

**QAP/INSPECTION CRITERIA FOR PLASTIC AMMUNITION BOX M90 FOR PACKING
OF 40mm L/70(UPGRADED) AMMUNITION**

1	Item Code	9911358334 (SAP 15003252)
2	Nomenclature	Plastic Ammunition BOX M90 for packing of 40mm L/70(Upgraded) Ammunition
3	End use	Packing of 40mm L/70(Upgraded) Ammunition
4	Critical/Non critical	Non critical
5	Drawing No.	Drawing not available
6	Material	a)HDPE HMA 035 for BOX with Lid b) Styrofoam(XPS,FL300-50P) for Inner Package c) Aluminium foil as per MIL-B-131H Class 1 for aluminium foil Bag.
7	Test/check acceptance criteria for finished component	Test criteria mentioned later in this document
8	Lot/Batch size	375 or its multiple
9	Inspection/test	Examination of material, Fitment trial/critical dimensional analysis etc.
10	Inspection/test conducted by FY during bulk inspection	Visual inspection, Examination of material, Fitment trial/critical dimensional analysis, Drop test and stack test etc.
11	Inspection test conducted by QA(MAT.)	After Audit of acceptance documents, the necessary tests are being carried out
12	Dimension checking at OFK after received of sample	Fitment trial/critical dimensional analysis.
13	Marking on Box	Mention Lot/Batch No. with Manufacturer initial and year of manufacturing

TECHNICAL SPECIFICATION

END USE: Packing of 40mm L/70(Upgraded) Ammunition

INSIDE DIMENSION: a) length 570mm (approx.)

b) width 273 mm (approx.)

c) height 144 mm (approx.)

GROSS WEIGHT: 24 Kg (including the weight of 08 rounds)

GENERAL INFORMATION ABOUT THE 8 ROUND PLASTIC AMMUNITION BOX:

The 8 rounds Plastic ammunition box complies with packaging requirements of dangerous goods. In addition to that, the packaging system offers a superior support and protection of the ammunition against the elements. The Styrofoam inner casing supports the complete geometry of the all-up round and the complete packaging offers a long time protection against moisture ingress.

Ammunition box M90 consists of the following main parts:

- a) 1 No. Plastic box with hatches and a carrying handle
- b) 3 Nos. of Styrofoam inner lining (Bottom section, middle section and top section)
- c) 2 Nos. of drying agent (Bag's, one per Styrofoam layer)
- d) 1 No. Aluminium foil bag.
- e) 1 No. Plastic lid.

TEST PARAMETER:

The Ammunition box M90 is a Plastic box type 4H2 as per UN regulations. For plastic boxes containing solid material there are two type of test to be conducted

Drop test

The drop test is a series of 6 boxes from each lot/batch drooped in various impact angles. The drop height is 1.2 m. The target on which the box is dropped against must be a concrete flooring or a solid plate guaranteed not flexing at impact (in reality this means a concrete floor of min. 20cm thickness or a steel plate, min. 20mm thickness placed on a solid floor).

The boxes were filled with their shock absorbents and a test dummy. Then dropped at maximum -18.0°C

1. Drop: flat on the bottom
2. Drop: flat on the top
3. Drop: flat on the long side
4. Drop: flat on the short side
5. Drop: on a corner

Criteria for passing the test:

A packaging containing solids that strikes the target with its upper face passes the test if the entire contents are retained.

No rupture is permitted in packaging.

Drop test and pass criteria are further described in UN-Regulation Vol2 para 6.1.5.3

Stack Test

In the stack test, 3 boxes are to be tested. Each box tested is to be exposed to a pressure equivalent to an in total 3m high "tower". The boxes were filled with the dummy and foam. The test sample was subjected to a force applied to the top of the test sample equivalent to the total weight of identical packages in a height of identical packages in a height of 3m. The boxes should be subjected to the stacking test for the whole test period.

The stack test is to be conducted for a duration of 24 hours.

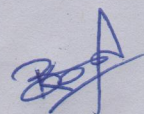
In summary, pass criteria is that the test item may not crack or burst during the test. There shall be no leakage. The packaging shall not have been damaged in such a way that it reduces the safety in transport or have deformation that can reduce its strength or cause instability in stacks.

Stack test and pass criteria are further described in UN Regulation Vol2 para 6.1.5.6

INSPECTION CRITERIA

Following identification of material and test will be performed during inspection at OFK

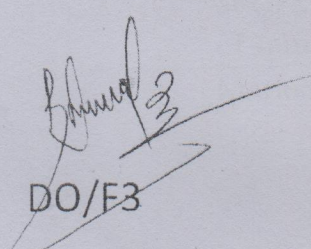
1. Material identification as per [redacted] specification.
2. Test as per [redacted] specification [redacted]
[redacted]
3. User fitment trial report.
4. Visual inspection of appearance and surface finish
5. Sampling plan: ISO 2500

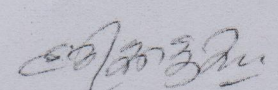


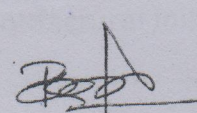
GENERAL INFORMATION:

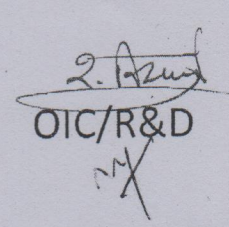
The supplier shall offer OFK or his authorized representative located at different stations free of cost, all reasonable/related facilities (including test equipment/gauges/proof ranges) for satisfying himself during auditing that the stores are being manufactured strictly in accordance with the governing specifications/and the environment and for this purpose the OFK or his authorized representative must have free access to the suppliers work premises, his processing facilities, assembly line. Test beds at all times during the auditing as well as run of the contract. The supplier is requested to notify the OFK of all the subcontractors engaged by him and ensure their quality to execute and realize the specific order. The supplier shall also make arrangements with outside agencies wherever becomes imperative to execute the spl. Quality management tools/tests with advance information to the OFK for effective/meaningful auditing as per 19011-2002 standard.

Note: If any details (such as firm's inspection report, test report etc.) will required at any stage, the same will be provided by firm.


DO/F3


OIC/F3


JWM/F3


OIC/R&D