

RESTRICTED COPY
Project code-LG
QAP NO.GCF/SC/LG/2023-24 DATE-04/05/2023

QUALITY ASSURANCE PLAN
OF
BOX
DESIGN NO. ILG-TA-039, PART NO. ICM 320A &
D S CAT NO. 8115-002944

Prepared and published by



Gun Carriage Factory
A Unit of Advanced weapon and equipment India
Limited
Government of India, Ministry of Defence,
Jabalpur (MP) 482011



QAP

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. Drawing No. & Nomenclature: DESIGN NO. ILG-TA-039, PART NO. ICM 320A,
D S CAT NO. 8115-002944 & BOX

2. Material & Condition: As per Standard given in drawings and given in table-1.

TABLE-1

QTY No.	NOMENCLATURE	MATERIAL & SIZE	No. OFF	PART NO.
1	BODY	ILG-TA-039 SHT 2	1	IWP 2090
2	LID	ILG-TA-039 SHT 3	1	IWP 2091
3	SIDE	ILG-TA-039 SHT 4	2	IWP 2092
4	PARTITION PLATE	CQA / WPN / 1770	1	IWP 2098
5	HINGE PLATE	ILG-TA-039 SHT 5	2	IWP 2095
6	HASP	DET. No. J OF 8140-000310 SHT 2	2	
7	PLATE	ILG-TA-039 SHT 8	2	IWP 2096
8	SUPPORT FRONT	ILG-TA-039 SHT 12	4	IWP 2099
9	PIN	IS: 5517-40-C8 (1978) $\phi 8 \times 40 L$	2	
10	STRIP	CQA / WPN / 1769	1	IWP 2087
11	EYE	DET. No. M OF 8140-000310 SHT 2	2	
12	RIVET SOLID SNAP HD. STEEL	IS: 2158 $\phi 6 \times 20 L$	2	
13	WASHER	IS: 5517-40-C8 (1978) $\phi 14 \times 6 \times 6 \times 6$	2	
14	FELT LOWER	SPEC. No. IS: 1719 SOFT No. 2 $61 \times 341 \times 10$	1	
15	HANDLE CLIP	CQA / WPN / 1771	4	IWP 2089
16	HANDLE	CQA / WPN / 1765	2	ICM 2251
17	FELT UPPER	SPEC. No. IS: 1719 SOFT No. 2 $61 \times 341 \times 10$	1	
18	HINGE PT. II	ILG-TA-039 SHT 7	2	IWP 2094
19	PIN	IS: 5517-40-C8 (1978) $\phi 6 \times 120 L$	2	
20	HINGE PT. I	ILG-TA-039 SHT 6	2	IWP 2095
21	SUPPORT REAR	ILG-TA-039 SHT 11	2	IWP 2098
22	STIFFNER	ILG-TA-039 SHT 10	4	IWP 2097

2.1 Test/Checks and Acceptance criteria for Material.

SL.NO	TEST/CHECK	PARAMETER	ACCEPTANCE
1	Chemical	composition	As per Standard
2	Mechanical properties	Tensile Strength	As per Standard
		Yield Stress	As per Standard
		% Elongation	As per Standard
		Hardness	As per Standard
		Izod Min. (Impact Test)	As per Standard

Note – The entire raw 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 chemical composition and mechanical properties before undertaking of manufacture of component.

NOTES :

(1) WELDING CONVENTIONS CONFORM TO SPEC IS:813-1961

(2) BOX TO BE PAINTED OLIVE GREEN TO SPEC WPN/GEN/2 PARA 10(F)

(3) FELT AVAILABLE IN ANY COLOUR TO BE PASTED WITH DUNLOP ADHESIVE S-758 OR FEVICOL SR-998

(4) BOX TO BE STENCILLED/ STAMPED

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

3. Method of manufacturing: Machining & other operations will be 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	All Sharp Edges & Burrs	If applicable, to be rounded off/chamfered and burrs to be removed.
B	Chattering Marks on Thread	Not allowed on thread.
C	Tool Marks and Scratches	Not allowed.
D	Complete surface of the machined component should be free from rust/pit marks	Rust /pit marks not allowed.

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	Hardness Test (In process Inspection)	100%	If applicable, Hardness Within Specified hardness Range 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) Heat treatment I-note as per 5.1 SL. No (A) (B) and(C), if applicable.


(3) NABL/Govt. approved Lab certificate required for material that includes chemical composition and mechanical properties (tensile strength, Yield strength, Elongation, impact strength as per Izod & Hardness).

