

SANGIR PLASTICS PVT. LTD.

A1/ 2212,2213 , 3rd PHASE , G.I.D.C , VAPI

Ph No. 0260 2430238 /2420310

QUALITY ASSURANCE PLAN FOR HDPE PIPES

(AS PER ISO 4427-5)

Customer : M/s Walchandnagar Industries Ltd
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ISSUED BY : K.V.C.DORA
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APPROVED DATE :
VERSION : 0

Sr. No.	Test Parameter	Specification	Sample Size	SPPL	TCC/TPI	Remarks
1	Raw material	Equilent to CRP 100	Each batch of raw material	R	R	Supplier T.C Review
2	<u>Conforming Test</u> (i) OD (ii) Thickness (iii) Ovality (iv) Appearance (v) Colour (vi) Length	ISO : 4427 :05 Table-1 & 2	10% of each lot Lot - 48 hrs. production	P	Review	
3	<u>Performing Test</u> (i) Hydro static strength (ii) M.F.I (At 190 ^o c,5 kg)	(As per ISO :4427-05) & ISO 1167 SDR 11 - 159 PSI, 80 ^o c ,165 Hr SDR 17 - 99 PSI, 80 ^o c ,165 Hr SDR 21 - 80 PSI, 80 ^o c ,165 Hr Annex C Clause 8.2	3 sample of of each lot 3 sample of each lot	Perform Perform	Review -do-	

Note : Pipe shall be manufactured out of BASEL -CRP 100
P - PERFORM
R - REVIEW

For SANGIR PLASTICS PVT.LTD

QUALITY CONTROL MANAGER