

MONITORING INSTRUCTION FOR INSPECTION		Issue No. 01 Rev. No. 02
		Date of Issue 04.06.22
PLASTIC CONTAINER (125mm FSAPDS AMK-339)		HEPF/QA/SC/AMK/001
Rev no	Amendment	Date
1	Drawing number revision removed	22.04.22
2	Raw material testing at HEPF premises added as per Action point of WPRM Dtd:30.05.2022	04.06.22

DRAWING NO. : HEPF Drg. H AMK 125 1 126 (LASTEST REVISION)
RAW MATERIAL : 1. FOR SL.NO. 1,2,3&5 - HIGH DENSITY POLYETHYLENE
TO SPEC JSS 9330-03 : 2014 (TYPE 2) IN ORANGE COLOUR .
2. FOR SL. No.6 (GASKET) – NEOPRENE RUBBER
TO SPEC IND/ME/884 (PROV).
3. FOR SL. No 4 (CUSHION PADS) - SPONGE RUBBER TO SPEC: IND/ME/645
END USE : 125mm FSAPDS AMK-339

TABLE A. INSPECTION CHECKS TO BE CARRIED OUT ON RAW MATERIAL AT FIRM'S PREMISES

SL. NO.	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1	TESTING	1. JSS 9330-03:2014 CLAUSE 7.4 test requirements for high density polyethylene: (a) Chemical Requirements (b) Physical Requirements 2. Neoprene rubber to spec IND/ME/884 (PROV). 3. Sponge Rubber To Spec: IND/ME/645 (PROV).	Two samples/ Lot or batch

NOTES:

- Firm to select raw material samples / test specimens for each heat lot/batch and forwarded to nearby NABL accredited / Govt. Approved / P.S.U lab for testing and forward test report.
- Based on satisfactory test results, HEPF will accord material clearance to make
 1. 10 pilot samples of plastic container for new source suppliers.
 2. Bulk supply for existing suppliers.

TABLE B. PILOT SAMPLE INSPECTION TO BE CARRIED OUT ON RECEIPT AT HEPF (NEW SOURCE)

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	4 nos
4	PACKING	Packing slip indicating source code, material grade , lot no. and qty.	100%

NOTE:

- Based on satisfactory test results, HEPF will accord material clearance for bulk production of plastic containers

TABLE C. BULK INSPECTION TO BE CARRIED OUT ON RECEIPT AT HEPF.

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	10%
3	DROP TEST	As per specification JSG 0102	Random sample 1%/ Lot or batch
4	PACKING	Packing slip indicating source code, material grade , lot no. and qty.	100%



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TABLE D. FOLLOWING INSPECTION DOCUMENTS MUST BE ENCLOSED ALONG WITH EACH SUPPLY OF FINISHED PRODUCT.

SL. NO.	INSPECTION DOCUMENTS
1	Dimensional inspection report from supplier.
2	Test reports from NABL ACCREDITED / GOVT. APPROVED / P.S.U LAB for tests mentioned Table no. A.
3	Packing slip details
4	Guarantee / warranty certificate
5	In addition to the above soft copies of all the certificates shall be sent to e-mail ID'S.

- (i) Explicit deviation(s) if any such as typographical error, values, numeric, other parameter, etc is/are found monitoring instruction of the above stores, the relevant standards conforming to the concerned specifications shall be referred to confirm the parameter.
- (ii) In case of any damages during inspection at HEPF Trichy, 100% replacement to be done by the firm.
- (iii) Correspondence w.r.t the quality of supplied material and their acceptance or otherwise is to be made at e-mail id happqa@ord.gov.in

C. Shanmuga Sundaram C
SHANMUGA SUNDARAM C
JWM
MEMBER / MI COMMITTEE

Jagvimal Phogaat
12/07/22
JAGVIMAL PHOGAAT
WM / ASSY (USER SECTION)
MEMBER / MI COMMITTEE