7. Important Note:

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

Date: -04/05/2023

for
Prepared by
JWM/SC
04/05/2023

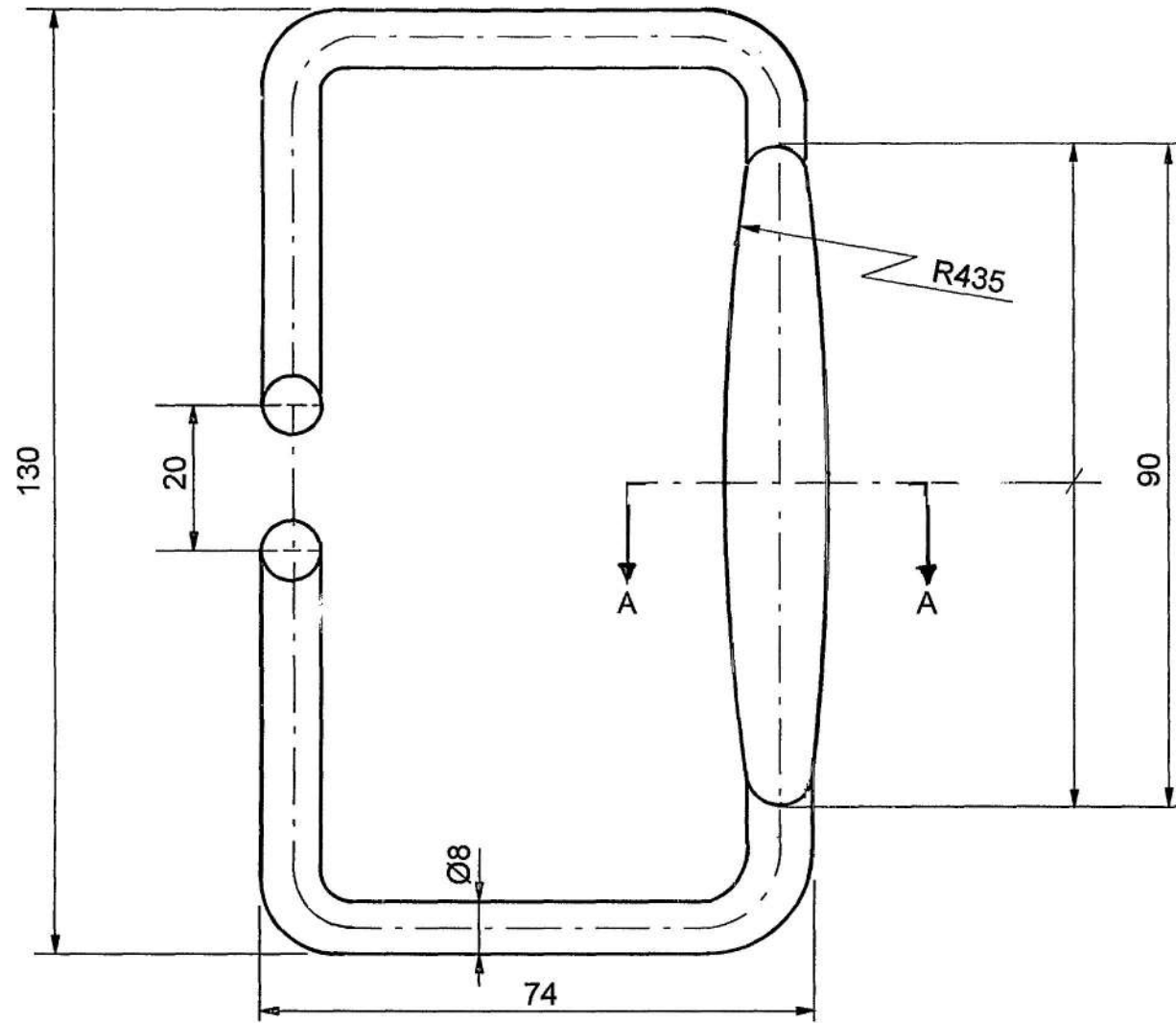
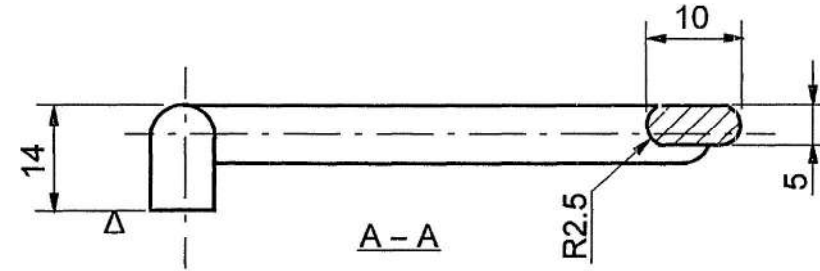


APPROVED BY
Quality Controlling Officer

8 7 6 5 4 3 2 1

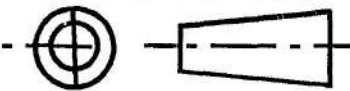
PART No **ICM 2231**
 DRG CONVENTIONS CONFORM TO IS 696
 DIMENSIONS ARE IN mm
 TOLS FOR UNTOLERANCED LINEAR DIMNS. IS: 2102 (MED. CL)

