



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

QUALITY ASSURANCE PLAN/ACCEPTANCE TEST  
PROCEDURE  
OF  
BEARING HOUSING MACHINED CASTING  
(GCF-50-40889)

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

QAP NO-GCF/QC/100/QAP/155MM/45CAL/DHANUSH/BEARING HOUSING  
MACHINED CASTING (GCF-50-40889)/JUNE/2021/01


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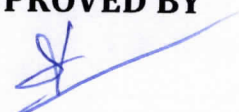
**REVIEWED BY**



**(NILESH SOLANKY)  
WM/QC**

**PREPARED BY**

  
**(DANISH ANSARI)  
JWM/QC**

**APPROVED BY**

  
**(SANJAY SHRIVASTAVA)  
AGM/Q**

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**1. MATERIAL DETAILS:**

S.N.	Material
a)	Chemical composition and mechanical properties compliance with standard given in drawing.  And its Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports 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. Casing tolerance according: SS722GTA12 or SS722 GTB 16, which ever mentioned in casting drawing. ii. Dimensions given regarding wall thickness are minimum. iii. Appropriate casting clearance to be applies.	General engineering instrument		



**3. NON-DESTRUCTIVE TESTING :**

Parameter	Specification	Report
1. Radiography	Gas hole and forging material: level 5 as per ASTM E-192 Shrinkage (All type): Level 3 as per ASTM E-192.	NABL accredited/Gov. approved lab reports
2. Ultrasonic test	ASTM E446-78 , Class 2 , Group A,B & C Group D, E, F & G are not acceptable.	
Note:		

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i. The above mentioned ND Test to be done according to individual drawing. ii. X-ray first part sample only (Conditional).		
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**4. DESTRUCTIVE TEST:**

Parameter	Report
Tensile test: One tensile test from separate cast test piece from each charge.  Note: The above mentioned Tensile Test to be done according to individual drawing.	NABL accredited/Gov. approved lab reports

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

- a) 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.
- b) NABL accredited /Gov. approved Chemical composition report.
- c) All dimension check list reports.
- d) Cast test report.

**6. IMPORTANT NOTES:**

- a) Manufacturing Specification: A2003, if applicable.
- b) Inspection and delivery specification: A2017 commercial quality, if applicable.
- c) Sealing and surface decarburization, if applicable.
- d) Test Specification: 0804092, if applicable.
- e) Use rust preventative (W11-217-1) after integration, location specified in drawing; if applicable.
- f) If any 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

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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.

- g) Sample test piece of adequate size need to submit for testing purpose.
- h) All necessary mark/punch/patter should be compliance with drawing, if applicable.

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

- a) A copy of drawing no. GCF-50-40890

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