

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
		Rev No :
		Date of Issue 08/02/2024
C 5089 (CATCH BODY) ✓		OFT/MI/30mm/C5089 ✓
Rev.No	Amendment	Date

MATERIAL : II-OCT 3-4365-79 / 23XГC2MФПУ ТУ АДІ 116-78 ✓
INDIGENOUS MATERIAL : IS: 10343:1999 Gr.19Q with C 0.45% – 0.50% ✓

CONDITION OF SUPPLY : FULL FINISHED THROUGH INVESTMENT CASTING ROUTE ✓

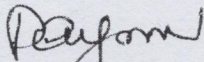
END USE : 30mm CANNON. ✓

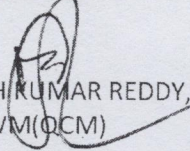
INSPECTION CHECK TO BE CARRIED OUT

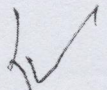
Table 'A'

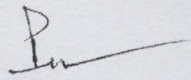
SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The Casting shall be free from defects such as rust, scale, burrs and any other harmful defects.	100%
2.	Dimension	100% Dimension check as per store drawing.	
3.	Chemical Composition (%)	<p>23XГC2MФПУ ТУ АДІ 116-78 ✓</p> <p>C = 0.20-0.24 Mo = 0.25-0.30 Si = 1.80-2.00 V = 0.10-0.15 Mn = 0.50-0.80 S = 0.025(Max) Cr = 0.60-0.90 P = 0.025(Max)</p> <p>IS: 10343,1999 GR.19Q ✓</p> <p>C = 0.45-0.50 (As per drg) ✓ Ni = 0.40 (Max) ✓ Mn = 0.65-0.95 ✓ Mo = 0.10 (Max) ✓ Si = 0.20 - 0.80 ✓ Cu = 0.30 (Max) ✓ Cr = 0.80 – 1.10 ✓ V = 0.15 (Min) ✓ S = 0.045(Max) ✓ P = 0.040(Max) ✓</p> <p>Total Content of the Unspecified Elements = 0.80 (Max) ✓</p> <p>(Permissible variations in value as per specification standard)</p>	One sample per Heat

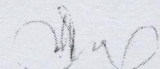
4.	Mechanical Properties	<p>23ХГС2МФПУ ТУ АДИ 116-78</p> <p>UTS = 130 Kgf/mm² (Min) Yield Strength = 110 Kgf/mm² (Min) } (as per drawing) Elongation = 6% (Min) Impact strength = 4 Kgf.m/cm² (Min)</p> <p>IS: 10343-1999 GR.19Q</p> <p>Tensile Strength = 1310 MPa (Min). Yield Strength = 1172 MPa (Min) Elongation = 4% (Min)</p>	One sample Per Heat
5.	Hardness	41.5-51.5 HRC (as per drawing).	100%
6.	Radiographic Test	<p>Radiographic test as per ASTM-E-192, level (i) Gas Hole-3 (ii) Foreign Material-3 (iii) Shrinkages (All Type) – 2 (iv) Defects like cracks, hot tears, cold shuts will not be acceptable.</p> <p>(ii) Radiography using Gamma-ray shall not be permitted at all up to the thickness range of 25mm (Test report to be submitted).</p>	5% per Heat
7.	Other Tests	(i) Decarburization Test : Casting shall be subjected to decarburization test as its maximum thickness region. Depth of decarburization shall not exceed 2% of the thickness (Test report to be submitted).	3% per Heat
		(ii) Magnetic Particle Inspection (MPI) Test to be carried out on a sampling basis, inspection level -III at AQL 0.65 as per IS:2500 Pt.1, 1992.	As per specification
8.	Protective finish	Accelerated electroless phosphating with chromate treatment.	100%
9.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	Each consignment
10.	Marking	<p><u>Details to be marked on the tag</u></p> <p>Sl.No of Tag, Batch No, No of Component in the Batch, Inspection mark of mould check, Inspection mark of Component.</p>	


P.MURUGESAN
HoS/ QCM,
CHECKED BY


M.GIRISH KUMAR REDDY,
WM(QCM)


SUKESH GEHLAUT,
Jt.GM (QCM)
APPROVED


A.PETER FRANCIS XAVIER
HoS/STD.CELL
PREPARED BY

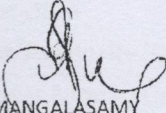

U.MANGALASAMY
AWM

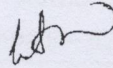
Note:

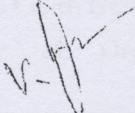
1. The Raw material/component/forging/casting to be tested by the firm on selection of the sample by the firm itself for chemical composition and mechanical properties in NABL accredited approved Lab as per Table 'A'.
2. The Firm has to check for the dimensions, visual defects, packing and marking as per Table 'A'. After completion of tests as per Note-1 as above, the Firm has to submit the following documents to OFT.
 - I. The Raw material certificate from the original manufacturer, Heat number, and quantity purchased and number of bars is to be mentioned in the inspection letter to OFT.
 - II. The Chemical and Mechanical test certificates from NABL accredited approved lab as per Table 'A'.
 - III. **Raw material sample minimum of 300mm should be supplied for cross verification along with the first supply of stores.**
 - IV. Dimensional reports including visual as per Table 'A'.
 - V. Guarantee / Warrantee certificate of supplier against the supply.
3. All the above Documents mentioned at Note No.2 above are to be forwarded to GM/OFT along with supply.
4. OFT shall verify all the documents as above and accord clearance to the firm for dispatch of the material to OFT if all documents are in order.
5. OFT/Trichy shall verify all the parameters as per Table 'A' and after satisfactory results, the material will be accepted /cleared accordingly.
6. Material has to be replaced 100% by the firm in case of non-conformity to specification as per Table-A, during inspection at OFT, Trichy.

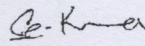
VERIFICATION OF INSPECTION DOCUMENTS

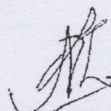
SL_NO	INSPECTION DOCUMENTS
1	The Raw material original Manufacturer's certificate, Details of Heat Number, Quantity purchased and number of Bars etc.,
2	The Chemical and Mechanical test certificates from NABL accredited approved Lab.
3	Dimension report including visual.
4	Packing slip details.

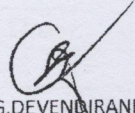

U.MANGALASAMY
HOS/STD.CELL
CHECKED


L.S. ASHA
HOS / QCM
CHECKED


V.RAVEENDAR
JWM/STD.CELL
PREPARED


S. KRISHNA SWAMY
JT.GM (QC and R&D)


A.K SINGH
AGM / (WP & MAINT)
APPROVED


G.DEVENIRANE
AWM (QCM & HT)