



**155MM/45CAL ELECTRONICALLY UPGRADED GUN  
SYSTEM  
"DHANUSH"**

**QUALITY ASSURANCE PLAN/ACCEPTANCE TEST  
PROCEDURE  
OF  
PROTECTOR RIGHT (1146579)**

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

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**QAP NO-GCF/QC/100/QAP/155MM/45CAL/DHANUSH/PROTECTOR RIGHT**  
**(1146579)/FEB/2020/01**

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PROCEDURE OF  
PROTECTOR RIGHT (1146579)  
FOR  
155 mm / 45 CAL DHANUSH**

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Prepared and published by



**Gun Carriage Factory**  
Ordnance Factory Board  
Government of India, Ministry of Defence,  
Jabalpur (MP) 482011



Under the Authority of  
Secretary, Ministry of Defence, Govt. of India

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**REVIEWED BY**

**(NILESH SOLANKY)  
WM/QC**

**PREPARED BY**

  
04.03.2020  
**(DANISH ANSARI)  
JWM/QC**

**APPROVED BY**

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

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1. MATERIAL DETAILS:

S.N.	Material
a)	Chemical composition and mechanical properties are according to the given standard.  And its Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports for all items/components from which the same are manufactured/formed/integrated is to be attached herewith.

2. 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.  <b>Note:</b> i. General tolerance according to IS standard.	General engineering instrument		

3. 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

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

- Dimensional acceptance check sheet - 100%.
- Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports for all items/components from which the same are manufactured/formed/integrated.

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WM/QC

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- c) Heat treatment NABL Accredited/Gov. approved report with specified hardness as mentioned in standard along with graph, representing HT cycle, if applicable.
- d) NABL / government approved NDT certificated report to be attached herewith, if the same test is mentioned.
- e) Surface treatment report, if applicable.
- f) Surface Coating conformation certificates for all sub-assy, if applicable.
- g) Fabrication report along with SR report, if applicable.
- h) 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.

5. **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 applicable 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 of its Chemical and mechanical properties.
- e) ***Final authority of acceptance is based on the Practical trial report.***
- f) All necessary mark/punch/patter should be compliance with drawing, if applicable.

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

- a) A copy of all drawings under article no. 1146579

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

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- a) Dimensional acceptance check sheet - 100%.
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