



PIN ASSEMBLY BREECH LOCK (6008784)

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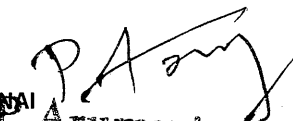
QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6008784								QAP No: OFT/QAP/M2HB/6008784
Nomenclature	PIN ASSEMBLY BREECH LOCK , OOW50BMG. REQD FOR HB ASSEMBLY (7265636)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Pin Assembly Breech Lock (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 6008784 & Components		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 6008784 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 6008784 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 6008784 & Components		Firm Inspection report	W	
<p>*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable. (ii) In case of hard ware items, NAI, Trichy will review the reports, if required.</p>									



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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
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Drg . No.	5009274								QAP No: OFT/QAP/M2HB/5009274
Nomenclature	PIN, BREECH LOCK, OOW50BMG : REQD FOR PIN ASSEMBLY BREECH LOCK (6008784)								
Material	STEEL, ASTM A576; 1095, 1070, 1080 OR STEEL, ASTM A686: CLASS W 1-8 THRU 10, GRADE 'C'. ALT: AISI 4140.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Pin, Breech Lock (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A576; 1095, 1070, 1080 OR STEEL, ASTM A686: CLASS W 1-8 THRU 10, GRADE 'C'. ALT: AISI 4140.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	HEAT AT 787°C TO 816°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 81.5-84.5)		Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171	Finish 5.3.1.2 (or) 5.3.2.2	Test report from NABL lab	R	
In process -As per Drawing 5009274	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5009274		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5009274		Firm Inspection report	W	


*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.


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QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5009357								GAP No: OFT/QAP/M2HB/5009357
Nomenclature	SPRING,RETAINING, OOW50BMG : REQD FOR PIN ASSEMBLY BREECH LOCK (6008784)								
Material	WIRE, STEEL ASTM A228.								
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
Spring Retaining (Raw material)	General appearance	Non Critical	Visual	100%	WIRE, STEEL ASTM A228.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 5009357	STRESS RELIEVE AT 224°C ± 5°C FOR 30 MINUTES AFTER FORMING.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual	100%	MIL-STD-171	FINISH 5.3.1.2 (or) 5.3.2.2		R	
In process -As per Drawing 5009357	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5009357		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5009357		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 out sourced 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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