

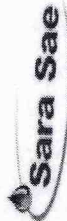
	SARA SAE ENGINEERING SPECIFICATION	
	SPECIFICATION NUMBER: SES 26-813	
	Issue: "A"	Rev No.: "0"
	Eff. Date: 20/09/2016.	Page: 1 of 1

PROCEDURE FOR PHOSPHATING AS PER MIL-DTL-16232 (TYPE M class 2)

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

7/1/16



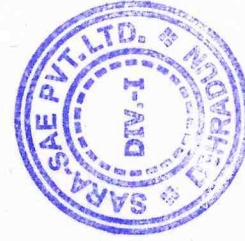


PROCEDURE FOR PHOSPHATING AS PER MIL-DTL-16232 (TYPE M class 2)

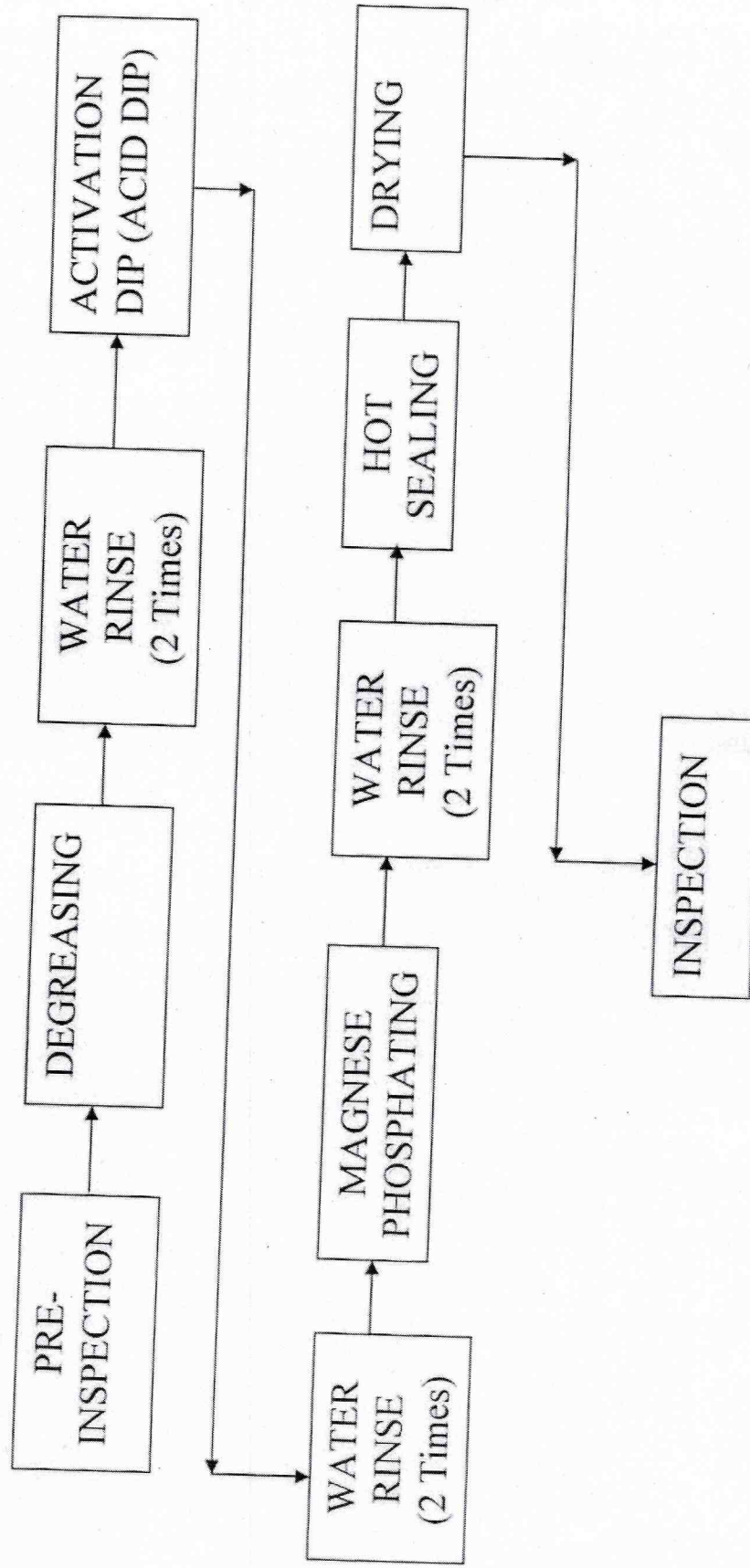
SES 26 - 813

REV 0

Part/ Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg. Manual Operation	Characteristics		Special Char. Class.	Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Methods Sample Size	Sample Freq.	Control Method	Reaction Plan Inform to Customer
			No.	Product Visual Defects							
1	Pie Inspection										
2	Degreasing	Manual Operation Chemical Gardoclean 8x		Part Clean	Time	No dent / finger / scratch	Visual	5 nos.	Every Lot		Reaction Plan Inform to Customer
3	Water Rinse				Temperature	5 Min.	Click/Timer	100%	Every Batch		CHECK TIMER SETTING
4	Water Rinse	Water Tank			Concentration	65-75° C	Temp. Controller	100%	Day		
5	Activation Dip	Water Tank		Cleaning Component	Time	7%		100%	Day		Adjust concentration
		Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
		Manual Operation		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
				Clean Component	Time	1-2 Min.	Click/Timer	100%	Lot		
6	Water Rinse	Water Tank			Room Temp.			100%	Day		
7	Water Rinse	Water Tank		Cleaning Component	Concentration	2%	Temperature Controller	100%			
8	Magnese Phosphating	Water Tank		Cleaning Component	Time	3-5 Dip	Dipping	100%			Adjust concentration
		Manual Operation		Cleaning Component	Time	3-5 Dip	Dipping	100%	Lot		
				Clean Component	Time	5-30 Min.	Dipping	100%	Lot		
