REAR SIGHT ASSEMBLY (12003047)

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	12003047							. ,	/ / 2021			
Nommenclature	REAR SIGHT ASSE		QAP No:									
Material	AS PER MATERIAL		OFT/QAP/M2HB/12003047									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks					
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Rear Sight Assembly (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	AS PER MATERIAL	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		R	Sample will be drawn and sealed by Inspection Agency			
	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 Drawii	ng 12003047 & Components	Test report from NABL lab	R				
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawii	ng 12003047 & Components	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 12003047 & Components		Firm Inspection report	R	Pre inspection Report for the same b			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawir	ng 12003047 & Components	Firm Inspection report	W				

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G.DEVENDIKANE, I.O.F.S.

ASST WORKS MANAGER

COVT.OF.INDIA, MIN. OF DEFENCE

ORDNANCE FACTORY

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			Q		URANCE PLAN N IM PHASE)	1			Issue No : 01 Rev No: 00 Date of Issue / / 2021
Drg . No.	7267936								7 7 2021
Nommenclature	LEAF ASSEMBLY,		QAP No:						
Material	AS PER MATERIAL	OFT/QAP/M2HB/7267936							
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Remarks			
	General appearance	Non Critical	Visual	100%	Firm Inspection report R				
Leaf Assembly, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	AS PER MATERIAL	SPECIFICATION IN THE ASSEMBLY PARTLIST.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	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 Drawi	ng 7267936 & Components	Test report from NABL lab	R	
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawi	ng 7267936 & Components	Test report from NABL lab	R	Firm will be undertaking
n process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7267936 & Components As per Drawing 7267936 & Components		Firm Inspection report	R	Pre inspection Report for the same b submitted
-inal Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%			Firm Inspection report	W	

P Axumugam (Civilian Technical Officer (Mech)

for Principal Inspector Of Navai Admament

Tiruchirappalli.

G.DEVENDIKANE, I.O. F.S.
ASST WORKS MANAGER
GOVT. OF. INDIA, MIN. OF. DEFENCE
ORDNANCE FACTORY
TIRUCHIRAPPALLI-TAMILNADU

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
				(22	,				Date of Issue / / 2021			
Drg . No.	5013610											
Nommenclature	KNOB,REAR SIGHT	QAP No:										
Material	CARBON STEEL BA	OFT/QAP/M2HB/5013610										
Component Nomenclature/ operations	nclature/ Characteristics Class Type of check check check document Acceptance norms (Review/Witness)											
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Knob, Rear Sight Elevating Screw (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BARS	CARBON STEEL BARS, ASTM A108, GRADES 1117, 1118.		R	Sample will be drawn and sealed by Inspection Agency			
(naw material)	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	_		Test report from NABL lab	R ·				
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	AMS 2759/7. AUSTEN	SE DEPTH OF 0.203 TO 0.305 IAW NITIZE IF NECESSARY, OIL QUENCH TEMPERING THE CARBURIED SHALL BE HR15N 90 MINIMUM.	Test report from NABL lab	R				
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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5013610		Firm Inspection report	R	submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5013610	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.

Communical Officer (Mech)

for Principal inspector Of Navel Armsment Tiruchirappalli.



	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	12003249											
Nommenclature	nmenclature LEAF REAR SIGHT, FOR: LEAF ASSEMBLY, REAR SIGHT, OOW50BMG (7267936)											
Material	CARBON STEEL BA		OFT/QAP/M2HB/12003249									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks					
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Leaf Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BAR	S, ASTM A108, GRADES 1018-1022	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	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 pe	r Drawing 12003249	Test report from NABL lab	R				
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	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 12003249		Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	r Drawing 12003249	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.

Civilian Technical Officer (Mech)
for Principal Impeditor Of Nevel Armament
Thruchicapp alti.

G.DEVENDIRANE, I.O.F.S.

