

QAP FOR TEAR GAS GUN (METALLIC COMPONENT)

QAP/TGG/102/1
DATE: 3/01/19

DATE: 31-11-2023

1	NOMENCLATURE	UPPER BLOCK BARREL		
2	DRG. NO./ D. S. CAT NO.	TGG-102		
3	MATERIAL SPECIFICATION	BS:970; PT1: 1983, 070M55(EN-9) OR BS:970; PT1: 1983, 708M40(EN-19A)		
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING		
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING		
6	DOCUMENT VERIFICATION	A) SUPPLY ORDER	E) MECHANICAL TEST CERTIFICATE	
		B) MIS	F) CRACK DETECTION CERTIFICATE	
		C) BATCH NO.	G) PRE-INSPECTION REPORT	
		D) CHEMICAL TEST CERTIFICATE	H) BATCH SIZE	
7	VISUAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(PT.1):2000.	A) COMPONENT SHOULD BE FREE FROM RUST, PITS, CRACKS, SHARP EDGES & BURRS B) MARKINGS :- AS PER DRAWING.		
8	DIMENSIONAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(PT.1):2000.	SL. NO.	AUDIT POINTS/ DIMENSIONS	GAUGE NO. / METHOD
		1.	DIMN. 8.1+0.1	RFG 24499 GG
		2.	DIMN. $\varnothing 4.0+0.006$	RFG 24500 GG RFG 24501 GG
		3.	DIMN. 6.9+0.01	RFG 24590 GG RFG 24591 GG
		4.	DIMN. 8.1 & DOVETAIL SIMMETRICITY	RFG 24675 GG
		5.	DIMN. 2.1+0.05	RFG 24678 GG
		6.	DIMN. 20.8 $\pm$ 0.1 & 4+0.05	RFG 24680 GG
		7.	DIMN. 5-0.05	RFG 24679 GG
9	HEAT - TREATMENT			
10	CASE DEPTH			
11	PROTECTIVE FINISH			
12	OTHER TESTS	A) SALT SPRAY TEST FOR PHOSPHATING B) FITMENT AND FUNCTIONAL TRIAL		

NOTE :-

- 1) PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
- 2) TEST REPORT IS TO BE ISSUED FROM NABL APPROVED LAB./ DGQA LAB./DGQA APPROVED LAB./ ORDNANCE FACTORIES LAB.
- 3) RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
- 4) ENSURE MARKING OF MANUFACTURER'S CODE (IF MENTIONED IN THE DRAWING) ON THE STORE SUITABLY & ENTRY OF LOT NO. & YEAR OF MANUFACTURE IN PRE-INSPECTION REPORT.
- 5) TEST PIECES (ALONGWITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECIFICATION ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

REP. OF ODC

REP. OF OC