Sreenivasa Rao Bodala
11/07/22
SREENIVASA RAO BODALA
DGM / Q (QCO)
CHAIRMAN

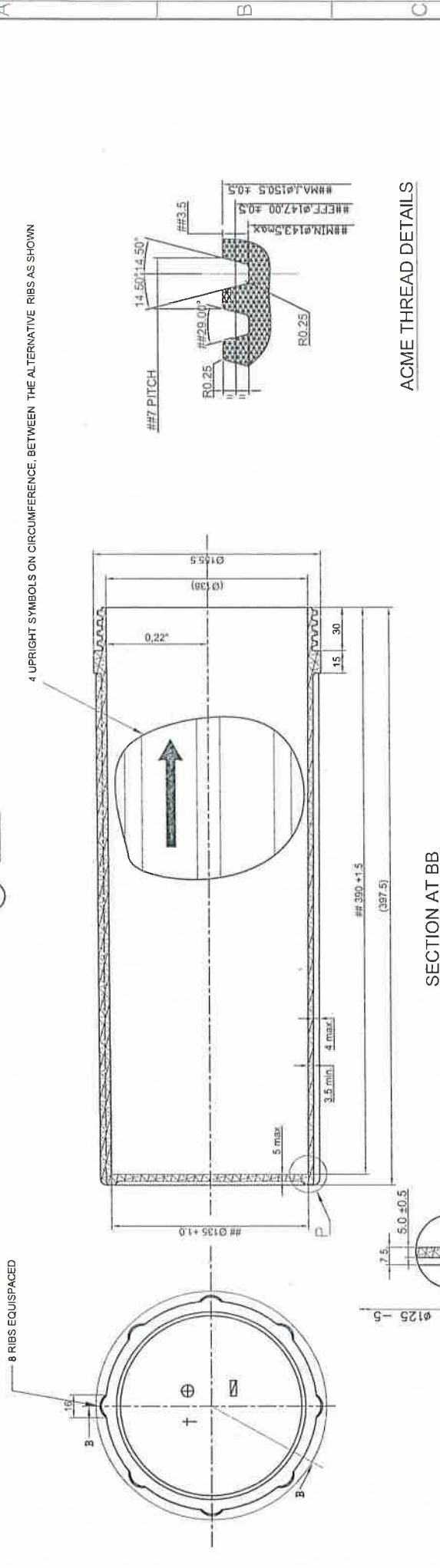
MPS
ISSUED BY
STANDARD CELL
NO: 220 421 Dt: 7/12/22
DATE: 20/1/23
SIGNATURE:

DRG NO: H AMK 125 1 126 3

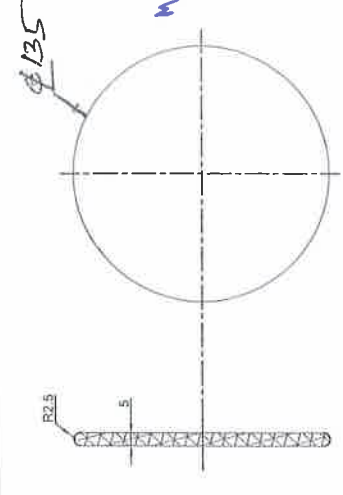
REV: MEDIUM CLASS TO IS-2102 UNLESS OTHERWISE STATED.

DRAWING CONVERSIONS CONFORM TO INDIAN STD. CEN. TOL.

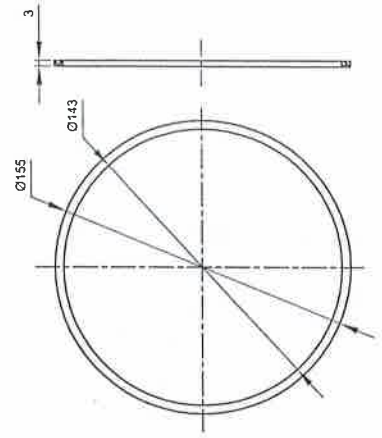
1 BODY



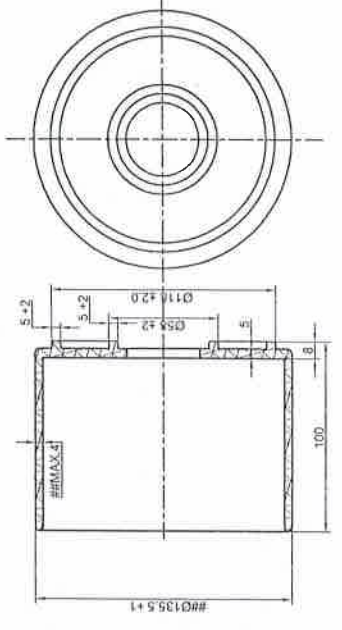
4 CUSHION PAD



6 GASKET



5 SLEEVE BOTTOM



ISSUED BY: STANDARD CELL

DATE: 22/11/23

M.P. NO: 200421

SIGNATURE: [Signature]

