

ACCEPTANCE TESTING PROCEDURE
OF
PIPE ASSEMBLY
DRG NO.4710-040645

Prepared and published by

Gun Carriage Factory

A Unit of Advanced weapon and equipment India
Limited

Government of India, Ministry of Defence,
Jabalpur (MP) 482011



ATP

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. Drawing No. & Nomenclature: 4710-040645 & PIPE ASSEMBLY.

2. Material & Condition: As per Standard given in drawing.

2.1 Test/Checks and Acceptance criteria for Material.

SL NO.	SEQUENCE OF OPERATION/PROCESS/FUNCTIONAL CHECK/INSPECTION	REMARKS(SAMPLE PLAN OR ANY OTHER APPLICABLE INSTRUCTION)
1	FIT ASSEMBLE ALL DETAILS AS PER DRG.	ASSY SHOULD CONFIRM ACCEPTANCE TEST
2	ACCEPTANCE TEST	

3.0 Inspection: Following methodology is to be followed for inspection.

3.1 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.

(c) Acceptance as per chemical composition and Mechanical properties/performance Test/Fitment Trial/Practical Trial/Any other functional requirement.

4.Submission of Documents:

Following documents should be submitted along with finished product:

- (1) Acceptance test report after functional trial.
- (2) NABL/GOVT. approved Lab certificate required for material.

Date: 01/03/2023

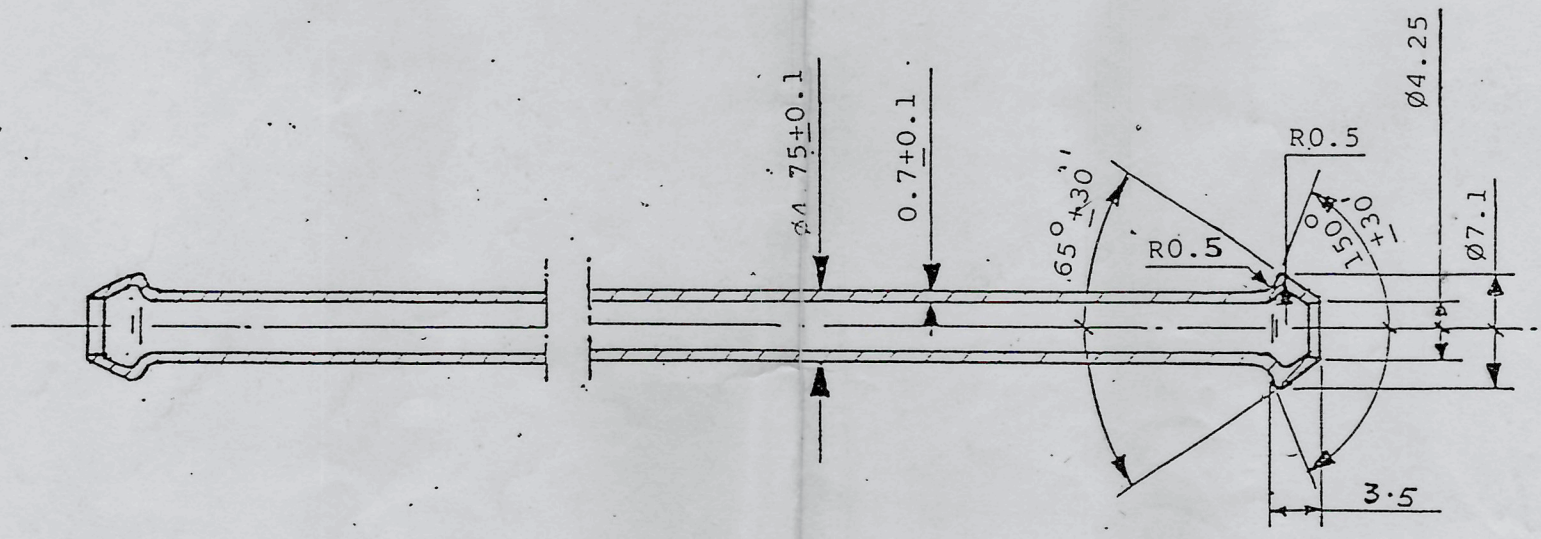
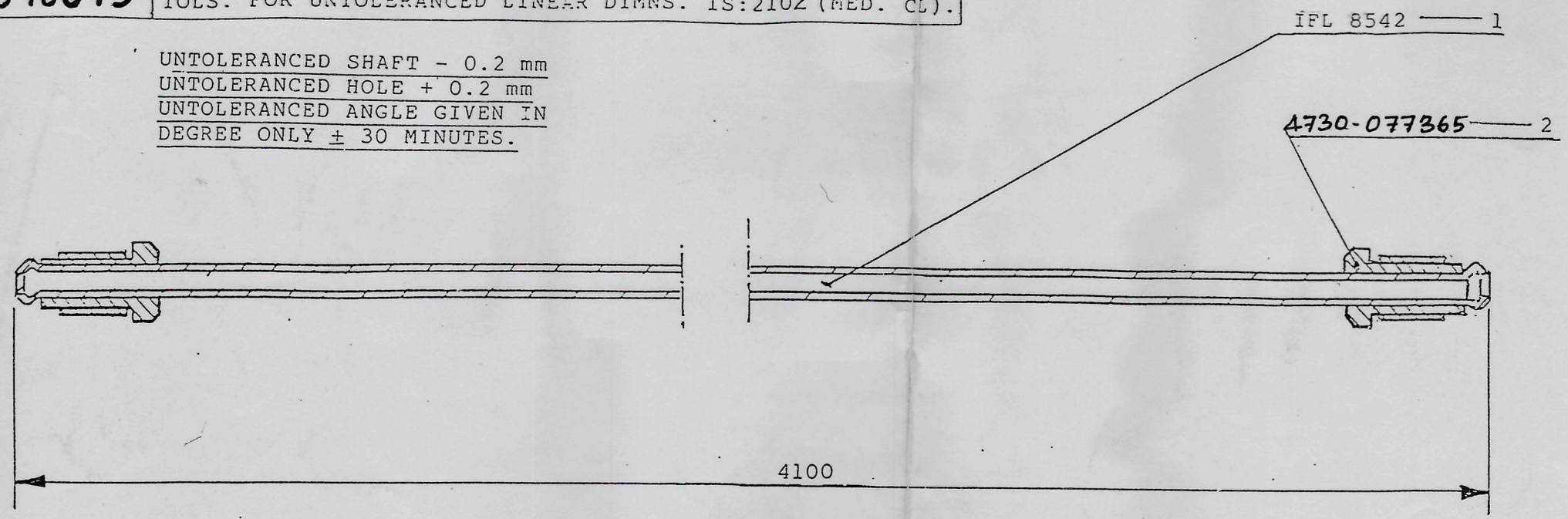
ABia
**Prepared by
JWM/SC**