ASST WORKS MANAGER

GOVT. OF INDIA, MIN. OF DEFENCE

ORDNANCE FACTORY

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			Q		URANCE PLAN N IM PHASE)	1		,	Issue No : 01 Rev No: 00 Date of Issue
Drg . No.	5013162								7 7 2021
Nommenclature	PIN, STRAIGHT, HE		QAP No:						
Material	CARBON STEEL BA		OFT/QAP/M2HB/5013162						
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks		
	General appearance	Non Critical	Visual	100%		<u> </u>	Firm Inspection report	R	
Pin, Straight, Headless (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BARS, ASTM A576, GRADES 1080 THRU 1095 OR TOOL STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.		Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	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 pe	er Drawing 5013162	Test report from NABL lab	R	
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	Firm will be undertaking 100 % Checks and
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5013162		Firm Inspection report	R	Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5013162	Firm Inspection report	W	

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)												
Drg . No.	5163398								/ / 2021				
Nommenclature	QAP No: OFT/QAP/M2HB/5163398												
Material	terial CARBON STEEL BARS, ASTM A108, GRADES 1018 THRU 1022, 1117 OR 1118.												
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks						
	General appearance	Non Critical	Visual	100%		<u> </u>	Firm Inspection report	· R					
Plunger, Click, Elevating Screw Knob (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	1	S, ASTM A108, GRADES 1018 THRU 22, 1117 OR 1118.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
(Naw Haterial)	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 pe	er Drawing 5163398	Test report from NABL lab	R					
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	AMS 2753C	FERRITIC NITRO CARBURIZING	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5163398		Firm Inspection report	R	Pre inspection Report for the same be submitted				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5163398	Firm Inspection report	w					

P Arumugam Circle Technical Officer (Mech)

Principal Inspector On Nevel And ament

inirappalli.



			Q	UALITY ASS	URANCE PLAN	· ·			Issue No : 01 Rev No: 00			
				(M2HB GUN	N IM PHASE)				Date of Issue / / 2021			
Drg . No.												
Nommenclature	SCRW, ELEVATING	, REAR	SIGHT, FOR: LEAF	ASSEMBLY, REA	AR SIGHT, OOW50E	BMG (7267936)			QAP No: OFT/QAP/M2HB/6008973			
Material	CARBON STEEL BA	ARBON STEEL BARS, ASTM A108, GRADES 1117, 1118.										
Component Nomenclature/ operations	Characteristics	Class	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks							
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Screw, Elevating, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BARS	5, ASTM A108, GRADES 1117, 1118.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
muchan	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 pe	er Drawing 6008973	Test report from NABL lab	R				
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	Firm will be undertaking 100 % Checks and			
in process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 6008973 As per Drawing 6008973		Firm Inspection report	R	Pre inspection Report for the same b submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%			Firm Inspection report	W				

Endmugam Civilian Technical Officer (Mech)

for Principal inspector Of Waval Armament

Tiruchirappalli.



			Q	_	URANCE PLAN	N			Issue No : 01 Rev No: 00		
				(M2HB GUN	IM PHASE)				Date of Issue / / 2021		
Drg . No.	12003250										
Nommenclature	SLIDE, REAR SIGH	T, FOR:	LEAF ASSEMBLY, I	REAR SIGHT, OO	W50BMG (7267936	5)			QAP No: OFT/QAP/M2HB/12003250		
Material	CARBON STEEL BARS, ASTM A108, GRADES 1018 TO 1022. INVESTMENT CASTING: STEEL SAE AMS-S-22141, GRADE IC4340. TENSILE TEST SHALL NOT APPLY. CLASSIFICATION & INSPECTION OF INVESTMENT CASTINGS SHALL BE IAW SAE AMS-2175, CLASS 2, GRADE 'C'.										
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks				
	General appearance	Non Critical	Visual	100%	CARBON STEEL BARS, ASTM A108, GRADES 1018 TO 1022.		Firm Inspection report	R			
Slide, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	IC4340. TENS	NG: STEEL SAE AMS-S-22141, GRADE SILE TEST SHALL NOT APPLY. & INSPECTION OF INVESTMENT	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	CASTINGS SHALL	BE IAW SAE AMS-2175, CLASS 2, GRADE 'C'.	Test report from NABL lab	R			
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As pe	er Drawing 12003250	Test report from NABL lab	R			
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	Firm will be undertaking 100 % Checks and		
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 12003250		Firm Inspection report	R	Pre inspection Report for the same submitted		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 12003250	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.