NOTE - UNTOLERANCED SHAFT -0.2



BASED ON ILG-TA-039 SHT 5

~ (▽)

			DRAWN:-		CHD:-	ASSY DRG:- ICM 320 A	CQA(W), JABALPUR
			SCANNED:- PKA		CHD:- GSN	DATE:-	
09-2-17	19574-W		MATL AMENDED			AHSP	
16-7-14			SCANNED & PRINTED WITHOUT CHANGE			SCALE:- 1:1	
DATE	AUTHORITY	ZONE	AMENDMENTS	SIG AHSP	SIG. DO	MATERIAL:- IS: 2004 - 1991 GRADE 45 CB (CLASS 4)	DESIGN No. CQA/WPN/1768
PREV DC Nos:- 18538-W, 18020-W & 18844-W DT 03-01-04						PROTECTIVE FINISH:-	PART No. ICM 2231
DRG SEALED:- 18844-W DT 03-01-04						<u>HANDLE</u>	DS CAT No.
				DO CQA(W)			

PART No.

IWP 2087

DRG CONVENTIONS CONFORM TO IS : 696

DIMENSIONS ARE IN mm

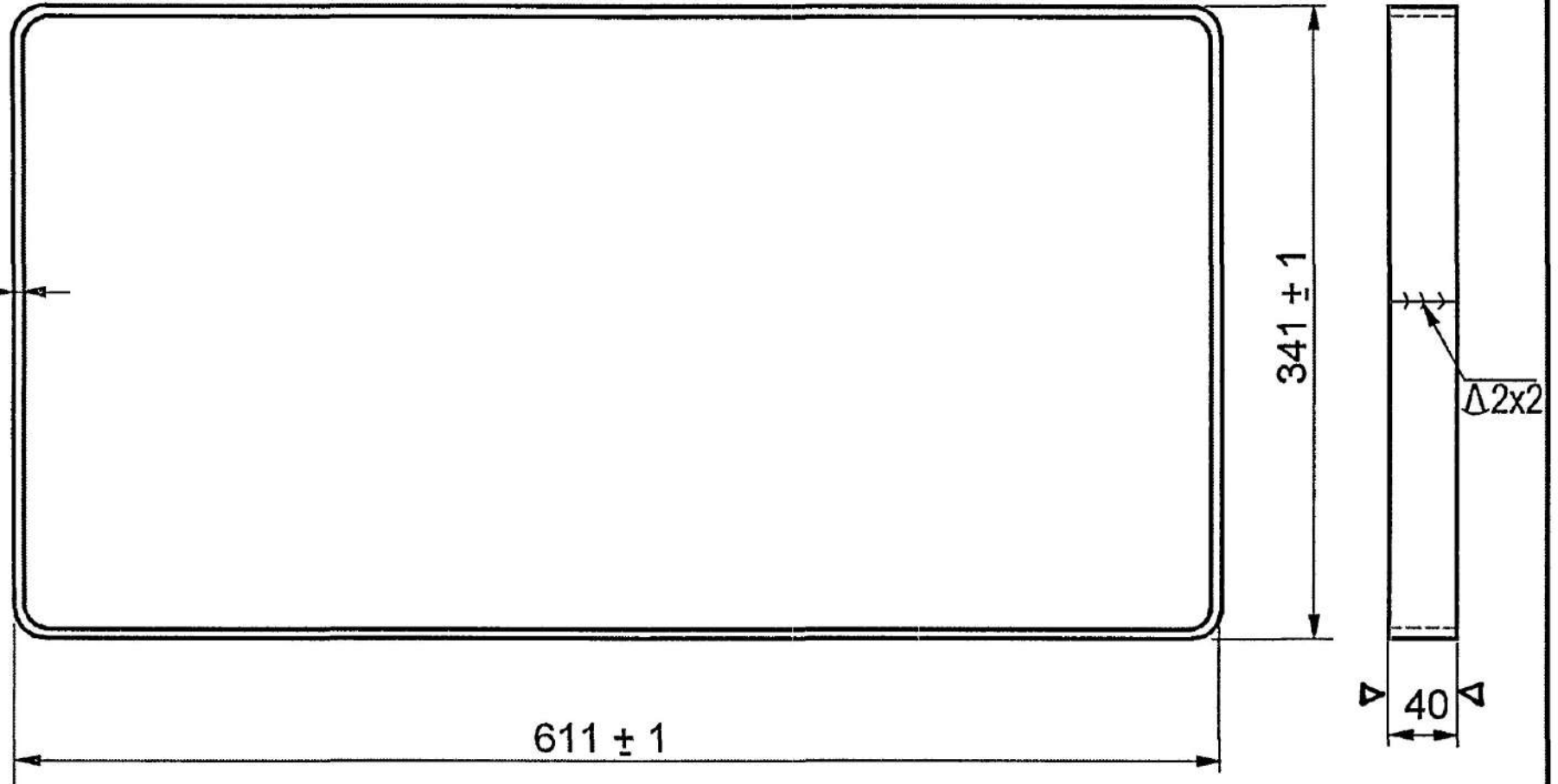
TOLS FOR UNTOLERANCED LINEAR DIMNS IS:2102 (MED CL)

