

<b>QUALITY MONITORING INSTRUCTION FOR INSPECTION</b>		Issue No : 01
		Rev No :
		Date of Issue 18/08/2021
44P 10000*2 (20mm MAGAZINE ASSY)		OFT/MI/AMR/44P 10000
Rev.No	Amendment	Date

**MATERIAL SPECIFICATION :**

SL NO	ASSEMBLY AND SUB ASSEMBLY	COMPONENT	MATERIAL	
1	44P 16000*2 (14.5mm MAGAZINE ASSY)	44P 10001*2, 20mm Magazine Spring	IS:4454 Pt.1,2001 Gr 'DH'.	
2		44P 10204*2, Floor Plate	IS:6911-1992, Gr.420 S2.	
3		44P 10100*2 (20mm Magazine Welded Assy)	44P 10101*2, 20mm Side Plate L.H.	BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
4			44P 10102*2, 20mm Side Plate R.H.	BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
5			44P 10103*2, 20mm Rim Guides L.H & R.H.	BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
6			44P 10105*2, 20mm Feed Ramp.	BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
7			44P 10106*2, 20mm Back Plate	BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
8			44P 10200*2 (20mm Follower Weld Assy)	44P 10201*2, 20mm Follower Guide L.H
9		44P 10202*2, 20mm Follower Guide R.H		BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.
10		44P 10203*2, 20mm Follower.		BS:1449 Pt.1, 1983 CS40 (or) CS50 Sec.4 (or) IS:2507-1975, Gr.1 Design. 45C8 (or) 55C6.

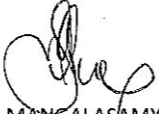
CONDITION OF SUPPLY : FULLY FINISHED WITH FIRM'S MATERIAL  
 END USE : 14.5/20mm AMR

**INSPECTION CHECK TO BE CARRIED OUT**


Table 'A'

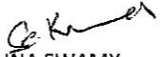
SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The component shall be free from defects such as rust, scale, burrs and any other harmful defects. Welding Should Have Uniform thickness and must be free from defects viz., blowholes, cracks etc.,	100%
2.	Dimension	100% Dimensional Check as per drawing.	
3.	Chemical Composition	As per Material Specification against the Drawing including <b>Trace Elements.</b>	One Sample per Heat.
4.	Mechanical Properties	As per material Specification against the Drawing.	

5.	Other Tests	Macro Test, NMIR (Wherever applicable) , Salt Spray Test (for phosphated components) as per Specification Standard. Bend Test , Decarburization test as per specification standard for Sheet materials.	One Sample per Heat.
6.	Hardness	As per Drawing.	100%
7.	Protective Finish	As per Drawing.	
8.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	Each Consignment.
9.	Marking	Each Packing shall be legibly marked with manufacturer's identity , Qty, Heat No, OFT Supply order No etc.,	

  
U.MANGALASHAMY  
HOS/STD.CELL  
CHECKED

  
L.S. ASHA  
HOS / QCM  
CHECKED

  
V.RAVEENDAR  
JWM/STD.CELL  
PREPARED

  
S. KRISHNA SWAMY  
JT.GM (QC and R&D)

  
A.K SINGH  
AGM / (WP & MAINT)  
APPROVED


  
G.DEVENDHIRANE  
AWM (QCM & HT)

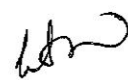
**Note:**

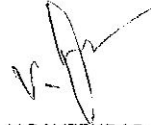
1. The Raw material/component/forging/casting to be tested by the firm on selection of the sample by the firm itself for chemical composition and mechanical properties in NABL accredited approved Lab as per Table 'A'.
2. The Firm has to check for the dimensions, visual defects, packing and marking as per Table 'A'. After completion of tests as per Note-1 as above, the Firm has to submit the following documents to OFT.
  - I. The Raw material certificate from the original manufacturer, Heat number, and quantity purchased and number of bars is to be mentioned in the inspection letter to OFT.
  - II. The Chemical and Mechanical test certificates from NABL accredited approved lab as per Table 'A'.
  - III. **Raw material sample minimum of 300mm should be supplied for cross verification along with the first supply of stores.**
  - IV. Dimensional reports including visual as per Table 'A'.
  - V. Guarantee / Warrantee certificate of supplier against the supply.
3. All the above Documents mentioned at Note No.2 above are to be forwarded to GM/OFT along with supply.
4. OFT shall verify all the documents as above and accord clearance to the firm for dispatch of the material to OFT if all documents are in order.
5. OFT/Trichy shall verify all the parameters as per Table 'A' and after satisfactory results, the material will be accepted /cleared accordingly.
6. Material has to be replaced 100% by the firm in case of non-conformity to specification as per Table-A, during inspection at OFT, Trichy.

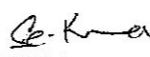
**VERIFICATION OF INSPECTION DOCUMENTS**

SL_NO	INSPECTION DOCUMENTS
1	The Raw material original Manufacturer's certificate, Details of Heat Number, Quantity purchased and number of Bars etc.,
2	The Chemical and Mechanical test certificates from NABL accredited approved Lab.
3	Dimension report including visual.
4	Packing slip details.

  
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