

Name of operatives: Mr. Ravi kumar, Mr. Shashidhar, Mr. Deepak Date : 08.08.2024

Part Name/Number: Test part EACH BATCH

Operation	Characteristic	Specification	Observations	Remarks
1. Degreasing bath (Gin bond - NS 35)	Conc (Make Up)	40 - 65 gms/ltr	45.45 gms/ltr.	
	Temp.	35 +/- 5 Degree	36°C	
	Time	1 - 3 Min	2 min	
2. Alkaline Etching (Caustic Soda)	Conc (Make Up)	40 - 50 gms/ltr	46.2 gms/ltr.	
	Temp.	30 +/- Degree	28°C	
	Time	1 - 3 Min	2 min	
3. Desmutting (Nitric Acid)	Conc (Make Up)	10 - 15 %	13.86 % v/v	
	Temp.	Room Temperature	Found OK	
	Time	1 - 5 Min	4 min	
4. Anodizing (Sulphuric Acid)	Conc (Make Up)	15 +/- 2 w/v	15.4 % w/v	
	Al. Conc	Less than 10 gms/ltr	4.17 gms/ltr.	
	Voltage	15 to 20 V	18 V	
	Temp.	20 +/- 2 degree	21°C	
	Time	40 to 60 Min	60 min	
5. Dyeing (Arodal Deep Black)	PH	4.0 to 5.0	4.8	
	Temperature	40 to 50 Degree	47°C	
	Time	40 to 60 Min	60 min	


6. Sealing (Anno Seal)	Conc (Make Up)	3 - 5 g/l	4.69 gms/ltr.	
	PH	5.5 to 6.0	5.8	
	Time	40 to 60 Min	60 min	
7. Final Rinsing	PH	6.0 to 8.0	7.1	
	Time	1 - 2 Min	2 min	
8. Drying	Temperature	Room temperature	Found OK	
	Time	10 - 15 Min	15 min	
9. Thickness Inspection	15 - 20 Microns		18.5 μ	
10. Visual Inspection	<p>1. Except for touch up areas, the applied anodic coating shall be continuous, smooth, adherent, uniform in appearance, free from powdery areas, loose films, breaks, scratches and other defects which will reduce the serviceability of anodized parts or assemblies</p> <p>2. Difference in anodic coating appearance resulting from inherent base metal difference in a component such as the presence in the welds, components containing cast and machined surfaces and differences in grain size within a forging shall not be cause to reject the anodic coating unless otherwise specified in the contract or purchase order</p> <p>3. Discoloration not allowed.</p> <p>4. Contact marks. The size and number of contact marks shall be at a minimum consistent with good practice</p>		<p>All are found OK</p>	
11. Corrosion resistance test	Specimens shall be exposed for 300 hours except that the significant surface shall be inclined 6 degrees from the vertical. After exposure, specimens shall be visually examined to determine that all of		External lab.	<p>MLS/TC no. 0575/2024-2025 Test found OK</p>

the following conditions are met.

Note : Rinse bath conditions are maintained as per standard specification given

Conclusions:

Above mentioned process validated and mentioned. personnels are qualified.

Issued by : Quality  Approved by : Plant head