d
**APPROVED BY
Quality Controlling Officer**

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DS CAT No. **4710-040645** DRG CONVENTIONS CONFORM TO IS:696.
 DIMENSIONS ARE IN mm.
 TOLS. FOR UNTOLERANCED LINEAR DIMNS. IS:2102 (MED. CL).

UNTOLERANCED SHAFT - 0.2 mm
 UNTOLERANCED HOLE + 0.2 mm
 UNTOLERANCED ANGLE GIVEN IN
 DEGREE ONLY ± 30 MINUTES.



ENLARGED VIEW OF TUBE

BASED ON ILG-2235/1

REDUCED AT CQA(W) JABALPUR
 PREPARED BY KKT CHECKED BY *V.S.S.* DATE 3-12-93

10-12-12	19292-W	NOMEN, HINDI & DS CAT N. AMENDED
03-1-04	18344-W	PROV. SEALING CANCELLED & DRG. SEALED.
13-12-93	17327-W	DRG. SEALED PROV.

<i>R. Havel</i> CHIEF D'MAN	ASSY DRG IFL 530 A	CQA (W) JABALPUR
<i>gru</i> AHSP	ESTD MASS	
<i>For CQA(W)</i> DRG SEALED: - 18844-W DE. 03-1-04 DO CQA(W)	DATE 14.11.85	DESIGN No.
	SCALE - NTS	PART No. IFL943SA
	DRN	DS CAT No. 4710-040645
	CHD	

पाइप असेम्बली PIPE ASSEMBLY

DS CAT No.

4730-077365

DRG CONVENTIONS CONFORM TO IS : 696
DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED

TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS

ABOVE	-	6	30	120	315	1000	2000	4000
UP TO	6	30	120	315	1000	2000	4000	-
TOLS	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3

