

	SARA SAE ENGINEERING SPECIFICATION	
	SPECIFICATION NUMBER: SES 26-814	
	Issue: "A"	Rev No.: "0"
	Eff. Date: 10/12/2016	Page: 1 of 1

PROCEDURE FOR Anodic Coating per MIL-A-8625 Type II Class I

Rev	Reason of Change	Date	Made By	Reviewed By	Approved By	Status
0	--	10/12/2016	ND	USR	KKD	RELEASED

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PROCEDURE FOR Anodic Coating per MIL-A-8625 Type II Class I
SES 26 - 814
REV 0



●Prototype ○Pre-Launch ○Production												
Part / Proc #	Process Name / Operation description	Machine, Device, Jig, Tools For Mfg.	Characteristics			Special Char. Class.	Methods					Reaction Plan
			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
1	Inspection	Manual Operation		Visual Defects			No dent/ damage/ scratch	Visual	5 nos.	Every Lot		Inform to Customer
2	Fixturing	Manual Operation			Gap of fixture at Grooves		No Gap	Visual	100%	Every Batch		Re Fix the Component
3	Degreasing	Soak Degreasing Tank			Time		2-5 Min.	Clock/Timer				
					Temperature		65-80°C	Temprature Controller				
					Concentration		40-60 gm/ltrs	Chemical Analysis	1	Week		Add Chemicals Daily As per Consump. Pattern
4	Water Rinse	Water Tank		Clean Component	Time		1 Dipping	Dipping	1	Batch		
5	Water Rinse	Water Tank		Clean Component	Time		1 Dipping	Dipping	1	Batch		
6	Bright Acid Dip	Acid Tank		Cleaning Component	Time		2-5 Dip	Dipping	100%	Batch		
7	Water Rinse	Water Tank		Clean Component	Time		1 Dipping	Dipping	1	Batch		
8	Anodizing	Anodizing Tank			Temp.		15-25°C	Temprature Controller	1	Hour		
					Density		18-22 Be	Hydrometer				
				No Roughness	Concentration of Sulfuric Acid		180-200 gm/ltr	Density	1	Week		Adjust Concentration
					Current Density		300-450 Amps	Current Controller	1	Batch		Set Current
					Voltage		18-24 V					



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			No.	Product	Process		Product / Process Specification / Tolerance	Evaluation / Measurement Technique	Sample Size	Sample Freq.	Control Method	
9	Water Rinse	Water Tank		Clean Component	Time		1 Dipping	Dipping	1	Batch		
10	Water Rinse	Water Tank		Clean Component	Time		1 Dipping	Dipping	1	Batch		
11	Hot Water Sealing	Hot Water Tank		Pores Sealing	Temp.		60-85°C					
					Time		20-30 Min.	Dipping		Batch		
12	Drying			Visual Defects			No nicks/cracks / Granules / Scratches/Dents / and any other defects.	Visual	100 %	Batch		Reject/Rework
13	Inspection			Anodizing Thickness			≥ 20 Micron	Thick Gauge	10 Nos. per Batch	Batch	If Any rejection check 100%	Reject/Rework
14	Packing	Packing Material		Clean Component			Pack In Bins Provided	Visual	1	Batch		



BSL**SPECTRO LAB**

CERTIFICATE NO.
T - 1452 & T - 1453

& METALLURGICAL TESTING CENTRE

(A Unit of BSL Castings Pvt. Ltd.)
(NABL ACCREDITED LAB)

TEST REPORT

WORKS & OFFICE :
PLOT NO. 263, SECTOR-24,
FARIDABAD - 121 005 (INDIA)
Ph. No. : 0129-4189800
FAX No. : +91-129-4065535
E.mail : rawat@bsltd.net

BSL/SPECTRO/5.10F-01/01/00

Issued to: M/S Sara Sae Pvt. Ltd.,
Mohabbewala, Dehradun,
Dehradun - 2408001 (Uttarakhand)

Report No. 90295

D.O.T. : 16.01.2017

Ref. No.

D.O.R. : 31.12.2016

J.O. No. : 23247

Sample Description. : Aluminium Plate with Anodic Coating (Sample No. QAD/038/16)

SALT SPRAY TEST REPORT

(A) Test Parameters

Salt Solution = 5 % Sodium Chloride
Solution PH = 7.0 (On Collected Vessels)
Air Pressure = 1.0 Kg/cm²
Test Temp. = 35°C
Rate of Fog Collection = 1.5ml. per hour



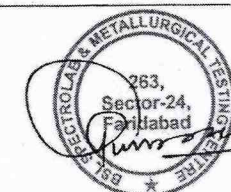
(B) Test Results

(Pic. After test)

S.No.	Salt Spray Exposure Time	Observation
1	336 Hrs. Hrs.	No white rust, blister or any other abnormality is observed

Protocol Used - IS 9844 / ASTM B 117

4
Checked By



Authorised Signatory
(Q.M. / T.M.)

- Note :
1. The result listed refer only to the tested samples and applicable parameters, Endorsement of product is neither inferred nor implied.
 2. Total Liability of our Laboratory is limited to the invoiced amount. No. liability will be accepted after the sample is taken back.
 3. *Not Covered under NABL Scope.
 4. This report can not be used as an evidence in a court of law.
 5. Samples will be destroyed after 15 days.
 6. Any Complaints about this report should be communicated within 7 days of issue of this report.
 7. This report shall not be reproduced except in full, without the written permission of the Laboratory.
 8. # Results found outside the range of NABL accredited scope.
 9. For Sample Collection Please call 9911783436, 9911709909





97176222
93105049
0120-41550



Techno Enterprises

AN ISO 9001 : 2000 COMPANY

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

CERTIFICATE OF CONFORMITY

Customer Name – Sara Sae Pvt. Ltd. Dehra Dun

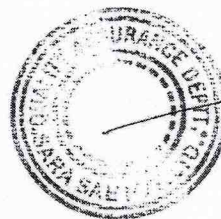
Part Name- Plate Fixing Machining

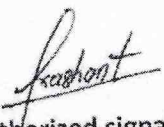
Drawing No. - Y11075A-00 Rev. 01

Quantity- 02 Nos.

Certified that the flange weight listed above have been coated and inspected accordance with the standard (MIL-A-8625 Type IIB Class I) and requirement of purchase order and unless declared here on, conforms in all respect to the drawing (s) and specification (s) relevant there on.

Techno Enterprises




(Authorized signatory)

TECHNO ENTERPRISES
A-1 & 12, Site-3, Meerut Road,
Indl. Area, Ghaziabad (U.P.)
TIN No. 09389003433



TECHNO

OBSERVATION SHEET



PPIV NO. :- 0417

DATE:-

P.O. NO. :-

DATE:-

NAME OF THE PARTY: *Sara Sae Private Limited*

DATE :- 16-12-2016

S.NO.	DESCRIPTION	DRAWING NO.	QTY. (Nos.)	OBSERVATION	
				THICKNESS	VISUAL
1	Fixing Plate ANODIC COATING per MIL-A-8625 TYPE II B5 TO 18 Microin THICK CLASS 1	Y11075A- 00	02 Nos	(1) 7, 6, 7 (2) 5, 6, 7	M OK M OK
Total			02 Nos		

Job Card No. :-

Inspected By :-

TECHNO ENTERPRISESA-13/12, Site-3, Meerut Road,
Indl. Area, Ghaziabad (U.P.)

TIN No. 09389003483