D

C

B

A



MATERIAL :- IS :5986-2011 GRADE 205

OR

IS :513 -2008 GRADE CR2 ANNEALED

NOTE :- WELDING CONVENTIONS CONFORM TO IS : 813-1961

BASED ON ILG-TA-039 SHT 5

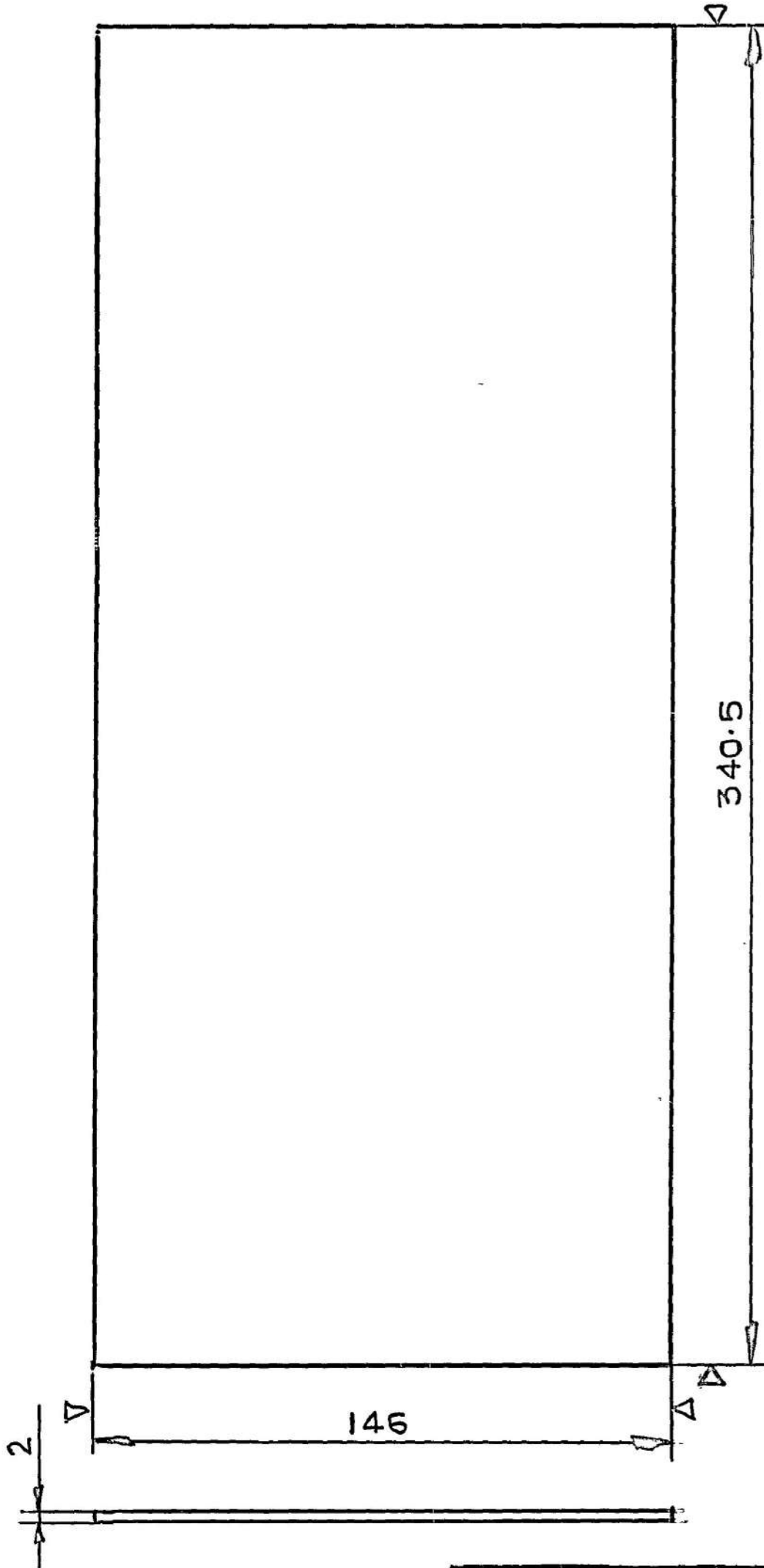
~(V)

					CQA(W), JABALPUR	
09-2-17	19574-W		MATERIAL AMENDED			DRN:-
24-5-17			SCANNED & PRINTED WITHOUT CHANGE			CHD:-
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO	CHD:- <i>Shikhar</i>
PREV DC Nos:-18020-W & 18844-W DT 03-01-04						AHSP
DRG SEALED:-18844-W DT 03-01-04						HOS
SCALE :- NTS, 1:5					ESTD mass	DATE :-
MATERIAL :- AS ABOVE					FOR CQAW	
PROT FINISH :-					ASSY DRG. ICM 320 A	
<u>STRIP</u>					DESIGN No. CQA/WPN/1769	
					PART No IWP 2087	
					DS CAT No.	

