



ASSEMBLY, CARRYING HANDLE (10208111)


<u>SL.NO</u>	<u>PART NO.</u>	<u>ASSY/COMPONENT</u>	<u>NOMENCLATURE</u>	<u>PAGE</u>
1	10208112	COMPONENT	FRAME, CARRYING HANDLE, QCB	268
2	10208114	COMPONENT	POST, CARRYING HANDLE, QCB	269
3	10208113	COMPONENT	CARRYING HANDLE, QCB	270
4	10208115	LOCK ASSEMBLY, CARRYING HANDLE, QCB & COMPONENTS	LOCK ASSEMBLY, CARRYING HANDLE, QCB	271
5	10208116		LOCK, CARRYING HANDLE, QCB	272
6	10208117		SPRING, LOCK, CARRYING HANDLE, QCB	273
7	10208119		RIVET, LOCK ASSEMBLY, CARRYING HANDLE, QCB	274
8	10208118		COMPONENT	PIN, SPRING, STRAIGHT
9	91333A160	COMPONENT	LOCKNUT, 5/16-18, NYLON INSET	276
10	91434A135	COMPONENT	WASHER, FLAT, 5/16, NARROW, QCB	277


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208111								GAP No: OFT/QAP/M2HB/10208111
Nomenclature	ASSEMBLY, CARRYING HANDLE, OOW50BMG. REQD FOR HB ASSEMBLY (7265636)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Assembly, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 10208111 & Components		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208111 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208111 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208111 & Components		Firm Inspection report	W	


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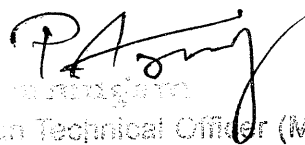

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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208112								GAP No: OFT/QAP/M2HB/10208112
Nomenclature	CASTING, FRAME, CARRYING HANDLE . FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL, AISI 1040, 1045, 1050, 4140, 4340								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Casting, Frame Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, AISI 1040, 1045, 1050, 4140, 4340		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 10208112	ANNEAL; HARDEN AND TEMPER 28-32 HRC.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
In process -As per Drawing 10208112	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208112		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208112		Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for <u>out sourced</u> components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.</p>									


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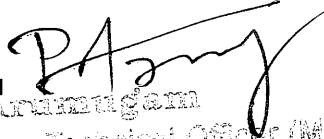
QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208114								QAP No: OFT/QAP/M2HB/10208114
Nomenclature	POST, CARRYING HANDLE . FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL, AISI 1040, 1050, 4140, 4340								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Post, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, AISI 1040, 1050, 4140, 4340		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process -As per Drawing 10208114	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208114		Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208114		Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01. Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for <u>out sourced</u> components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.</p>									


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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208113								QAP No: OFT/QAP/M2HB/10208113
Nomenclature	CARRYING HANDLE . FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	PLASTIC, MOLDING, THERMOSETTING, SPEC MIL-M-14, SPEC ASTM D5948, TYPE CFI-20, OR EQUIVALENT. COLOR: BLACK ALT: PLASTIC, INJECTION MOLDING THERMAL PLASTIC RESIN, DELRIN 500P BK602.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	PLASTIC, MOLDING, THERMOSETTING, SPEC MIL-M-14, SPEC ASTM D5948, TYPE CFI-20, OR EQUIVALENT. COLOR: BLACK ALT: PLASTIC, INJECTION MOLDING THERMAL PLASTIC RESIN, DELRIN 500P BK602.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process -As per Drawing 10208113	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%		As per Drawing 10208113	Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%		As per Drawing 10208113	Firm Inspection report	W	


(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for out sourced components. JRI will be done by NAI & OFT on sampling basis.
For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.