Civilian Technical Officer (Mech) for Principal Inspector Of Naval Armament Tiruchirappalii. ORDINANCE FACTORY AND COLLEGE ORDINANCE FACTORY ASSTRANCE FACTORY AND COLLEGE FACTORY

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	5163397											
Nommenclature	SPRING, HELICAL	COMPRE	SSION, FOR: LEAF	ASSEMBLY, RE	EAR SIGHT, OOW50	BMG (7267936)			QAP No: OFT/QAP/M2HB/5163397			
Material	WIRE, MUSIC, ASTM A228.											
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks					
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Spring, Helical Compression	Chemical properties	Non Critical	Chemical Lab analysis	100%	WIRE,	MUSIC, ASTM A228.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
(Raw material)	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R				
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	STRESS RELIEVE AT 2 FORMING.	24°C ± 5°C FOR 30 MINUTES AFTER	Test report from NABL lab	R				
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171	FINISH 5.3.1.3 + 30.7 OR 5.3.2.3 + 30.7	Test report from NABL lab	R .	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5163397		Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5163397	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.

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	MS51923-142								/ / 2021			
Nommenclature	PIN, COILED SPRIN	IG, FOR	: LEAF ASSEMBLY,	REAR SIGHT, O	OW50BMG (726793	6)			QAP No: OFT/QAP/M2HB/MS51923-142			
Material	STEEL COMP 302	EL COMP 302										
Component Nomenclature/ operations	Characteristics	Remarks										
	General appearance	Non Critical	Visual	100%	Firm Inspection R							
Pin, Coiled Spring (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	s	TEEL COMP 302	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	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 [Orawing MS51923-142	Test report from NABL lab	R				
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per [As per Drawing MS51923-142		R	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing MS51923-142		Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing MS51923-142		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.

NAI P Arumugam

Civilian Technical Officer (Mech)

for Principal Inspector Of Naval Amazirent

Tirucairappalli.

G.DEVENDIRANE, I.O.F.S. ASST WORKS MANAGER GOVI.OF.INDIA, MIN.OF.DEFENCE ORDNANCE FACTORY TIRUCHIRAPPALLI.TAMII NADII

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	12003051								_			
Nommenclature	nenclature RISER, REAR SIGHT FOR: REAR SIGHT ASSEMBLY, OOW50BMG (12003047)											
Material	rial CARBON STEEL BARS, ASTM A108, GRADES 1018-1040											
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Remarks					
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Riser, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BAR	S, ASTM A108, GRADES 1018-1040	Test report from NABL lab	· R	Sample will be drawn and sealed by Inspection Agency			
	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 pe	er Drawing 12003051	Test report from NABL lab	R				
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	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 12003051		Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 12003051 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.

PNALTHINEGATI

Civilian Technical Officer (Mech) for Principal Inspector Of Naval Atmament Tiruchirappalii.

OFT VORVENDINAME I.O.E.S.

ASST WORKS MANAGER

GOV. OF INDIA, MIN. OF OFFENCE

ORDINANCE ACTORY

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)												
Drg . No.	. No. 5013607 Immenciature SCALE, WINDAGE, REAR SIGHT: FOR: REAR SIGHT ASSEMBLY, OOW50BMG (12003047)												
Nommenclature	SCALE, WINDAGE,		QAP No: OFT/QAP/M2HB/5013607										
Material	STEEL, CARBON; A	STM A1		Of maximizing solution									
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				
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Scale, Windage Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	STEEL,	CARBON; ASTM A109	R	Sample will be drawn and sealed by Inspection Agency					
	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 pe	er Drawing 5013607	Test report from NABL lab	R					
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	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	er Drawing 5013607	Firm Inspection report	R	Pre inspection Report for the same be submitted				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5013607	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 <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.

Civilian Technical Chicer (Mach) for Principal Inapedior Of Kaval Armament ThuchkeppsNi.

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	QUALITY ASSURANCE PLAN												
			•	(M2HB GUN	I IM PHASE)				Date of Issue / / 2021				
Drg . No.	. No. 5013167 mmenclature SCALE, WINDAGE, REAR SIGHT: FOR: REAR SIGHT ASSEMBLY, OOW50BMG (12003047)												
Nommenclature	SCALE, WINDAGE,		QAP No: OFT/QAP/M2HB/5013167										
Material	CARBON STEEL BA	ARS, AST	,	G. 11 .2 1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.1.									
Component Nomenclature/ operations	Characteristics	Characteristics Class Type of check Quantum of check Reference document Acceptance norms Format of record (Review/Witness)											
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Scale, Windage Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BARS	5, ASTM A108, GRADES 1018, 1020, 1117, 1118.	R	Sample will be drawn and sealed by Inspection Agency					
	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 pe	er Drawing 5013167	Test report from NABL lab	R					
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	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As po	er Drawing 5013167	R	Pre inspection Report for the same be submitted					
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	W								