PART No.
IWP-2088

DRG CONVENTIONS CONFORM TO IS: 696
DIMNS ARE IN mm
TOLS FOR UNTOLERANCED LINEAR DIMNS IS: 2102 (MED. CL)

MATL:- IS: 5986-2011 GRADE 205
OR
IS: 513-2008 GRADE CR2
ANNEALED



DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. DO
16-11-16	1954-3-W		MATL AMENDED		
03-01-04	18844-W		PROV. SEALING CANCELLED & DRG. SEALED		
23-8-94	18020-W		DRG. SEALED PROV.		
			NEW POLY NEG. PREPARED		

AMENDMENTS

BASED ON ILG-TA-039 SHT 5

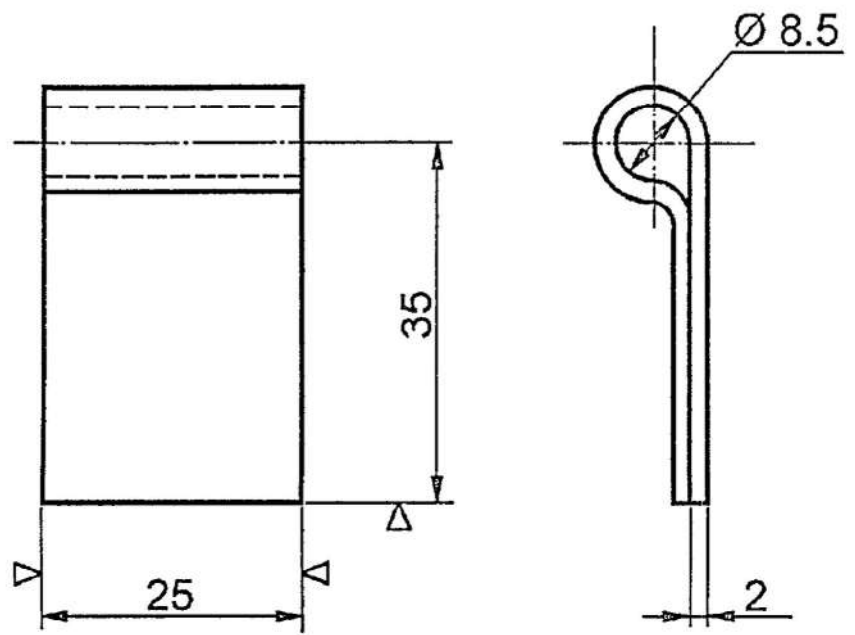
<p><i>Poojit Sevilal</i> CHIEF D'MAN</p> <p><i>[Signature]</i> DO</p> <p>AHSP <i>[Signature]</i></p> <p>FOR CQA W</p> <p>DRG SEALED:- 18844-W 03-01-04 <i>[Signature]</i> DO CQA W</p>	<p>ASSY DRG: ICM 320 A</p> <p>ESTD MASS:-</p> <p>DATE:-</p> <p>SCALE:- 1:2</p> <p>DRN:- A S JHA</p> <p>CHD:- M R R</p>	<p>C Q A(W) JABALPUR</p> <p></p> <p>DESIGN No. CQA/WPN/1770</p> <p>PART No. IWP-2088</p> <p>D S CAT No.</p>
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PARTITION PLATE

SKT TRACED
[Signature]
CHECKED

4	3	2	1
PART No. IWP 2089		DRG CONVENTIONS CONFORM TO IS : 696 DIMENSIONS ARE IN mm TOLS FOR UNTOLERANCED LINEAR DIMNS IS:2102 (MED CL)	