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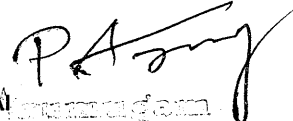

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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208115								QAP No: OFT/QAP/M2HB/10208115
Nomenclature	LOCK ASSEMBLY, CARRYING HANDLE. FOR:ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Lock Assembly, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 10208115 & Components		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208115 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208115 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208115 & Components		Firm Inspection report	W	


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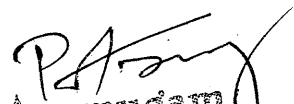

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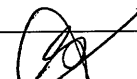
QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208116								QAP No: OFT/QAP/M2HB/10208116
Nomenclature	LOCK, CARRYING HANDLE, FOR:LOCK ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL, AISI 1040, 1045, 1050, 4140, 4340.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Lock, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, AISI 1040, 1045, 1050, 4140, 4340.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process -As per Drawing 10208116	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%		As per Drawing 10208116	Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%		As per Drawing 10208116	Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for <u>out sourced</u> components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.</p>									


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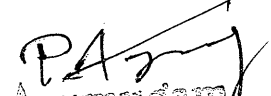
QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208117								QAP No: OFT/QAP/M2HB/10208117
Nomenclature	SPRING LOCK, CARRYING HANDLE, FOR:LOCK ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL, AISI 1095, 6150.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Spring, Lock, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, AISI 1095, 6150.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	FOR 1095 STEEL; HEAT AT 787°C-816°C, OIL QUENCH. TEMPER 1 HOUR MINIMUM TO HRC 45-50. FOR 6150 STEEL; HEAT AT 843°C-871°C, OIL QUENCH. TEMPER 1 HOUR MINIMUM TO HRC 45-50.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
In process -As per Drawing 10208117	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208117	Firm Inspection report	R		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208117	Firm Inspection report	W		
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for <u>out sourced</u> components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.</p>									



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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	10208119								QAP No: OFT/QAP/M2HB/10208119
Nomenclature	RIVET, LOCK ASSEMBLY, CARRYING HANDLE, FOR:LOCK ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL, AISI 1018, 1020								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Rivet, Lock Assembly, Carrying Handle (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, AISI 1018, 1020		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process -As per Drawing 10208119	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 10208119		Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 10208119		Firm Inspection report	W	

*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.


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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00	
									Date of Issue / / 2021	
Drg . No.	10208118									QAP No: OFT/QAP/M2HB/10208118
Nomenclature	PIN, SPRING, STRAIGHT. FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.									
Material	SPRING STEEL 1050-1095 ALT: MS16562-122.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks	
Pin, Spring, Straight (Raw material)	General appearance	Non Critical	Visual	100%	SPRING STEEL 1050-1095 ALT: MS16562-122		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%		BLACK PHOSPHATE	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
In process -As per Drawing 10208118	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%		As per Drawing 10208118	Firm Inspection report	R		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%		As per Drawing 10208118	Firm Inspection report	W		

***Note** : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.
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275

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	91333A160								QAP No: OFT/QAP/M2HB/91333A160
Nomenclature	LOCKNUT, 5/16-18, NYLON INSERT. FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	BLACK ULTRA-CORROSION-RESISTANT COATED STEEL WITH NYLON INSERT.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Locknut, 5/16-18, Nylon Insert. (Raw material)	General appearance	Non Critical	Visual	100%	BLACK ULTRA-CORROSION-RESISTANT COATED STEEL WITH NYLON INSERT.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 91333A160		Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 91333A160		Firm Inspection report	W	

*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.
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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	91434A135								QAP No: OFT/QAP/M2HB/91434A135
Nomenclature	WASHER, FLAT, 5/16, NARROW. FOR : ASSEMBLY, CARRYING HANDLE, OOW50BMG.								
Material	STEEL								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Washer, Flat, 5/16 Narrow. (Raw material)	General appearance	Non Critical	Visual	100%	STEEL		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 91434A135		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 91434A135		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 91434A135		Firm Inspection report	W	
<p>*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable. (ii) In case of hard ware items, NAI, Trichy will review the reports, if required.</p>									

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277