4. PREPARATION OF TEST SAMPLES BY MOULDING (AS PER IS 3400 PART I). TEST
4. PREPARATION OF THE MET SAMPLES AS METIONED BLOW SHALL BE PREPARED FROM EACH BATCH OF RAW
MATERIAL FOR CARRYING OUT VARIOUS TESTS, SPECIFIED. 3. TESTING OF RAW MATERIAL FOR EACH BATCH IS MANDATORY A TESTING OF EACH BATCH OF RAW MATERIAL-FOR EACH BATCH OF THE RAW MATERIAL-FOR EACH BATCH OF A SPER NOTE AT SI, NO. A SMALL BE TESTED FOR COMPLIANCE OF ALL REQUIREMENTS AS MENTIONED IN NOTE GAY 2. PAW MATERIAL FORMULATION DETAILS FOR 1 KG BASE MATERIAL (THESE ARE GENERAL GUIDELINES FOR 10115 KG BATCH) 5. TESTING, AS MENTIONED BELOW, SHALL BE CARRIED OUT. NOTES: 1. METHOD OF MANUFACTURE: MOULDING NOTE: RECORD OF EACH BATCH OF FORMULATION ALONG WITH BATCH NO CODE NO. SHALL BE MANKAINED AND SUBMITED BY THE VENDOR TO THE INSPECTION AUTHORITY. BATCH PREFMANDAL MIX THE BASE MATERIAL SUCON RUBBER BY PASSING THROUGH TWO ROLLERS ROTAMAG, HO OPPOSITE DIRECTIONS AND VARYING THE DISTANCE BETWEEN THESE ROLLERS, AND THE CURING AGENT DIRED RICH BY ORD MIX OSLUCON RUBBER, AND COLOUR POWDER TOGETHER, MIX THE WHOLE MATERIAL TO FORM THE HOMOGENOUS BATCH, WRAP THE RUBBER SUAB INTO THE POWNETHYLENE SHEET. THE SAMPLES SHALL BE CUREO/PREPARED AS UNDER: CURING(VULCANIZING) PARAMETERS FOR MOULDING
OF THE TEST SAMPLES: BASE MATÉRIAL: FLUORINATED SILICONE RUBBER (FVMQ 60): 1 KG THE FLASH (EXTRAPROTRUDED) MATERIAL SHOULD NOT BE MORE THAN 0,003 NICH THICKNESS COLOUR: BLUE, QTY: 0.5GM FLASH SHALL BE REMOVED BY BUFFING ON MANDREL AND SUBJECTING THE MOULDED MATERIAL AT VERY LOW TEMPERATURE SLAB: 150MMX150MMX2MM THICK CURING AGENT: DHDP (IQUID, QTY: 116M BUTTONS: ØZ9MMX12,5 MM POST-CURING OF TEST SAMPLES: ANOS. TEMPERATURE: 150" C± 5"C DURATION; 15 MINUTES FEEDING WEIGHT: 1411GM FEEDING WEIGHT: 72 GM • • • • O'RING HOT CHAMBER TEST AT 200°C FOR 70 HRS 8(A) ALL THE TESTS AS BELOW TO BE CONDUCTED AS PER ASTM 02000-05 (8) TEST FOR SPECIFIC GRAVITY SHALL BE CARRED OUT AS MENTINED BELOW: BEGING CHARMIT/TODENSTY. BY MEASURING THE WIGHOT OF SAMPLES IN AND IN WAITER OBTAIN THE DENSITY SPECIFIC GRAVITY. SPECIFIC GRAVITY OF SULCON RUBBER (1.1 TO 1.9) (ON SAMPLE OF BUTTON): 8. INSPECTION 7. RAW MATERIAL REPORT AND REALISATION OF 'O' RING:  $\varphi, PROTECTIVE$  FINISH: APPLICATION OF FINE CHALK POYADER BEFORE PACKING AND DESPATCH TO CONSIGNEE REALISATION OF 'O' RINGS: SHALL BE REALISED TO COMPLY WITH THE DRAWING DIMENSIONS COMPRESSION SET AT 175°C FOR 22 HRS.
