	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



21/10



SARA SAE ENGINEERING
DIV.-I
DEHRADUN



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.	Methods			Reaction Plan	
			No.	Product		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size		
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.			Temperture 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	Temperture 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	100%		
12	Final Inspection		Visual Defects				Thick Gauge	5 Nos. per Batch	If Any rejection check 100%	Reject/Rework

OBSERVATION SHEET

PPIV NO. :-

DATE:-

P.O. NO. :- Po/1617/10/56

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	IT020322 074333A-00 Rev-02	01 Pcs		Visual etc Panivication Done Done of Panivication as per Standard
2)	Plate Boring Machine	IT020322 074333A-00 Rev-02	01 Pcs		

Job Card No. :-

Inspected By :-



TP Techno Enterprises

AN ISO 9001 : 2000 COMPANY

A DIVISION OF ALL TYPE OF METAL COATING HARD CHROME, HARD ANODIZING & E.N.R.

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.

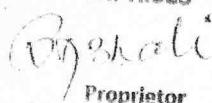
Thanks & Best Regards,

R.S.Bhati

For TECHNO ENTERPRISES

(Proprieter)

Techno Enterprises


R.S. Bhati
Proprietor



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

ORIGINAL

TEST REPORT

F01 (5.10)/01


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: rknarang@narangtestlabs.com, nmss22@yahoo.com
 Web: www.narangtestlabs.com

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

Party Code:

Issued to:

S5525

 SARA SAE PVT.LTD.
 MOHABBEWALA,
 SUBHASH NAGAR,
 DEHRADUN-248001

GN29024

 Report No: 18-Oct-2016
 Dt. of Issue: 46748/1 # C
 Job Order: 08-Oct-2016
 Dt. of Receipt:

Sample Desc :

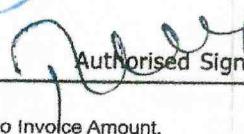
SAMPLE OF 074333A-00-01 WAS RECEIVED FOR SALT SPRAY TEST.

Value Reported in Wt%

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

S.No.	DESC OF SAMPLE	RESULTS
1.	074333A-00-01 ALUMINIUM FLAT	<p><u>TEST CONDITIONS</u></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><u>OBSERVATION:</u> NO WHITE RUST & RED RUST OBSERVED AFTER 168 Hrs.</p> <p><u>REMARKS:</u> 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.