THREADS CONFORM TO IS : 4218

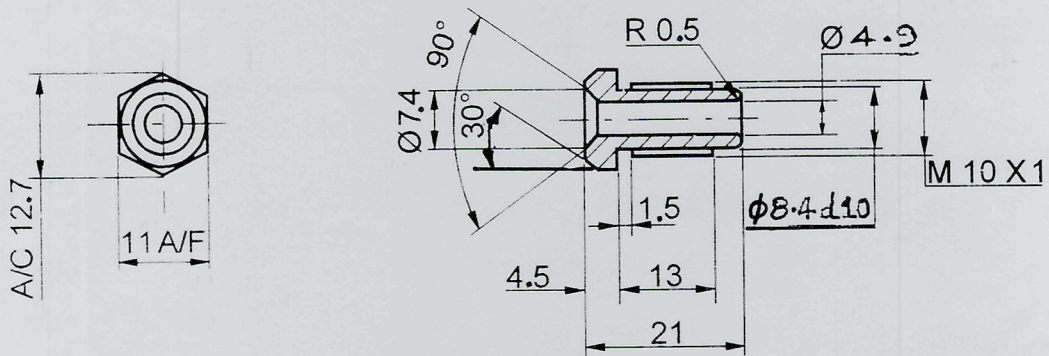
UNTOLERANCED SHAFT - 0.2 mm

UNTOLERANCED HOLE + 0.2 mm

UNTOLERANCED ANGLE GIVEN IN DEGREE

ONLY ± 30 MINUTES

NOM. SIZE & FIT	DEVIATION
Ø8.4 d10	-0.040 -0.098



- NOTE :- 1. CADMIUM PLATING AS PER IS : 1572
2. SHARP CORNERS TO BE REMOVED

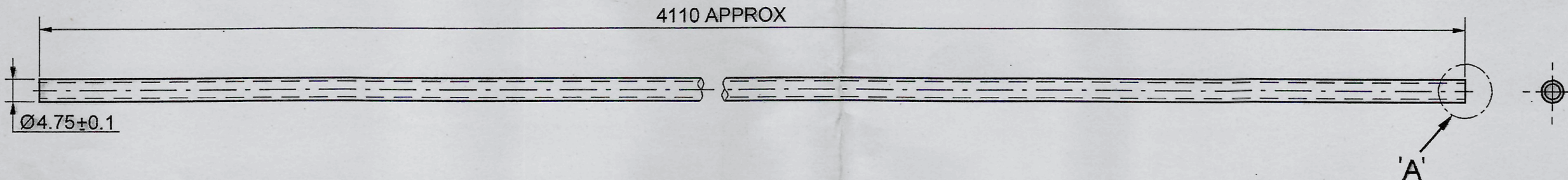
VV

						CQA(W), JABALPUR	
						DRN	CHD
11-3-14						SCANNED :- PKA	CHD GSN.
SCANNED & PRINTED WITHOUT CHANGE						AHSP	
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO	H O S FOR CQAW	
PREV DC Nos:- 17827-W, 18825-W, 18844-W & 19292-W DT 10-12-12						ASSY DRG.	
DRG SEALED :- 18844-W DT 03-01-04						1015-003234	
SCALE :- 1 : 1		ESTD mass		DATE :-		DESIGN No.	ASSY DRG
MATERIAL :- IS : 4431 - 40 C 10 S 18 (B) 1978						ILG 2237 / 1	ILG 2235 / 1 SA
PROT FINISH :-						PART No	IFL 8296
BOLT FLUID PASSAGE						DS CAT No.	4730-077365
बोल्ट फ्लूड पेसेज							

PART No.

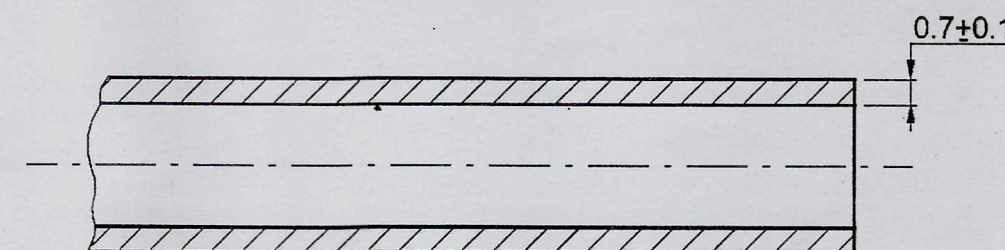
IFL 8542

DRG CONVENTIONS CONFORM TO IS : 696								
DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED								
TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS								
ABOVE	-	6	30	120	315	1000	2000	4000
UP TO	6	30	120	315	1000	2000	4000	-
TOLS	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3



MATL:-

- STEEL TUBE (BUNDY TUBE)
- TS 42 Kg/mm²(MIN)
- ELONGATION 25% (MINIMUM)
- PRESSURE LOAD TEST 350 Kg/cm²
- BURST STRENGTH 800 Kg/cm²
- BENDING TEST 360° BEND AT 1.5 D
- TIN LEAD COATING 2 TO 3 μ BY (HOT DEEP PROCESS)
- OR ELECTROGALVANISING 8 μ.



ENLARGED VIEW AT 'A'

SCALE:- 5:1

- NOTE:-**
1. TUBE ENDS TO BE FORMED AS INDICATED IN DRG No. 1015-003234.
 2. BEFORE FORMING THE TUBE ENDS SCREWS COUPLING 1015-003233 QTY-2 TO BE ASSEMBLED AS SHOWN IN DRG No. 1015-003234.

BASED ON ILG 2235/1

				DRAWN:-		CHD:-		ASSY DRG:- 1015-003234		CQA(W), JABALPUR		
				SCANNED:- AKB		CHD:- <i>[Signature]</i>		DATE:- 20-12-85				
01-05-19 19718-W				UNDER COLUMN 'MATL' AMENDED.				AHSP		SCALE:- 1:1		
20-07-17				SCANNED & PRINTED WITHOUT CHANGE				HOS DO		FOR CQA(W) ESTD mass:-		
DATE	AUTHORITY	ZONE	AMENDMENTS			SIG AHSP	SIG DO	MATERIAL:- IS: 3074-2005, GRADE CDS-2			DESIGN No.	
PREV DC Nos:- 17827-W, 18844-W DT. 03-01-04						PROTECTIVE FINISH:-						PART No.
DRG SEALED:- 18844-W DT. 03-01-04						TUBE						IFL 8542
												DO CQA(W)