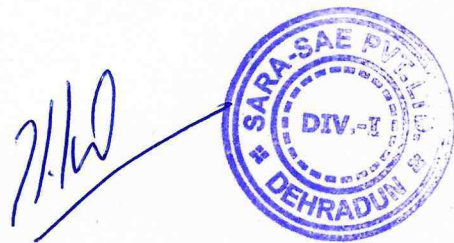
	SARA SAE ENGINEERING SPECIFICATION	
	SPECIFICATION NUMBER: SES 26-812	
	Issue: "A"	Rev No.: "0"
	Eff. Date: 20/9/2016	Page: 1 of 1

PROCEDURE FOR Chromatic Conversion MIL-DTL-5541F Type1 Class3

Rev	Reason of Change	Date	Made By	Reviewed By	Approved By	Status
0	--	20/9/2016	ND	USR	KKD	RELEASED





PROCEDURE FOR Chromatic Conversion MIL-DTL-5541F Type1 Class3

SES 26 - 812

REV 0

Part/ Proc *	Process Name / Operation description	Machine, Device, Jig, Tools For Mid.	Characteristics		Special Char. Class.	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Methods		Reaction Plan
			No.	Product	Process				Sample Freq.	Control Method	
1	Pre- Inspection	Manual Operation		Visual Defects		No dent/ damage/ scratch	Visual	5 nos.	Every Lot		Inform to Customer
2	Cleaning	Manual Operation Chemical Autotek 151			Time	5 Min.	Clock/Timer	100%	Every Batch		CHECK TIMER SETTING
					Temperature	65-75° C	Temp. Controller	100%	Day		
					Concentration	50-60 gm/ltr		100%	Day		Adjust
					EH	9					
3	Water Rinse	Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
4	Water Rinse	Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
5	Activation Dip	Manual Operation		Clean Component	Time	3-5 Dip	Clock/Timer	100%	Day		
					Room Temp.		Temperature Controller	100%			
					Concentration	30-40 %		100%			Adjust
6	Water Rinse	Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
7	Water Rinse	Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
8	Chromatic Conversion (Trivalent)	Manual Operation		Clean Component	Time	1-3 Min.	Dipping	100%	Day		CHECK TIMER SETTING
					Temperature	50-60 °C	Temperature Controller	100%			
					Concentration	100-200 gm/ltr		100%			Adjust
					PH	3-4	pH Paper		Day		
9	DM Water Rinse	DM Water Tank		Clean Component	Time	1 Dip	Dipping	100%	Lot		
10	Hot Sealing				Temperature	65-75 °C	Temp. Controller	100%			
11	Drying			Visual Defects		No nicks/cracks / Granules/ Scratches/Dents / and any other defects.	Visual				
12	Final Inspection			Visual Defects			Thick Gauge	5 Nos. per Batch	Batch	If Any rejection check 100%	Reject/Rework



OBSERVATION SHEET



PPIV NO. :-

DATE:-

P.O. NO. :- PO/1617/1056

DATE:- 27-9-16

NAME OF THE PARTY : Sang Sai Pvt Ltd

DATE :- 04-10-16

S.NO.	DESCRIPTION	DRAWING NO.	QTY. (Nos.)	OBSERVATION	
				THICKNESS	VISUAL
1)	Plate Fixing Machine	1T020322 074333A-00 Rev-02	01 Pcs	Visual OK	Panivication Done Done of Panivication as per Standard.
2)	Plate Fixing Machine	1T020322 074333A-00 Rev-02	01 Pcs		



[Signature]

[Signature]

TECHNO ENTERPRISES
10/4, 8th St, 1st Floor
10/4, 8th St, 1st Floor
10/4, 8th St, 1st Floor

Job Card No. :-

Inspected By :-



9717622229
9310504999
0120-4156004



Techno Enterprises

AN ISO 9001 : 2000 COMPANY

A HOUSE OF ALL TYPE OF METAL COATING HARD-CHROME, HARD ANODIZING & E.N.P.

To,

SARA SAE PVT.LTD.

DEHRADUN

Dear Sir,

We are certified that we are done chromatic
conversion coating on the part name Plate fixing
machining as per Drawing no.074333A-00,Rev 02 &
standard MIL-DTL-5541F TYPE 1 CLASS 3.

Thanks & Best Regards,

R.S.Bhati

For TECHNO ENTERPRISES

R.S.Bhati
Proprietor

(Proprieter)

Techno Enterprises



A-13/12, SITE - III, MEERUT ROAD INDL AREA, GHAZIABAD (U.P.)



ORIGINAL

TEST REPORT

Narang Metallurgical & Spectro Services

"Reliable Accuracy, Trustworthy Quality"®"ISO/IEC 17025 : 2005, ACCREDITED BY NABL,
DEPARTMENT OF SCIENCE & TECHNOLOGY, GOVERNMENT OF INDIA"1E/18, Ground Floor, Jhandewalan Extn., New Delhi-110 055
Mobile: 98102-68092, 98180-33846, Phones: 43587980, 45652356, 43552341
E-mail: rkharang@narangtestlabs.com, nmss22@yahoo.com
Web.: www.narangtestlabs.com

F01 (5.10)/01

Certificate No T-1505/1506
www.nabl-india.org

Party Code:

Issued to:

S5525

SARA SAE PVT.LTD.

MOHABBEWALA,
SUBHASH NAGAR,
DEHRADUN-248001

Report No:

GN29024

Dt. of Issue:

18-Oct-2016

Job Order:

46748/1 # C

Dt. of Receipt:

08-Oct-2016

Sample Desc :

SAMPLE OF 074333A-00-01 WAS RECEIVED FOR SALT SPRAY TEST.

Value Reported in Wt%

***** CERTIFICATE OF ANALYSIS *****

S.No.	DESC OF SAMPLE	RESULTS
1.	074333A-00-01 ALUMINIUM FLAT	<p>TEST CONDITIONS</p> <p>START TIME 11.00 Am</p> <p>DATE 08-10-2016.</p> <p>DUE DATE 15 -10-2016</p> <p>TIME 11.00 Am</p> <p>TEMP. : 35°±1°C</p> <p>SALT SOLUTION CONCENTRATION: 5 % Nacl</p> <p>TIME EXPOSURE: 168 HOURS</p> <p>OBSERVATION: NO WHITE RUST & RED RUST OBSERVED AFTER 168 Hrs.</p> <p>REMARKS: IT PASSES SALT SPRAY TEST AS PER ASTM B 117 - 1973.</p>



PROTOCOL USED: ASTM B 117 - 1973 & MIL-DTL-5541F

Verified by

Authorised Signatory

- Note: (i) Samples are not drawn by us. ***** End Of Report *****
- (ii) Description of sample is as provided by the party & total liability of our work is limited to Invoice Amount.
- (iii) Test Samples will be disposed after 30 days of receipt.
- (iv) This report cannot be used as an evidence in a court of law without written approval of the lab.
- (v) This report is valid for 90 days from date of issue, photocopy without authentication is not valid.
- (vi) (+) Not under NABL Scope.
- (vii) Please look for our Hologram sticker for genuine report.