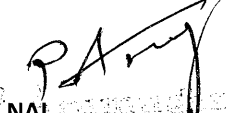



**PIN ASSEMBLY TRIGGER BAR (7313106)**

<b><u>SL.NO</u></b>	<b><u>PART NO.</u></b>	<b><u>ASSY/COMPONENT</u></b>	<b><u>NOMENCLATURE</u></b>	<b><u>PAGE</u></b>
1	7313104	COMPONENT	BODY, TRIGGER BAR PIN	188
2	7313105	COMPONENT	LOCK, TRIGGER BAR PIN	189

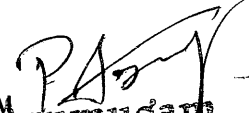
QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00 Date of Issue / / 2021
Drg . No.	7313106								QAP No: OFT/QAP/M2HB/7313106
Nomenclature	PIN ASSEMBLY, TRIGGER BAR, OOW50BMG. REQD.FOR HB ASSEMBLY( 7265636)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
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
Pin Assembly, Trigger Bar (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	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 7313106 & Components		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313106 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313106 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313106 & Components		Firm Inspection report	W	
<p>*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.</p>									


  
 NAI  
 Civilian Technical Officer (Mech)  
 In-charge Principal Inspector Of Naval Armament  
 Tiruchirappalli.

  
 OFT  
**G. DEVENDIRANE, I.O.F.S.**  
**ASST WORKS MANAGER**  
**GOVT. OF INDIA, MIN. OF DEFENCE**  
**ORDNANCE FACTORY**  
**TIRUCHIRAPPALLI, TAMILNADU**


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313104								QAP No: OFT/QAP/M2HB/7313106
Nomenclature	BODY, TRIGGER BAR, PIN, OOW50BMG.								
Material	STEEL, ASTM A108; 1022, 1018 OR ASTM A576; 1022, 1018								
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
Body, Trigger Bar, Pin (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A108; 1022, 1018 OR ASTM A576; 1022, 1018		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	CARBURIZE AT 857°C TO 871°C. TO CASE DEPTH 0.203 TO 0.305. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 86-89)		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313104		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313104		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. Arumugam**  
 Chief Technical Officer (Mech)  
 Inspector Of Naval Armament  
 Tiruchirappalli.

  
**G. DEVENDIRANE, I.O.F.S.**  
 ASST WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI-TAMIL NADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313105								QAP No: OFT/QAP/M2HB/7313106
Nomenclature	LOCK, TRIGGER BAR, PIN, OOW50BMG.								
Material	STEEL 1060-1095 PER ASTM A576 OR ASTM A510 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.								
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
Lock, Trigger Bar, Pin (Raw material)	General appearance	Non Critical	Visual	100%	STEEL 1060-1095 PER ASTM A576 OR ASTM A510 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	HEAT AT 787°C TO 816°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 83-85.5)		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313105		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313105		Firm Inspection report	W	
<p><b>(*) Note :</b> 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 &amp; 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>									

  
**P. Arunugan**  
 Civilian Technical Officer (Mech)  
 for Principal Inspector Of Naval Armament  
 Tiruchirappalli.

  
**S. DEVENDRAN**  
 ASST. WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI