

RESTRICTED



Gun Carriage Factory
A Unit of Ordnance Factory Board,
Government of India, Ministry of Defence,
Jabalpur (MP) 482011



Prepared and published by

QUALITY ASSURANCE PLAN OF
PACKING PERFORMED,
DS CAT NO. 5330-382978

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This quality plan is a general guide to meet the quality requirements of product. It consists of applicable procedures (describing production processes, inspection & testing instructions), applicable workmanship standards, the measurement tolerances acceptable, the description of material standards and so forth. It also mentions the list of documents, test certificates that will be submitted by firm to GCF along with finished component.

1. Nomenclature & Drawing No. – PACKING PERFORMED, 5330-382978

2. Material & Condition : As per Standard given in drawing.

2.1 Test/Checks and Acceptance criteria for Material.

Sr.	TEST/CHECK	TYPE/APPLICATION REQUIREMENT	PARAMETER	ACCEPTANCE	
1	Functioning parameters	LOW PRESSURE TYPE OR MEDIUM PRESSURE OR HIGH PRESSURE	STATIONARY OR MOVABLE	Grooves, shapes	As per Standard
				Degree of surface smoothness	As per Standard
				Grip	As per Standard
				Maximum working pressure	As per Standard
				Diameters of C/S of o-ring	As per Standard
				Care for damage against EDGES/HOLES/THREAD ETC.	As per Standard
				Bright/scratches & damage free.	As per Standard

Note – The entire material required for manufacture of the store shall be procured as far as possible in bulk to meet the entire quantity. These materials shall be initially tested for functioning parameters and other working condition required before undertaking of manufacture of component.

2.2 Manufacturer to supply one test piece along with bulk supply. (Factory may check chemical and mechanical properties whenever required)

3. Method of manufacture * : Machining & other operations as per process. During and after machining, all dimensions and surface finish should be maintained as per specified drawing.

4.0 Inspection: Following methodology is to be followed for inspection.

4.1 Mode of Inspection & Sample Size/Selection:

(a) At Firm Premises: Inspection by the manufacturer for 100% quantities of lot size.

(b) At receipt End: Inspection by MID/QC (GCF Rep.) at receipt at GCF. Sample selection as per existing IS

standard 2500 part-II, 1965.

4.2 Visual Inspection

S.NO.	DETAILS OF FEATURE	ACCEPTANCE CRITERIA
A	Scratches	Not allowed
B	Complete surface of the rubber component	As per drawing

4.3 Dimensional Inspection: all dimensions (critical, major & minor in nature) & geometrical features of drawings are to be covered in check sheet and should be duly inspected by concerned quality control section. Components, having dimensions as per drawing, should only be accepted by inspectorate. No deviation in dimension or in geometrical feature is permitted.

5. Other Test on Semi-finished/finished Component.

5.1 Details of tests /check on Semi-finished/ finished items and acceptance criteria:

S No.	TEST / CHECK	SAMPLE SIZE	ACCEPTANCE CRITERIA
A	Working pressure/ Shaping, placing, surface smoothness of grooves respectively	100%	As per Standard.

6. List of Documents:

(To be submitted by firm along with finished component during factory end inspection)

(1) Dimensional Acceptance I-note checked by QC (Firm) with check-sheet as per Para 4.3. (Sample-100%)

(2) NABL/Govt. approved Lab certificate required for material that includes all the test observations.

7. Important Note:

Final authority of acceptance is based on the Fit for Trial (FFT) report.

Date:-08/07/2020

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08/07/2020

Approved By
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(QC Section)

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