D
C
B
A



MATL :-
IS : 5986 - 2011 GRADE 205
 OR
IS : 513 - 2008 GRADE CR 2 ANNEALED
NOTE :- UNTOLERANCED HOLE + 0.2 mm

BASED ON ILG - TA - 039 SHT 5

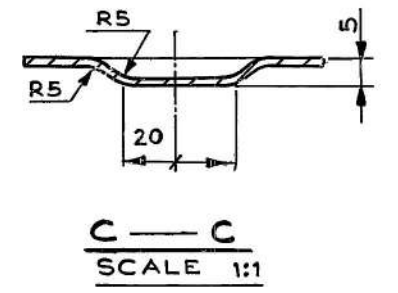
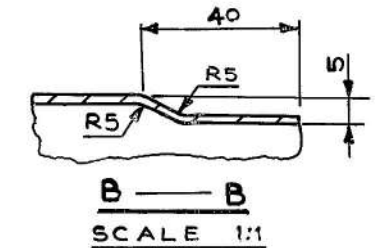
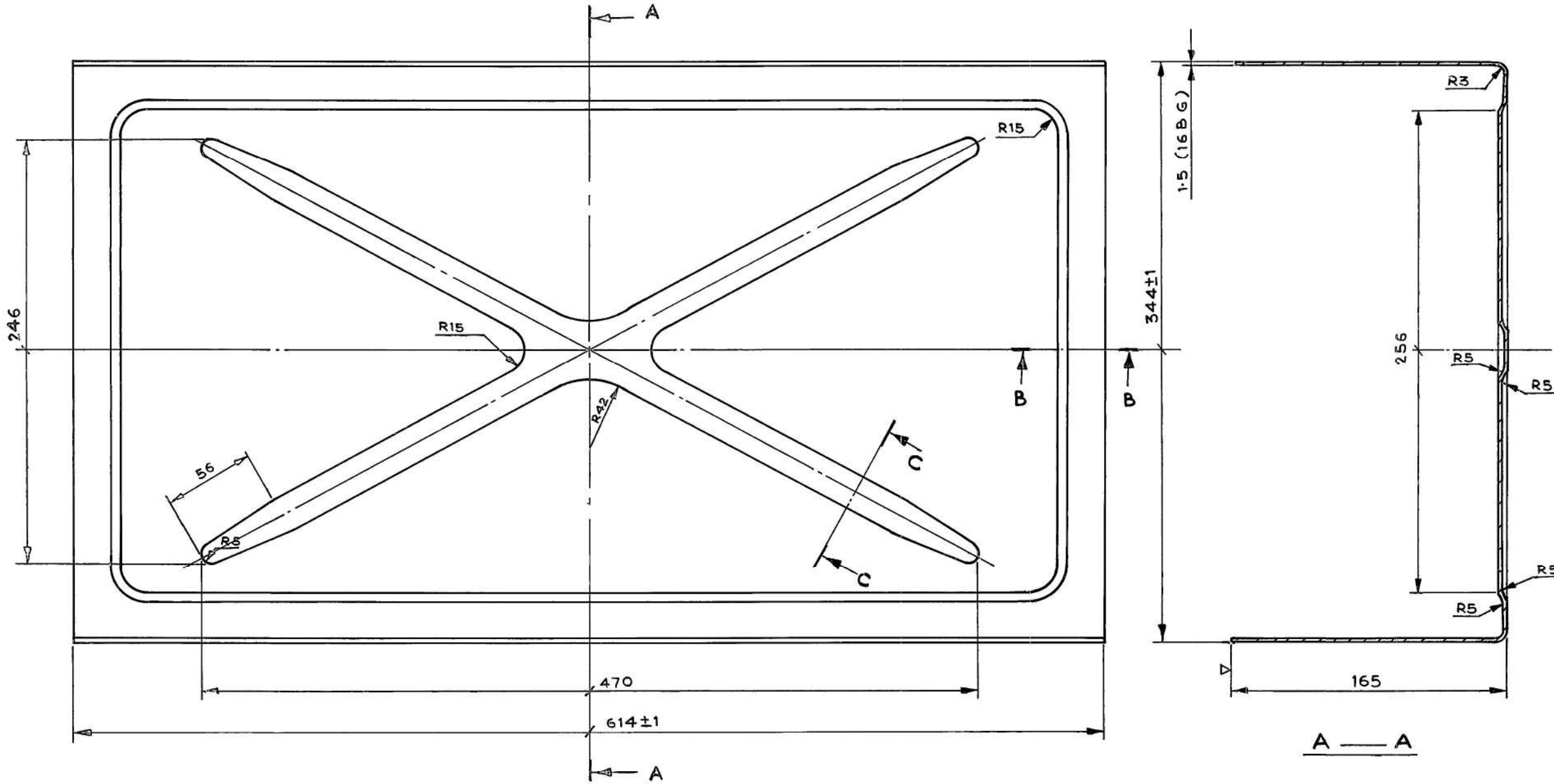
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						CQA(W), JABALPUR	
16-11-16	19543-W	MATERIAL AMENDED				DRN:-	CHD:-
10-11-16		SCANNED & PRINTED WITHOUT CHANGE				SCANNED :-PKA	CHD:- <i>R. Ghosh</i>
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO.	<i>6079476</i>	AHSP
PREV DC Nos:-18020-W,18538-W & 18844-W DT 03-01-04						JTO (D)	FOR CQAW
DRG SEALED:-18844-W DT 03-01-04						ASSY DRG.	
						ICM 320 A	
SCALE :-1 : 1		ESTD mass		DATE :-		DESIGN No.	
MATERIAL :- AS ABOVE						CQA/WPN/1771	
PROT FINISH :-						PART No.	
<u>HANDLE CLIP</u>						IWP 2089	
						DS CAT No.	