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ASST. WORKS MANAGER

ASST. WORKS MIN. OF. DEFENCE

ORDNANCE FACTORY

TIRUCHIRAPPALLITA MIN. OF. DEFENCE

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)												
Drg . No.													
Nommenclature	SPRING, REAR SIG		QAP No: OFT/QAP/M2HB/12003052										
Material	CARBON STEEL, A		OF 1/QAP/M2HB/12003092										
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				
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Spring, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL, AS	STM A684, GRADES 1050 TO 1074.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
,	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	=		Test report from NABL lab	R					
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%		NITIZING TEMPERATURE, QUENCH 15N 81-84 IAW SAE AMS 2759.	Test report from NABL lab	R					
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	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	er Drawing 12003052	Firm Inspection report	R	Pre inspection Report for the same be submitted				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 12003052	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.

Civilian Technical Officer (Mech)

for the half inspector Of Naval Armament

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)										
•				(M2HB GUN	IM PHASE)				Date of Issue / / 2021		
Drg . No.	5013160										
Nommenclature	WINDAGE SCREW,		QAP No: OFT/QAP/M2HB/5013160								
Material	STEEL, CARBON; S										
Component Nomenclature/ operations	Characteristics	Remarks									
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R			
Windage Screw, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	STEEL, CARBON	; SAE 1117, 1118; ASTM A108.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency		
materiari	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 pe	er Drawing 5013160	Test report from NABL lab	R			
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	Firm will be undertaking 100 % Checks and		
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	er Drawing 5013160	Firm Inspection report	R	Pre inspection Report for the same be submitted		
Final Inspection	General appearance	w									

PArumugam
Civilian Technical Officer (Mech) for Principal Inspector Of Naval Associations
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TIRUCHIRAPPALLI TAMILLI TAMILLI

·	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)												
				(IIIZI IB COIT					/ / 2021				
Drg . No.	6008809												
Nommenclature	KNOB, REAR SIGH	NOB, REAR SIGHT WINDAGE SCREW: FOR: REAR SIGHT ASSEMBLY, OOW50BMG (12003047)											
Material	STEEL, CARBON; S	TEEL, CARBON; SAE 1018 THRU 1022, 1117, 1118; ASTM A108 - COLD DRAWN.											
Component Nomenclature/ operations	Characteristics	Characteristics Class Type of check Quantum of check Reference document Acceptance norms Format of record (Review/Witness)											
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Knob, Rear Sight Windage Screw (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	, ,	AE 1018 THRU 1022, 1117, 1118; A108 - COLD DRAWN.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
materiary	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 pe	er Drawing 6008809	Test report from NABL lab	R					
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	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	er Drawing 6008809	Firm Inspection report	R	Pre inspection Report for the same be submitted				
Final Inspection	General appearance	W											

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Civilian Technical Officer (Mech) for Principal Inspector Of Navel Armameric Tiruchire poets. OFI

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ORDNANCE FACTORIX.

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	MS39086-56											
Nommenclature	PIN, COILED SPRIN		QAP No: OFT/QAP/M2HB/MS39086-56									
Material	1050-1095 SPRING	1050-1095 SPRING STEEL										
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Remarks						
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	·			
Pin, Coiled Spring (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	1050-	-1095 SPRING STEEL	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	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 MS39086-56	Test report from NABL lab	R				
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per	Drawing MS39086-56	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per	Drawing MS39086-56	Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per	Drawing MS39086-56	Firm Inspection report	W				

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		,,	Q		URANCE PLAN N IM PHASE)				Issue No : 01 Rev No: 00 Date of Issue / / 2021			
Drg . No.	5013155											
Nommenclature	PLUNGER, CLICK,	WINDAG	E: FOR: REAR SIG	HT ASSEMBLY,	OOW50BMG (12003	047)			QAP No: OFT/QAP/M2HB/5013155			
Material	HOT WROUGHT CA	OT WROUGHT CARBON STEEL BAR, ASTM A576. GRADE 1085 TO 1095, OR TOOL STEEL: ASTM A686. CLASS W1-8 THRU 11, GRADE 'C'.										
Component Nomenclature/ operations	Characteristics	Characteristics Class Type of check Quantum of check Reference document Acceptance norms Format of record (Review/Witness)										
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Plunger, Click, Windage (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	GRADE 1085 TO 10	CARBON STEEL BAR, ASTM A576. 195, OR TOOL STEEL: ASTM A686. 1-8 THRU 11, GRADE 'C'.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%		· · · · · · · · · · · · · · · · · · ·	Test report from NABL lab	R				
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%		NITIZING TEMPERATURE, QUENCH, A 73.5-77 IAW SAE AMS 2759.	Test report from NABL lab	R				
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	Firm will be undertaking 100 % Checks and			
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	er Drawing 5013155	Firm Inspection report	R	Pre inspection Report for the same be submitted			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 5013155	Firm Inspection report	w				

NAI PArinnigam
PArinnigam
Circles Technical Office (Mech)

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G.DEVENDIRANE, I.O.F.S.

ASST. WORKS MANAGER
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OFFICE
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ORDNANCE FACTORY
TIRUCHIRAPPALLI TAMIN.

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)										
Drg . No.	5013154										
Nommenclature .	SPRING, HELICAL		QAP No: OFT/QAP/M2HB/5013154								
Material	WIRE, MUSIC, STEE		OF I/QAF/MIZHB/8013134								
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		
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R			
Spring, Helical Compression	Chemical properties	Non Critical	Chemical Lab analysis	100%	WIRE, MU	JSIC, STEEL, ASTM A228.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency		
(Raw material)	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R			
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	STRESS RELIEVE AT 2 COILING	24°C ± 5°C FOR 30 MINUTES AFTER	Test report from NABL lab	R			
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171	FINISH 5.3.1.3 + 30.7 OR 5.3.2.3 + 30.7	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and		
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	. As po	er Drawing 5013154	Firm Inspection report	R	Pre inspection Report for the same be submitted		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As p	er Drawing 5013154	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 man

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.

> Civilian Technical Officer (Mech) for Principal Inspector Of Naval Armament Tiruchirappalli.

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	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)										
									/ / 2021		
Org . No.	MS35191-216								QAP No:		
Nommenclature	MACHINE SCREW,		OFT/QAP/M2HB/MS35191-216								
Material	STEEL, COMP 1010	, 1011 O	1								
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		
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R			
Machine Screw, Phillips Head, 2-64 UNF.	Chemical properties	Non Critical	Chemical Lab analysis	100%	STEEL, COI	MP 1010, 1011 OR 1013.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency		
(Raw material)	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 D	Drawing MS35191-216	Test report from NABL lab	R			
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	CADMIUM PER QQ-P-416	TYPE-II, CLASS	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and		
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per [Orawing MS35191-216	Firm Inspection report	R	Pre inspection Report for the same b submitted		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per [Drawing MS35191-216	Firm Inspection report	W			

(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

Sivilian Technical Officer (Mech)

for Principal Inspector **Of Navel** Armement Tiruchirappatii.

G.DEVENDIRANE, I.O.F.S.
ASST.WORKS MANAGER
GOVT. OF. INDIA, MIN. OF. DEFENCE
ORDNANCE FACTORY
TIRUCHIRAPPALLI TAMILLA SIL

	QUALITY ASSURANCE PLAN												
				(M2HB GUN					Date of Issue / / 2021				
Drg . No.	No. 12003056 menclature BASE ASSEMBLY, REAR SIGHT: FOR: REAR SIGHT ASSEMBLY, OOW50BMG (12003047)												
Nommenclature	BASE ASSEMBLY,		QAP No: OFT/QAP/M2HB/12003056										
Material	AS PER MATERIAL												
Component Nomenclature/ operations	Characteristics	Inspection by GM/OFT (Review/Witness)											
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Base Assembly, Rear Sight.	Chemical properties	Non Critical	Chemical Lab analysis	100%	AS PER MATERIAL	SPECIFICATION IN THE ASSEMBLY PARTLIST.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
(Raw material)	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 Drawi	ng 12003056 & Components	Test report from NABL lab	R					
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawi	ng 12003056 & Components	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawi	ng 12003056 & Components	Firm Inspection report	R	Pre inspection Report for the same be submitted				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawi	ing 12003056 & Components	Firm Inspection report	W					

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(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

Ve Devendikane, 1.0.7.5.

ASSY WORKS MANAGER

OVI OF INDIA, MIN. OF DEFENCE

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)											
Drg . No.	12003048								QAP No:			
Nommenclature	BASE, REAR SIGHT	SASE, REAR SIGHT: FOR: BASE ASSEMBLY, REAR SIGHT, OOW50BMG (12003056)										
Material	STEEL, CARBON, A	STEEL, CARBON, ASTM A109 TEMPER NO.4 OR 5.										
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			
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Base, Rear Sight (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	STEEL, CARBON,	ASTM A109 TEMPER NO.4 OR 5.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
(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 pe	er Drawing 12003048	Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	er Drawing 12003048	Firm Inspection report	W	submitted			

[*) 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.

PArumugam /

Civilian Technical Officer (Mech)

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ASST. WORKS MANAGER GOVT.OF.INDIA, MIN.OF.DEFENCE ORDNANCE FACTORY
TIRUCHIRAPPALLI TAMILMADII

	QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)												
Drg . No.													
Nommenclature	BUSHING, WINDAG	JSHING, WINDAGE SCREW: FOR: BASE ASSEMBLY, REAR SIGHT, OOW50BMG (12003056)											
	CARBON STEEL BA	STM A681, TYPE A2	OFT/QAP/M2HB/12003049										
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				
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R					
Bushing, Windage Screw (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BAR,	BARS, ASTM A108, GRADE 1141, ASTM A331, GRADE 4140 OR 4150, L. ASTM A681, TYPE A2 OR S7.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	-	,	Test report from NABL lab	R					
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	LOCALLY HARDENED	TREATED BEFORE ASSEMBLY OR AFTER PROVIDED HARDNESS 48 MIN. IS SATISFIED AFTER	Test report from NABL lab	R	Firm will be undertaking				
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As pe	r Drawing 12003049	Firm Inspection report	R	100 % Checks and Pre inspection Report for the same be submitted				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As pe	r Drawing 12003049	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.

P Mrumugam/

Civilian Technical Officer (Mech) for Principal Inspector Of Navel Armament

Tiruchirappalli.

GOEVENOINAME, 1.0.E.S.

ASST. WORKS MANAGER

GOVI OF INDIA, MIN. OF DEFENCE

ORDNANCE FACTORY

	Issue No : 01 Rev No: 00 Date of Issue / / 2021								
Drg . No.									
Nommenclature	RETAINER, SPRING	QAP No: OFT/QAP/M2HB/12003053							
Material	CARBON STEEL SH								
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
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	
Retainer, Spring (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%		SHEET OR STRIP, AMS QQ-S-700, RADES 1040-1050.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
(Kaw Material)	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	PART MAY BE HEAT TREATED BEFORE ASSEMBLY OR LOCALLY HARDENED AFTER PROVIDED HARDNESS REQUIREMENT SPECIFIED HEREON IS SATISFIED AFTER BRAZING. HARDNESS: ROCKWELL HARDNESS HRC 48 MIN.		Test report from NABL lab	Ř.	Firm will be undertaking
In process	Dimensions Specified in the Inspection report of the	Non Critical	Dimensional measurement	100%	As per Drawing 12003053		Firm Inspection report	R	Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 12003053		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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Civilian Technical Officer (Mech)

for Principal Inspector Of Navsi Armement

Tiruchirappalli.



	Issue No : 01 Rev No: 00 Date of Issue								
Drg . No.									
Nommenclature	STOP, REAR SIGHT	QAP No: OFT/QAP/M2HB/12003050							
Material	CARBON STEEL BA								
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
Stop, Rear Sight Leaf (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%	CARBON STEEL BAR,	BARS, ASTM A108, GRADE 1141, , ASTM A331, GRADE 4140 OR 4150, L, ASTM A681, TYPE A2 OR S7.	Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	OK TOOL STEE	L, A31111 (1002)	Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	LOCALLY HARDENED	TREATED BEFORE ASSEMBLY OR D AFTER PROVIDED HARDNESS 48 MIN. IS SATISFIED AFTER	Test report from NABL lab	R	Firm will be undertaking
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As p	er Drawing 12003050	Firm Inspection report	, ,	100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%		er Drawing 12003050 Trichy may do Surveillance audi	Firm Inspection report	VV	

*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

(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

Parumugam (

Civilian Technical Officer (Mech)

for Friedpal inspector Of Naval Armament Tire anirappalli.

G.BEVENDIKANE, 1.0.1.3.
ASST.WORKS MANAGER
GOVT. OF. INDIA, MIN. OF DEFENCE
ORDNANCE FACTOR
TIRUCHIRAPPALLITA MANAGER