REMOVE ALL SHARP EDGES ALL DIMENSIONS ARE IN mm		LATEST REF/DC NO.: H OMA 125 2 056 2	
MATERIAL	3	14.01.23	14.01.23
HARDNESS	2	10.03.22	10.03.22
SURFACE FINISH	1	21.11.20	21.11.20
ALTERATIONS		DATE	DATE
TITLE : CONTAINER FOR 125mm AMK-339		APPRO.	APPRO.
TEST.MASS	PROG/FINAL	DATE	DATE
HEAVY ALLOY PENETRATOR PROJECT		SCALE	SCALE
TIRUCHIRAPALLI		DRG. NO.	DRG. NO.
		H AMK 125 1 126 3	H AMK 125 1 126 3

1. SCOPE

1.1 This specification is meant to Govern Manufacture, Supply and Quality Assurance of the following grades of polyethylene.

(a) Low density polyethylene type 1 for use in the manufacture of sheets, lay flat tubing, bags used for packing ammunition, ammunition components, ammunition chemical and Explosives and wax special No. 8.

(b) Low density polyethylene type 2 for use in the manufacture of carriers, containers and other moulded components.

(c) Linear low density polyethylene for use in the manufacture of carriers, containers and other moulded components.

(d) High density polyethylene type 1 for use in packing of ammunition components and in the manufacture of washers, sleeves etc used in ammunition.

(e) High density polyethylene type 2 for use in the manufacture of carrier, containers and barmines.

2. RELATED SPECIFICATIONS / DOCUMENTS

2.1 Reference is made in this specification to :-

Sl. No.	Specification No. & Year	Nomenclature
(a)	IS 138 : 1992 (Third Revision) Reaffirmed 2009 AMD 1	Ready Mixed Paint, Marking for Packages and Petrol Containers.
(b)	IS 1060 (Part 1) : 1966 (Revised) Reaffirmed 2009 AMD 5	Methods of Sampling and Test for Paper and Allied Products : Part 1
(c)	IS 1060 (Part 2) : 1960 Reaffirmed 2009	Methods of Sampling and Test for Paper and Allied Products : Part 2
(d)	IS 13360 (Part 5 Sec 1) : 1996 Reaffirmed 2008	Plastics - Methods of Testing Part 5 : Mechanical Properties Sec 1 Determination of Tensile Properties - General Principles.

Sl. No.	Specification No. & Year	Nomenclature
(e)	IS 13360 (Part 5 Sec 2) : 1996 Reaffirmed 2008	Plastics - Methods of Testing Part 5 : Mechanical Properties Sec 2 Determination of Tensile Properties - Test Conditions for Moulding and Extrusion Plastics.
(f)	IS 13360 (Part 5 Sec 4) : 1996 Reaffirmed 2008	Plastics - Methods of Testing Part 5 : Mechanical Properties Sec 4 Determination of Izod Impact Strength.
(g)	IS 13360 (Part 5 Sec 5) : 1996 Reaffirmed 2008	Plastics - Methods of Testing Part 5 : Mechanical Properties Sec 5 Determination of Charpy Impact Strength.
(h)	ASTM - D 256	Test Method for Impact Resistance of Plastics and Electrical Insulating Materials.
(j)	ASTM - D 638	Test Method for Tensile Properties of Plastics.
(k)	ASTM - D 648	Test Method for Deflection Temperature of Plastics Under Flexural Load.
(l)	ASTM - D 1238	Test Method for Flow Rates of Thermoplastics by Extrusion Plastometer.

3. **MATERIAL.** Polyethylene Low density, Linear low density and High density shall essentially consist of polymer of Ethylene and shall be free from pigment and plasticizers like Polyisobutylene.

4. **MANUFACTURE.** Polyethylene Low density, Linear low density and High density shall be manufactured by a process which will produce the product conforming to this specification.

5. **TENDER SAMPLE.** The manufacturer / supplier / contractor shall submit a tender sample of 1 kg of moulding powder essentially from the same batch / lot of manufacture alongwith test specimen for the tests mentioned in clause 7.4 free of all charges and conforming to this specification, to the Quality Assurance Authority / Quality Assurance Officer as stated in the contract.

6. PRE - INSPECTION OF STORES / CONSIGNMENT

6.1 Manufacturers / Contractors must satisfy themselves that the stores are in accordance with the terms of the contract and fully conform to the required specification, by carrying out a thorough pre - inspection of each lot before actually tendering the same for inspection to the Quality Assurance Officer nominated under the terms of the contract. A declaration by the contractor that necessary pre - inspection has been carried out on the stores tendered will be submitted alongwith the challan. The declaration will also indicate the method followed in carrying out pre - inspection showing the features checked / tested and will have the test certificate attached to the challan / declaration.

6.2 If the Quality Assurance Officer finds that the pre - inspection of the consignment as required above has not been carried out, the consignment is liable for rejection.

7. QUALITY ASSURANCE

7.1 Inspection.

7.1.1 Polyethylene Low density, Linear low density and High density and the packages in which it is packed shall be subject to inspection by and to the final approval of the Quality Assurance Officer / Quality Assurance Authority.

7.1.2 Samples of the material and of the packages may be taken from any portion of the batch / lot / consignment.

7.2 **Sampling.** The representative sample of 500 g shall be taken from each package selected for sampling from the batch / lot. The number of packages to be selected to draw the samples from the lot are as under:-

Lot Size	No. of Containers to be Selected
Upto 3	Each Container
4 to 15	3
16 to 50	4
51 to 100	5
101 to 300	7
301 to 500	10
501 & above	15

7.3 **Criteria for Conformity.** If on examination, any sample is found not conforming to this specification, the whole batch / lot / consignment may be rejected.

7.4 **Test Requirements.** Samples taken from any portion of the batch/lot/consignment of material shall conform to clause 3 and in addition shall conform to the test requirements shown in the following tables :-

(a) **Chemical Requirements.**

Sl. No.	Characteristic	Passing Standard			Test Method
		(Low Density)	(Linear Low Density)	(High Density)	
(a)	Ash, % by mass	Max. 0.05	0.5	0.05	IS 1060 (Part 1) Method 11
(b)	pH of water extract	Min. 5 Max. 8	5 8	5 8	IS 1060 (Part 1) Method 10
(c)	Water soluble matter, % by mass	Max. 0.2	0.2	0.2	Appendix 'A'
(d)	Water soluble chlorides calculated as Sodium Chloride, % by mass	Max. 0.05	0.05	0.05	IS 1060 (Part 2) Method 17
(e)	Water soluble sulphates, calculated as anhydrous Sodium sulphate, % by mass	Max. 0.1	0.1	0.1	IS 1060 (Part 2) Method 18
(f)	Solubility in Toluene at 80 °C ± 1 °C	Soluble	Partially Soluble	Insoluble	Appendix 'B'
(g)	Extractable matter in Toluene at 25 °C ± 1 °C, % by mass	Max. 6.0	6.0	---	Appendix 'C'
(h)	Solubility in Ethyl acetate, Acetone at 25 °C ± 1 °C	Insoluble	Insoluble	Insoluble	Appendix 'D'
(j)	Effect of organic solvents	Resistant below 60 °C	Resistant below 60 °C	Resistant below 80 °C	Appendix 'E'

(b) Physical Requirements.