PART No.
IWP-2090

DRG CONVENTIONS CONFORM TO IS:696
DIMNS ARE IN mm UNLESS OTHERWISE STATED

TOLERANCES FOR UNTOLERANCED LINEAR DIMNS								
ABOVE	6	30	120	315	1000	2000	4000	
UP TO	6	30	120	315	1000	2000	4000	—
TOLS	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3



MATERIAL:-
IS: 5586 - 2011 GRADE 205
OR
IS: 513 - 2008 GRADE CR2 ANNEALED

8.7.94	30467- CQAW-QA-4	ASSY DRG No. AMENDED.		14/11/94	9-2-17	19574-W	MATL AMENDED	
18/94	30467- CQAW- QA-4	PART No. AMENDED.		14/11/94	03-01-04	18844-W	PROV. SEALING CANCELLED & DRG. SEALED.	
30.9.93	30467- CQAW-QA4	PART No. ADDED		14/11/94	23-8-94	18020-W	DRG. SEALED PROV.	
29.12.92	30823- CQAW-W4	MATL AMENDED.		14/11/94				
2-1-90		NEW POLY. NEG. PREPARED						
DATE	AUTHORITY	ZONE	NATURE	SIG	ANSP	SIG	DO	C/D'MAN
AMENDMENTS				MATERIAL:- AS ABOVE				
DRG SEALED:- 18844-W 03-01-04				PROTECTIVE FINISH:-				

