

**QUALITY ASSURANCE PLAN  
RIFLE 5.56mm INSAS 1B1  
(METALLIC COMPONENTS)**

|   |                                                                                                         |                                                                                                                                         |                                     |                    |
|---|---------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|--------------------|
| 1 | NOMENCLATURE                                                                                            | PISTON EXTENSION (FORGING)                                                                                                              |                                     |                    |
| 2 | DRG. NO./ D. S. CAT NO.                                                                                 | RFI SK.6422*2-S                                                                                                                         |                                     |                    |
| 3 | MATERIAL SPECIFICATION                                                                                  | IS:4432-1988, DESIGNATION 13NI13CR3                                                                                                     |                                     |                    |
| 4 | CHEMICAL COMPOSITION                                                                                    | AS PER SPECIFICATION/DRAWING                                                                                                            |                                     |                    |
| 5 | PHYSICAL PROPERTIES                                                                                     | AS PER SPECIFICATION/DRAWING                                                                                                            |                                     |                    |
| 6 | DOCUMENT VERIFICATION                                                                                   | A) SUPPLY ORDER                                                                                                                         | F) CRACK DETECTION CERTIFICATE      |                    |
|   |                                                                                                         | B) MIS                                                                                                                                  | G) RADIOGRAPHIC TEST CERTIFICATE    |                    |
|   |                                                                                                         | C) BATCH NO./HEAT NO.                                                                                                                   | H) DECARBURISATION TEST CERTIFICATE |                    |
|   |                                                                                                         | D) CHEMICAL TEST CERTIFICATE                                                                                                            | I) PRE-INSPECTION REPORT            |                    |
|   |                                                                                                         | E) MECHANICAL TEST CERTIFICATE                                                                                                          | J) BATCH SIZE                       |                    |
| 7 | <b>VISUAL CHECKING:</b><br>SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-IV & AQL-1.5 IS:2500(PT.1):2000. | 1. COMPONENT SHOULD BE FREE FROM CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES, SHARP EDGES & BURRS, ETC.<br>2. MARKINGS :- AS PER DRAWING. |                                     |                    |
| 8 | DIMENSIONAL CHECKING, SAMPLE SIZE AS PER SPECIAL INSPECTION LEVEL S-4 OF IS:2500 (PT-1):2000.           | SL. NO                                                                                                                                  | AUDIT POINTS/ DIMENSIONS            | GAUGE NO. / METHOD |
|   |                                                                                                         | 1.                                                                                                                                      | Dimn. 37                            | GE METHOD/GAUGE    |
|   |                                                                                                         | 2.                                                                                                                                      | Dimn. 23.5                          | GE METHOD/GAUGE    |
|   |                                                                                                         | 3.                                                                                                                                      | Dimn. 10.5                          | GE METHOD/GAUGE    |
|   |                                                                                                         | 4.                                                                                                                                      | Dimn. 11.5                          | GE METHOD/GAUGE    |
|   |                                                                                                         | 5.                                                                                                                                      | Dimn. 20.5                          | GE METHOD/GAUGE    |
|   |                                                                                                         | 6.                                                                                                                                      | Dimn. 42                            | GE METHOD/GAUGE    |
|   |                                                                                                         | 7.                                                                                                                                      | Dimn. 55                            | GE METHOD/GAUGE    |
|   |                                                                                                         | 8.                                                                                                                                      | Dimn. 34                            | GE METHOD/GAUGE    |
|   |                                                                                                         | 9.                                                                                                                                      | Dimn. 200                           | GE METHOD/GAUGE    |
|   |                                                                                                         | 10.                                                                                                                                     | Dimn. Ø20                           | GE METHOD/GAUGE    |