9	Water Rinse				Temperature	90-100° C	Temperature Controller	100%	Day		CHECK TIMER SETTING
		Water Tank			Concentration	40-60 gm/ltr		100%			
10	Water Rinse	Water Tank		Clean Component	Time	1 Dipping	Dipping	100%			Adjust concentration
11	Hot Sealing			Clean Component	Time	1 Dipping	Dipping	100%	Lot		
12	Drying				Temperature	65-75° C	Temp. Controller	100%	Lot		
				Visual Defects		No nicks/cracks / Granules/ Scratches/Dents / and any other defects	Visual	100%			
13	Final Inspection			Visual Defects		Thick Gauge		5 Nos. per Batch	Batch	If Any rejection check 100%	Reject/Rework



PROCESS FLOW DIAGRAM
FOR PHOSPHATING AS PER MIL-DTL-16232 (TYPE M class 2)



Prepared By- ND



Approved By- KKD



OBSERVATION SHEET



PPIV NO. :-

DATE:-

P.O. NO. :- P0/1617/1056

DATE:- 27-9-16

NAME OF THE PARTY : Sarg Sai Pvt. Ltd.

DATE :- 04-10-16

S.NO.	DESCRIPTION	DRAWING NO.	QTY. (Nos.)	OBSERVATION	
				THICKNESS	VISUAL
1	Adaptor Base	IT020322 07S156A-00 Rev 01	01 Pcs	1) 7, 8, 9 L 2) 7, 9, 9 L 3) 8, 7, 10 L 4) 7, 7, 8 L 5) 9, 9, 7 L	OK OK OK OK OK

Job Card No. :-

Inspected By :-





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:

GN28882

Dt. of Issue:

12-Oct-2016

Job Order:

46748/2 # C

Dt. of Receipt:

08-Oct-2016

Sample Desc :

SAMPLE OF 074333A-00-02 WAS RECEIVED FOR SALT SPRAY TEST.

Value Reported in Wt%

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

S.No. DESC OF SAMPLE RESULTS

1. 075156A-002

STEEL FLAT

TEST CONDITIONS

START TIME

11.00 Am

DATE

08-10-2016.

DUE DATE

09-10-2016

TIME

11.00 Am

TEMP. :

35°±1°C

SALT SOLUTION CONCENTRATION:

5 % Nacl

TIME EXPOSURE:

24 HOURS

OBSERVATION:NO WHITE RUST & RED RUST OBSERVED
AFTER 24 Hrs.REMARKS:

IT PASSES SALT SPRAY

TEST AS PER ASTM B 117 - 1973.

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.

