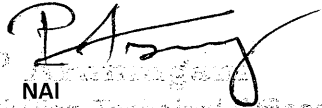
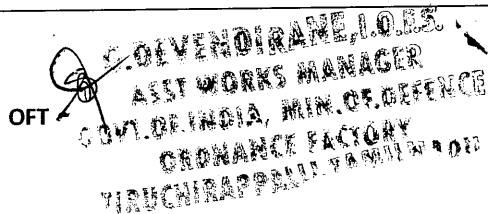


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6008975								OFT/QAP/M2HB/6008975
Nomenclature	PAWL, ALIGNING, CARTRIDGE, OOW50BMG REQD. FOR STOP ASSEMBLY CARTRIDGE (5577409)								
Material	WROUGHT STEEL, ASTM A322 OR A331, 6150, 5160 PRECISION CASTING, STEEL, MIL-S-22141; IC 6150. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A & B (AS SHOWN) OF MIL-STD-2175								
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
Pawl, Aligning, Cartridge (Raw material)	General appearance	Non Critical	Visual	100%	WROUGHT STEEL, ASTM A322 OR A331, 6150, 5160 PRECISION CASTING, STEEL, MIL-S-22141; IC 6150. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A & B (AS SHOWN) OF MIL-STD-2175		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 6008975	HEAT AT 843°C TO 871°C. OIL QUENCH. TEMPER FOR 1 HOUR MINIMUM TO HARDNESS SPECIFIED (RH A76.5- 81)	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%	MIL-STD-171	Finish 5.3.1.2 (or) 5.3.2.2	Test report from NABL lab	R	
In process -As per Drawing 6008975	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 6008975		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 6008975		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.


 P. Arany
 NAI
 Civilian Technical Officer (Mech)
 or Principal Inspector Of Naval Armament
 Tiruchirappalli.


 C. GOVINDARANE, I.O.E.S.
 ASST WORKS MANAGER
 GOVT. OF INDIA, MIN. OF DEFENCE
 ORDNANCE FACTORY
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