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**QUALITY ASSURANCE PLAN FOR MACHINING OF RACK,  
EXTERNAL & INTERNAL DRG. NO. 3013787 & 3031977**

**(FORGED RING WILL BE SUPPLIED BY GCF)**

(ITEM CODE : 9069112731)

Prepared and published by

**Gun Carriage Factory**

A Unit of Ordnance Factory Board,

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**QAP**

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This quality plan is a general guide to meet the quality requirements of product. It consists of applicable procedures (describing production processes, inspection & testing instructions), applicable workmanship standards, the measurement tolerances acceptable, the description of material standards and so forth. It also mentions the list of documents, test certificates that will be submitted by firm to GCF along with finished component.

**1. Nomenclature & Drawing No. :** MACHINING OF RACK,EXTERNAL &INTERNAL DRG NO.  
3013787&3031977

**2. Material & Condition :** As per Standard given in drawing.(Forged ring will be supplied by GCF)

**3. Method of manufacture \*** : Machining & other operations as per process. During and after machining, all dimensions and surface finish should be maintained as per specified drawing.

**4.0 Inspection:** Following methodology is to be followed for inspection.

**4.1 Mode of Inspection & Sample Size/Selection:**

**(a) At Firm Premises:** Inspection by the manufacturer for 100% quantities of lot size.

**(b) At receipt End:** Inspection by MID/QC (GCF Rep.) at receipt at GCF. Sample selection as per existing IS standard 2500 part-II, 1965.

**4.2 Visual Inspection**

S.NO.	DETAILS OF FEATURE	ACCEPTANCE CRITERIA
A	All Sharp Edges & Burrs	To be rounded off/chamfered and burrs to be removed
B	Chattering Marks on Thread	If applicable, Not allowed on thread
C	Tool Marks and Scratches	Not allowed
D	Complete surface of the machined component should be free from rust/pit marks	Rust /pit marks not allowed
E	Crack detection	After machining crack detection by appropriate method should be done to insure the component free from crack.

**4.3 Dimensional Inspection:** all dimensions (critical, major & minor in nature) & geometrical features of drawings are to be covered in check sheet and should be duly inspected by concerned quality control section. Components, having dimensions as per drawing, should only be accepted by inspectorate. No deviation in dimension or in geometrical feature is permitted.

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**6. List of Documents:**

(To be submitted by firm along with finished component during factory end inspection)

- (1) Dimensional Acceptance I-note checked by QC (Firm) with check-sheet as per Para 4.3. (Sample-100%)
- (2) Crack detection report.

**Date:-04/08/2021**

*Shree*  
04/8/2021  
Prepared By  
HOS/SC

Approved By  
Controlling Officer  
(QC)