

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5009373								
Nomenclature	CAM, EXTRACTOR, OOW50BMG : REQD. FOR RECEIVER ASSEMBLY (6535480)								
Material	ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 4340,4140; ALLOY STEEL BARS, COLD FINISHED, ASTM A108, GRADES 4340, 4140. ALT: ALLOY STEEL, BARS, HOT WROUGHT, ASTM A322, GRADES 4340, 4140; ALLOY STEEL, PLATES, ASTM A829, GRADES 4340, 4140; ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6359 (GRADE 4340); ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6395 (GRADE 4140).								
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
Cam, Extractor (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 4340,4140; ALLOY STEEL BARS, COLD FINISHED, ASTM A108, GRADES 4340, 4140. ALT: ALLOY STEEL, BARS, HOT WROUGHT, ASTM A322, GRADES 4340, 4140; ALLOY STEEL, PLATES, ASTM A829, GRADES 4340, 4140; ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6359 (GRADE 4340); ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6395 (GRADE 4140).	Firm Inspection report	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%				R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%				R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	AUSTENITIZE, QUENCH AND TEMPER IAW AMS 2759, TEMPER TO ROCKWELL HARDNESS A76-79.5.	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 5009373	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5009373	Firm Inspection report		R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5009373	Firm Inspection report		W	
<p>(*) 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 <u>out sourced</u> 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>									

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