

**VQC FOR RUBBER ITEMS**

*(Rumour Equipment quality for Indiaization)*

SI N O	Nomenclature & Drawing No.	Manufacturing Technology & Testing / Inspection Facilities required to produce the item	Must be possessed by the vendor in his own premises (List of Plant & Machinery and Testing / Inspection Facilities to be submitted)	Must be possessed by the vendor in his own premises or may outsource (Name and address of sub-contractor, list of Plant & Machinery and Testing / Inspection Facilities to be submitted)
		Raw material	To purchase polymers, additives, fillers etc., to meet Specific composition as given in respective drawing.	
		Raw material Testing		Inspection of Raw materials by Inhouse facilities/external testing agencies prior to use in production.
	MANUFACTURING OF VARIOUS RUBBER ITEMS	Raw material Storage	Suitable Controlled environment with Temperature and humidity monitoring for storage of Raw materials and Master Compound Batches.	Certification of Raw Rubber issued by Rubber Board in case of Natural rubber. <i>NABL accredited Lab. ✓</i>
		Die	Appropriate CAD/CAM Software for designing of dies and CNC Machining Centre, VTL/Lathe, Welding Technology.	
		Rheology Analysis	Test facilities for batch wise rheological analysis before finalizing the compounding process.	
		Compounding	Automated Raw Material Weighment, computerized sequence technology for raw material addition.	
		Mixing of compound	Automated Mixing system in Kneader of capacity min 50kg. as per technical sequence displayed in screen without manual intervention.	
		Slug preforming/ Cutting	Suitable preformers to cut/size the compound with weight control system/equivalent technology.	
		Moulding	Suitable Compression, transfer and injection Moulding presses from mini 350 T or above presses with temperature, time and pressure control through PLC.	
	Post curing	Post curing oven with efficient temperature control from room temp to 250 deg C. with alarm system/equivalent for monitoring the controlled parameters as per given technical specification.		
	Finishing	Mechanized trimming facility to cut according to sizes as given in drawings.		

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	Inspection	<p>Test Lab with approval of Dept of Scientific and Industrial Research (DSIR), Govt of India, New Delhi or other Government approvals.</p> <p>Analytical facility like FTIR, TGA and DSC tests.</p> <p>Should have quality accreditation like ISO 9000, ISO 14001 and ISO 45001.</p> <p>Firm should have in-house lab facility with NABL accreditation to check the physical properties of Rubber and to issue reports.</p>	Should be done through IRMRA Mumbai.
	Life Testing		

  
WMM/QA

  
AGM/MMI

  
JWM/DDO

  
AGM/QA  
28/3/21

  
JWM/ML

  
AGM/P

  
JWM/TRG