

# SANGIR PLASTICS PVT. LTD.

A1/ 2212,2213 , 3<sup>rd</sup> 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  
P.O/REF NO: A-9-2-5-84-165/ 64001  
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APPROVED BY :  
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	<b><u>Conforming Test</u></b> (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	<b><u>Performing Test</u></b> (i) Hydro static strength  (ii) M.F.I (At 190 <sup>o</sup> c,5 kg)	(As per ISO :4427-05) & ISO 1167 SDR 11 - 159 PSI, 80 <sup>o</sup> c ,165 Hr SDR 17 - 99 PSI, 80 <sup>o</sup> c ,165 Hr SDR 21 - 80 PSI, 80 <sup>o</sup> 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