LOW TEMPERATURE RESISTANCE
[GRITTLENESS] TEST 1-55°C, 3 MINUTES] KARDNESS (SHORE A) (USING DUROMETER) BUTTON
TENSILE STRENGTH, (MPA)
SLUB
SLUDHOATION AT SEELEM (YA)
SLUB
COMPRESSION SET AT 125°C FOR 22 HRS.
BUTTON POLYMER USEO (FVMQ, CLASSIFICATION FK) VISUAL INSPECTION: SURFACE SHALL BE FREE FROM FLASHES/EXTRA MATERIAL, SHARP EDGES CRACKS, CUT MARKS, FLASH AND MISMATCH SHALL NOT BE MORE THAT 0.1 MM SI. NO. DIMENSION FEATURE DIMENSIONAL PASPECTION: THE CITY OF 'O' RING PRODUCED FROM EACH BATCH OF RAW MATERIAL SHALL BE RECORDED TEST REPORT, FOR ALL THE TESTS AT 6(A) AND 6(B), AS ABOVE, SHALL BE SUBMITTED FOR EACH BATCH OF RAW MATERIAL BEFORE REALISATION OF 'O' RINGS SPECIFIC GRAVITY: M1/(M1-MZ)=\_ LOSS OF WEIGHT (M1-MZ):\_\_ TEST SAMPLE WEIGHT IN WATER(MZ): \_\_\_\_ GMS TEST SAMPLE WEIGHT IN AIR (M1): \_\_\_\_ GMS WEIGHT IN AIR PER LOSS IN WEIGHT IN WATER OF SAMPLE IN HARDNESS (SHORE A) BUTTOM
IN TENSILE STRENGTH (MPA) MRK SLAB
IN ELONGATION AT BREAK (%) MIN SLAB NNER DWWETER CROSS SECTION DWWETER 55°C, 3 MINUTES) ₽ E PROCESS FOR VENOURS CERTIFICATE FOR BATCH
PROCESS FOR FORMALTICN TO BE REQUISED TO INSPECTION
BUTTON
10 BUTTON
10 SUP ACCEPTANCE BUTTON 21 9 MIN 150% MIN 50% MAX NO CRACKS INSTRUMENT / EQUIPMENT DIAL THICKNESS GALIGE GAUGE PRI Ø 2.8 MM VDED TO INSPECTION FOR EXPLANATION OF QUENEXONING BTO, SEE ARDE MOTE SEET HE.S THIRD ANGLE PROJECTION DIMENSIONS ARE IN MILLSHETERS RAW MATERIAL: FLUGRINATED SILICONE RUBBER AS PER ASTM D 2000-05, DESIGNATION FK, GRADE 2,/FVAIDE0/CDLQUR; BLUE 19,5,80 7,11,70 14.09.10 7,4,2003 DATE MOM ON METALLIC IGNITER FOR 60 MM ROCKET Dt. 14 Sep 2018 AUTHORITY AL385 ESTIMATED WEIGHT: MATERIAL - AS ABOVE ZONE NEW DRAWING PREPARED FOR CHANGE IN RAW MATERIAL AND ITS TESTING RETRACED RETRACED WITHOUT CHANGE PREVIOUS AMENDMENT NOS. AG & ASG AMENDACKTS MENDED VIDE AL NO. 385 HARDNESS SHORE WAS 60 TO ASSY, DRG, ARDE 1135/20
NSS RS.
DRAWAY
CHEEF DWAM ARDE 1135 (ISSUE 1) ARMAMENT RESEARCH & DEVELOPMENT ESTT. PASHARPURE PPROVED MATURE GROUP OFFICE TRUESO C SRIKANTH, SOF 5<u>G</u>

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