



**155MM/45CAL ELECTRONICALLY UPGRADED GUN
SYSTEM
“DHANUSH”**

**QUALITY ASSURANCE PLAN/ACCEPTANCE TEST
PROCEDURE
OF
CHAIR (1129837)**

**GOVERNMENT OF INDIA, MINISTRY OF DEFENCE
ORDNANCE FACTORY BOARD
GUN CARRIAGE FACTORY
JABALPUR (M.P) 482011**

QAP NO-GCF/QC/100/QAP/155MM/45CAL/DHANUSH/CHAIR
(1129837)/JULY/2020/01

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OF
CHAIR (1129837)**

REVIEWED BY

**(NILESH SOLANKI)
WM/QC**

PREPARED BY

**(DANISH ANSARI)
JWM/QC**

APPROVED BY

**(SANJAY SHRIVASTAVA)
JT.GM/QC**



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1. DIMENSIONS:

Dimensions	Instrument to be used for measurement of dimension	Observed dimensions	Remark
All dimensions must compliance with drawing and should be in the tolerance limits. Note: i. General tolerance according to IS standard.	General engineering instrument		

2. PRACTICAL TRIAL WITH DHANUSH GUN SYSTEM (OR WITH ITS SUB-ASSY) AFTER THE SAID ITEM/COMPONENTS/SUB-ASSEMBLY RECEIVED AT GCF.

S.N	Remark to be filled by concerned section	Signature by concerned head of section

3. LIST OF DOCUMENTS TO BE SUBMITTED BY FIRM ALONG WITH SUB ASSY/ /COMPONENT/ ITEM:

- Dimensional acceptance check sheet - 100%.
- Chair cushion material NABL accredited/Gov. approved lab reports to be provided.
- NABL Accredited lab report / government approved lab report to be attached with QAP for all items/components used in this assembly.
- Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports for all items/components from which the same are manufactured/formed/integrated.
- Heat treatment NABL Accredited/Gov. approved report with specified hardness as mentioned in standard along with graph, representing HT cycle, if applicable.
- NABL / government approved NDT certificated report to be attached herewith, if the same test is mentioned.
- Surface treatment report, if applicable.

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- h) Surface Coating conformation certificates for all sub-assy, if applicable.
- i) Fabrication report along with SR report, if applicable.
- j) Copies of invoice /Purchases order of all raw materials/Standard items pertaining to said item/components/sub-assy are to be attached herewith this QAP/ATP by the firm in hard copy.

4. IMPORTANT NOTES:

- a) Handling according to standard V6-1, if the same mentioned in the drawing.
- b) Use rust preventative (W11-217-1) after integration, location specified in drawing; if applicable.
- c) If any query arise pertaining to dimensions, standards (viz. mechanical properties, chemical composition, Heat treatment etc) or any other aspects which are mentioned in QAP but the same is mismatched with actual drawings/standards, then the firm should intimate GCF with detail explanation .The commencement of bulk production only be initiate after the proper clarification received from GCF, Jabalpur.
- d) Test piece of adequate size of any sub-assy may asked by the GCF for verification in respect of its Chemical compositions, mechanical properties, NDT or any other aspects, if requested.
- e) MID section (GCF) has a responsibility to perform all necessary inspection before issuing to concerned section (GCF).
- f) *Final authority of acceptance is based on the Practical trial report.***
- g) All necessary mark/punch/patter should be compliance with drawing, if applicable.

5. LIST OF DOCUMENTS PROVIDED BY GCF TO FIRM ALONG WITH THIS QAP/ATP, ISENUMERATED BELOW:

- a) A copy of drawing no. 1129837

REVIEWED BY

**(NILESH SOLANKI)
WM/QC**

(PREPARED BY)

**(DANISH ANSARI)
JWM/QC**

RESTRICTED