONG WITH NAI I-NOTE ONLY.
7. MANUFACTURER'S TEST CERTIFICATES FOR RAW MATERIALS USED FOR PROTECTIVE SURFACE FINISH COATING AND COATING THICKNESS REPORT FOR 30 SAMPLES ARE TO BE SUBMITTED ALONG WITH EACH SUPPLY.

TABLE D. INSPECTION CHECK TO BE CARRIED OUT AT HAPP AFTER RECEIPT BY NAI.

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	WORKMANSHIP (VISUAL)	THE ASSY. SHALL BE FREE FROM DAMAGES, CRACKS OR OTHER DEFECTS..	100%
2.	DIMENSIONS	AS PER DRAWING NO.NASK 168/8	

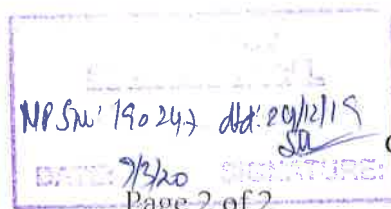
TABLE C. VERIFICATION OF INSPECTION DOCUMENTS

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	TEST CERTIFICATE FOR CHEMICAL, MECHANICAL etc., AS APPLICABLE UNDER TABLE "A" FROM NABL ACCREDITED LAB.
3	VISUAL & DIMENSIONAL REPORTS AS PER TABLE A SUBMITTED IN SEPARATE (OR) CERTIFY ALONG WITH TEST CERTIFICATE
4	PACKING SLIP DETAILS
5	IN ADDITION TO THE ABOVE SOFT COPIES OF ALL THE CERTIFICATES MENTIONED IN TABLE - C SHALL BE SENT TO E-MAIL ID'S. happqa.ofb@ofb.gov.in , mmhapp.ofb@ofb.gov.in
Note	1.IN CASE OF ANY DIFFERENCES, QAP & DRAWING SHALL PREVAIL 2.EXPLICIT DEVIATION(S) IF ANY SUCH AS TYPOGRAPHICAL ERROR, VALUES, NUMERIC, OTHER PARAMETER, ETC IS/ARE FOUND IN MONITORING INSTRUCTION OF THE ABOVE STORES, THE RELEVANT STANDARD CONFORMING TO THE CONCERNED SPECIFICATIONS SHALL BE REFERRED TO CONFIRM THE PARAMETER

8. MATERIAL/COMPONENT WILL BE CLEARED/ACCEPTED BASED ON NAI I-NOTE/CLEARANCE CERTIFICATE ONLY.
9. MATERIAL HAS TO BE REPLACED 100% BY THE FIRM IN CASE OF ANY DAMAGES DURING INSPECTION AT HAPP, TRICHY.

D.BHASKAR RAO
WM / PM (USER SECTION)
MEMBER / MI COMMITTEE



M.RAMESHPARAN
AWM / R&D
CHAIRMAN / MI COMMITTEE