

Monitoring Instructions as per Document No. ARDE/SPECN/491
Rolling Ring Assembly (450 KG)

1. Input material specification for **Rolling Ring Assembly (450kg)** as per IS: 1079:2009 Desg. 'HR5', as specified in Drg. No. ARDE-2122-01 DET-17 and vide Document No. ARDE/SPECN/491, ISSUE-1 Rev, dated Aug 2020.

2. Firm has to submit proof of raw material purchase and proof of sufficiency for production of full quantity demanded in supply order in OFM's raw material Inspection Format. Firm has to take clearance of raw material for chemical composition and Mechanical Properties. As per below specifications:-

TECHNICAL SPECIFICATIONS: for Ring, Plate, Strengthening Plate-1, Cover plate and Clamping Plate, Welding joint.

Sr. No.	Type of Test	Specification
1	Chemical Analysis	As per IS: 1079:2009 Desg. 'HR5'
2	Mechanical Test	UTS-400-500 Mpa. E%-26/27 Min.
3	Welding Test Piece	UTS-400-500 Mpa.

3. TECHNICAL SPECIFICATIONS: for Bolt, Washer & Punched Washer.

Sr. No.	Components/Sub-assemblies	Specification
1	Spring washer M16	IS:3063 :1994
2	Hex. Bolt M 16X25L	IS: 1363:2002
3	Hex .Bolt M 8X50 L	IS:1363:2002
4	Punched Washer M8	IS:2016 :1967

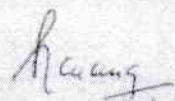
Note-

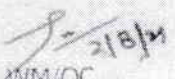
(I) All the welded portions of ring welding Assay (Two halves) shall be subjected for Dye penetrate test as per IS: 822:1970 & IS: 3658:1999 for detection of surface crack and gas hole.


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(II) All standard screws shall be tested for shear Test. Qty 10 samples, representing each lot shall be selected for test. The test shall be carried using suitable fixture approved by QA Agency. All standard components to be Zinc Nickel plated with passivation to ASTM B 841-2010. De-Embrittlement Treatment to be carried out immediately after palting. Temperature-Time graph to be provided to the QA Agency.

4. Firm has to submit two set of representative test samples (for Mechanical properties and Chemical Analysis as mentioned at clause No.2) and Test sample should represent the material for which clearance has been taken.
5. Components to be made as per drawing specified in the nomenclature & specification.
6. Firm shall submit 100% Dimensional Report along with each lot of supply.
7. The consignment shall be clean and free from Cracks, Scratches and Dents.
8. Identification: proper identification on each component i.e. supplier name and month & year of manufacture.
9. Firm to take all necessary precaution for proper packaging and surface Protection to avoid corrosion, damage during handling, transporting and storage.
10. Firms supplying the item for first time has to submit 05 set of advance sample for clearance before undertaking bulk production.


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CLEARANCE OF ADVANCE SAMPLE

Clearance of Advance samples of critical stores, being produced from trade, would be carried out jointly by the Ordnance Factory, Muradnagar & DAQAW(A) Muradnagar. Clearance of Advance Samples of non-critical stores, being produced from trade would be carried out by OFM. Submission of Advance samples would be governed by criteria appended below.

- i. When an item is being developed for the first time.
- ii. when an item is being developed through new source.
- iii. When the item is being supplied by the firm after a lapse of three years after completion of last order.