Sl. No.	Characteristic		Passing Standard					Test Method
			(Low Density Type)		(Linear Low Density)	(High Density Type)		
			1	2		1	2	
(a)	Melt flow index		--	2 ± 20 %	2 ± 20 %	--	8 ± 20 %	ASTM - D 1238
(b)	Density g/ml	Min. Max.	0.910 0.925	0.918 0.922	0.916 0.920	0.941 0.965	0.955 0.959	BS 2782 Pt 6 Method No. 620 A : 1991
(c)	Yield stress, MPa	Min.	7	12	20	21	23	BS 2782 Pt 3 Method 320 A : 1976 (1986)
(d)	Elongation% at yield	Min.	90	560	500	15	10	-- do --
(e)	Impact strength (Notched) in mJ/mm ²	Min.	--	--	--	--	2.7	ASTM - D 256 Method A
* (f)	Melting temperature, °C	Min. Max.	98 115	98 115	122 124	128 133	128 133	--
* (g)	Tensile modulus in MPa	Min.	98	98	350	530	530	ASTM - D - 638
* (h)	Heat deflection temperature at 4.6 kg/cm ² load, °C	Min.	60	60	68	83	83	ASTM - D - 648

Note.

- (i) The tests mentioned at Sl. No. (f), (g) & (h) are for information only. The limits for the same will be finalized after generation of date.
- (ii) The width of specimen for yield stress and elongation should be 6 mm and rate of traverse of the machine while testing should be 50 mm / minute.

8. **WARRANTY.** The stores supplied against the contract shall be deemed to be warranted against the defective material and performance by the contractor for a period of 12 months from the date of receipt of the stores at the consignee's end and shall retain the properties described above. If during this period any of the stores supplied is found defective, the same shall be replaced by the manufacturer / supplier / contractor free of charges at the consignee's premises.

9. **PACKAGING.** The packaging shall be in accordance with the terms of the contract or as agreed to between the purchaser and contractor.

10. MARKING

10.1 All packages containing the material shall be indelibly and legibly marked with the following details:-

- (i) Nomenclature and Specification Number.
- (ii) Name and Address of the Consignee.
- (iii) A/T. or S.O. Number and Date.
- (iv) Consignment Number.
- (v) Lot / Batch Number and Date of Manufacture.
- (vi) Gross and Net Mass.
- (vii) Consecutive Number of Package and Total Number of Packages in the Consignment.
- (viii) Date of Supply.
- (ix) Contractor's Initials or Recognized Trademark.

10.2 In addition to the above the Quality Assurance Officer / Quality Assurance Authority may suggest some more marking / identification considered suitable at the time of inspection.

10.3 The paint used for marking should conform to IS 138.

11. **SAFETY OF OPERATIONS.** Nothing in this specification shall relieve the manufacturer / supplier / contractor of his responsibility for the safety of operations in the manufacture, storage, transit use of this store.

12. DEFENCE STORES CATALOGUE NUMBERS

12.1 Defence Stores Catalogue numbers allotted to the stores are as under :-

Nomenclature	DS Cat. No.
Polyethylene Low Density Type 1	9330 - 000 115
Polyethylene Low Density Type 2	9330 - 000 131
Polyethylene Linear Low Density	9330 - 000 130
Polyethylene High Density Type 1	9330 - 000 117
Polyethylene High Density Type 2	9330 - 000 119

Applicability of the Amendment :-

- (a) Applicable to existing service stores and stores under manufacture.
- (b) Specification can be amended locally.

13. SUGGESTIONS FOR IMPROVEMENT

13.1 Any suggestion for improvement in this document may be forwarded to :-

The Director,
Directorate of Standardisation,
Ministry of Defence,
'H' Block, Nirman Bhawan PO,
New Delhi - 110 011

APPENDIX 'A'

A. PREPARATION OF AQUEOUS EXTRACT AND ESTIMATION OF WATER SOLUBLE MATTER, CHLORIDES AND SULPHATES

A.1 Cover 10 g of sample, cut to small pieces passing through 200 micrometer IS sieve, with 100 ml of boiling distilled water. Allow to stand in a stoppered conical flask for an hour with occasional shaking. Filter through No. 1 Whatman filter paper. Evaporate 25 ml of the above solution in a previously cleaned, dried and weighed glass evaporating dish (M1). On sand bath, keep the dish at 100 °C for 30 minutes. Cool in desiccators and weigh (M2).

$$\text{Water soluble matter \%} = \frac{(M2-M1) \times 100 \times 100}{\text{Mass of the sample taken} \times 25}$$

A.2 Using the remaining extract, estimate chlorides and sulphates as per method 17 and method 18 of IS 1060 (Part 2) respectively.

APPENDIX 'B'

B. SOLUBILITY IN TOLUENE AT 80 °C ± 1 °C

B.1 Samples shall be tested at 80 °C ± 1 °C with Toluene. Three samples of the material 1.5 g each shall be accurately weighed. These are transferred to three Erlenmeyer flasks of 125 ml capacity. To each sample shall then be closed with ground glass stoppers or with rubber stoppers wrapped with Aluminium foil to eliminate any effect of Toluene on the rubber. The mixture shall be stored for 16 hours at 80 °C ± 1 °C. The solubility of polyethylene in Toluene at 80 °C ± 1 °C shall be observed at this temperature. The polyethylene shall be classed as soluble in Toluene at 80 °C if a clear, homogenous solution with no undissolved residue is obtained.

APPENDIX 'C'

C. EXTRACTABLE MATTER IN TOLUENE AT 25 °C ± 1 °C

C.1 Polyethylene - Toluene mixture from Appendix 'B' shall be allowed to cool to 25 °C ± 1 °C. It is advisable not to accelerate the cooling operation. The solution shall be filtered through a sintered glass crucible (G - 3) which has been previously treated in order to remove any Toluene soluble material and to bring it to constant mass by heating at 50 °C ± 1 °C (M2). The solution shall then be transferred to the tared crucible and suction applied to hasten the filtration followed by rinsing of flask with Toluene three times using 15 ml of Toluene each time. After the transfer and rinsing are complete, the final traces of Toluene are completely removed by applying suction.

C.2 The crucible shall then be heated in an oven at 50 °C ± 1 °C to constant mass (M3). During the period when crucible and/or residue is not being heated or weighed, it shall be kept in desiccators with anhydrous Calcium chloride as desiccant.

C.3 The per cent extractable matter in Toluene shall be calculated by the following formula:-

$$\text{Per cent insoluble matter} = \frac{(M3 - M2) \times 100}{M1}$$

Where M1 = The mass of the sample taken for test for Solubility at 80 °C ± 1 °C in Toluene at Appendix 'B'.

C.4 If the value is less than 6.0 %, the material shall be considered insoluble at 25 °C in Toluene and also to have complied with the requirement for extractable matter.

APPENDIX 'D'

D. SOLUBILITY AT 25 °C ± 1 °C IN ETHYL ACETATE, ACETONE

D.1 1.5 g of sample is stored with Acetone and Ethyl acetate separately at 25 °C ± 1 °C for 20 hours with approximately 60 ml of reagent. The solubility shall then be observed by evaporating the solvent or visually.

APPENDIX 'E'

E. EFFECTS OF ORGANIC SOLVENTS

E.1 Immerse a piece of the sample (weighed quantity if in powder form) in an organic solvent (normally Toluene or Ethyl acetate or Amylacetate and in special cases if required Methanol, carbon tetra chloride or dioxine) and maintain at the required temperature (60 °C for grades A & B, low, density and linear low density polyethylene and 80 °C for grade C, High density polyethylene) for 1 hour. Take out the sample and examine it visually. The sample shall not become soft or deformed or no appreciable portion of it shall dissolve in the solvent.

RAKSHA MANTRALAYA/MINISTRY OF DEFENCE
MANKIKARAN NIDESHLAYA/DTE. OF STANDARDISATION

Sheet No. 1
No. of Sheets : 1
Authority :

AMENDMENT LIST No. 1

The following amendment are approved :-

JSS No. & Year	Nomenclature	Details of Amendments	Reason for Amendments
1	2	3	4
JSS 9330-03:2014 (Revision No. 3) DS Cat. No. 9330 - 000 115 9330 - 000 131 9330 - 000 130 9330 - 000 117 9330 - 000 119	Polyethylene Low Density, Linear Low Density and High Density	On page No. 07, Clause 7.4(b) Physical Requirements (a) FOR : Sl. No. (c) Yield Stress MPa READ : Sl. No. (c) Tensile Strength at break in MPa (b) FOR : Sl. No. (d) Elongation % at yield. READ : Sl. No. (d) Elongation % at break.	The amendments are suggested by CQA (ME) Pune, vide their letter No. CQA(ME)/5025/STD/73 Dt. 16 Jun 2015.