

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6009728								QAP No: OFT/QAP/M2HB/6009728
Nomenclature	SHANK BARREL EXTENSION ASSEMBLY , HB , OOW50BMG. REQD FOR BARREL EXTENSION ASSEMBLY (5504082)								
Material	STEEL, ASTM A331 OR A322; 4340, 4140, 6150.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI or their authorised Rep. (Review/Witness) (*)	Remarks
Shank, Barrel Extension. (Raw material)	General appearance	Critical	Visual	100%	STEEL, ASTM A331 OR A322; 4340, 4140, 6150.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%	As per Drawing 6009728	AUSTENITIZE, QUENCH AND DOUBLE TEMPER ( 2HOURS +1 HOUR) PER AMS 2759. MINIMUM TEMPERING TEMPERATURE 204°C TO HRC 52-58. LOCALLY INDUCTION TEMPER 4.82 RADIUS ZONE TO HRC 32 MINIMUM (TO PRODUCE A MACHINABLE CONDITION). DUE TO THE NATURE OF THE INDUCTION HEATING PROCESS, TEMPERED ZONE RADIUS IS APPROXIMATE MAXIMUM.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
In process -As per Drawing 6009728	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 6009728		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 6009728		Firm Inspection report	W	

(\* ) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) & (iii) the following is applicable.  
(ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.  
(iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.

*Patry*  
NAI  
Civilian Technical Officer  
of Material Inspection & Control  
Tiruchirappalli

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