BODY

ASSY DRG:- ICM 320A
DATE :- 11-5-89
SCALE:- 1:2 (1:1)
ESTD MASS:-

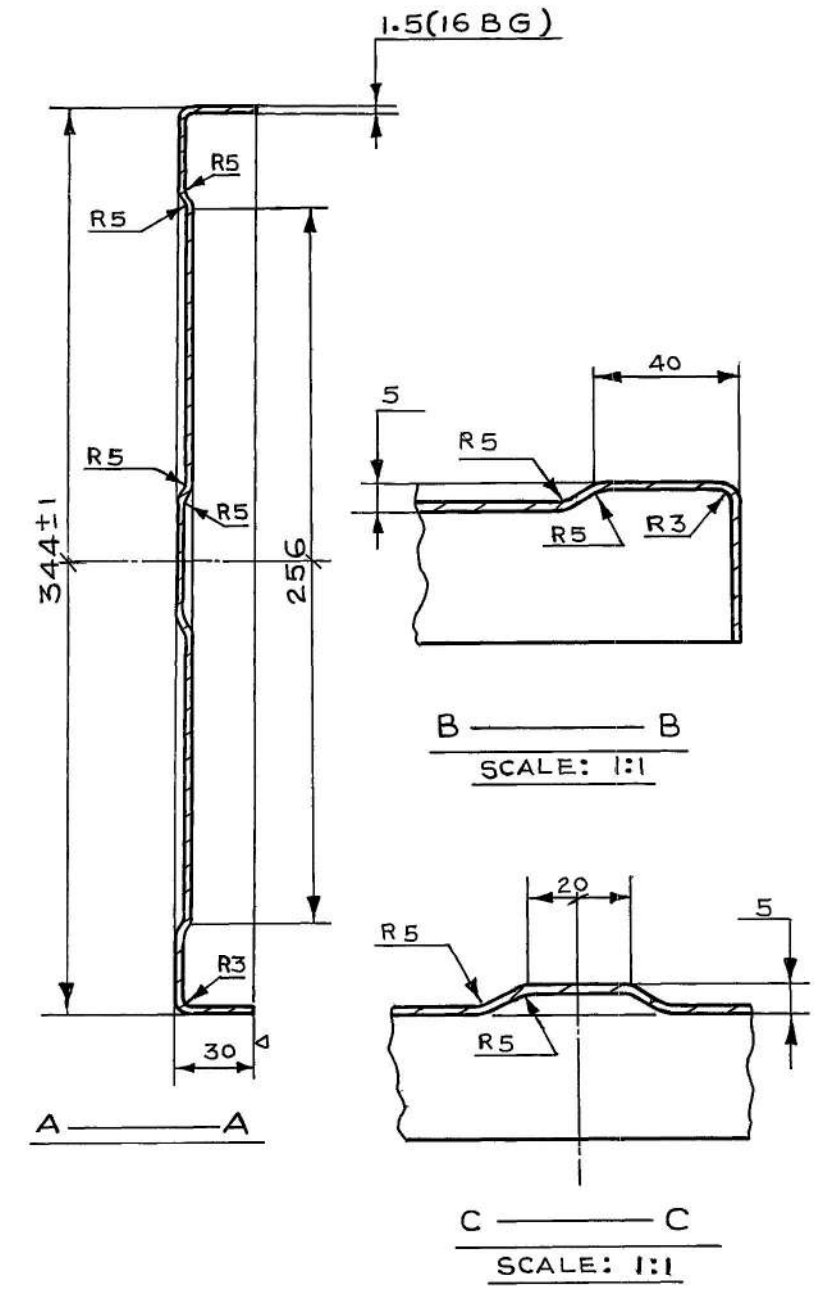
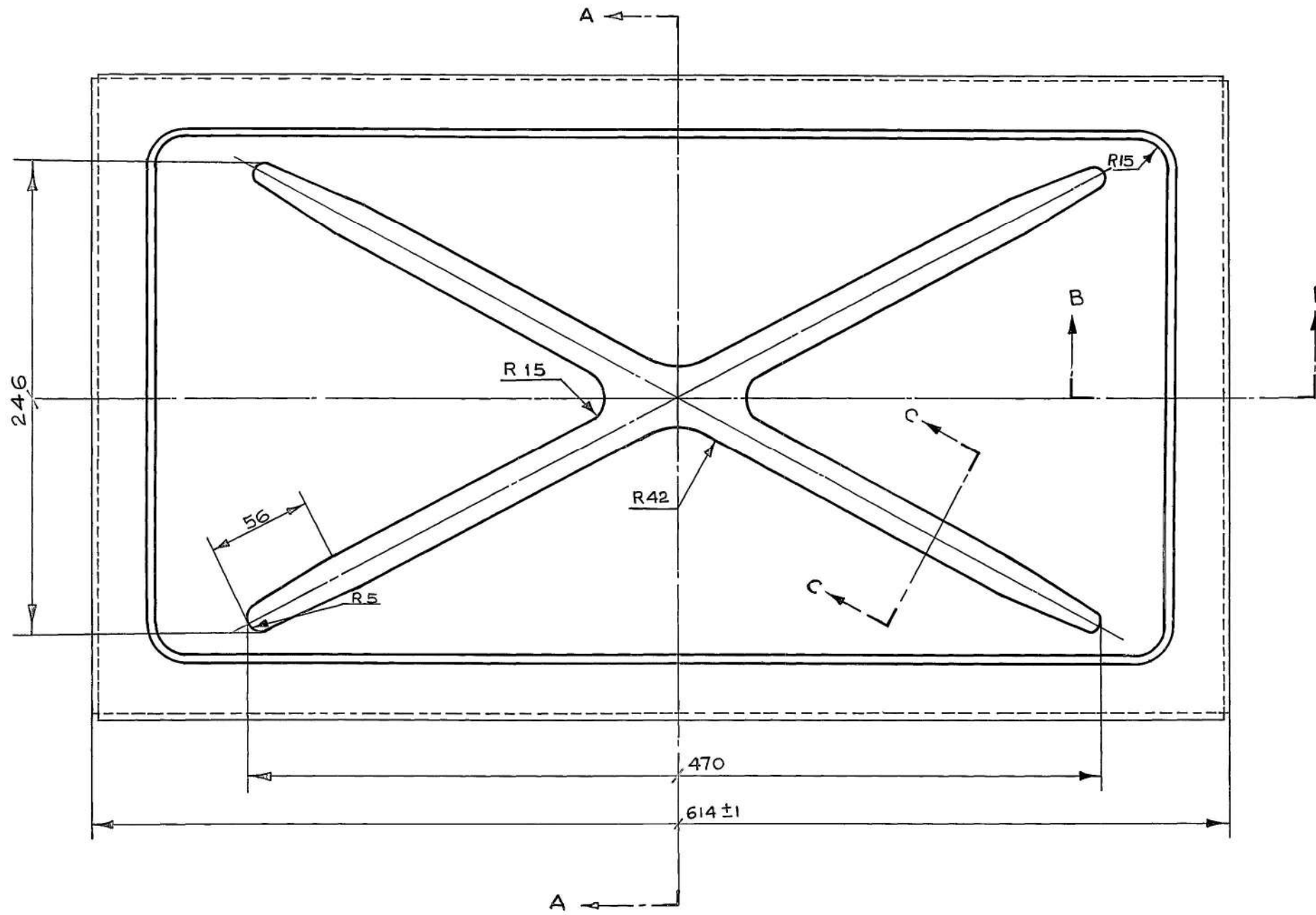
CQA(W)JABALPUR

DESIGN No. 12 SHT'S
ILG-TA-039 SHT 2
PART No.
IWP-2090
DS CAT No.

PART No
IWP-2091

DRG CONVENTIONS CONFORM TO IS:696
DIMNS ARE IN mm UNLESS OTHERWISE STATED

TOLERANCES FOR UNTOLERANCED LINEAR DIMNS								
ABOVE	6	30	120	315	1000	2000	4000	
UP TO	6	30	120	315	1000	2000	4000	-
TOLS	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3



MATERIAL:

IS : 5986 - 2011 GRADE 205
OR
IS : 513 - 2008 GRADE CR2 ANNEALED

8-7-94	30467-CQAW-QA-4	ASSY DRG NO. AMENDED.		18/08/94	03-2-17	18574-W	MATL AMENDED	
18-2-94	30467-CQAW-QA-4	PART No. AMENDE.		18/08/94	03-01-04	18844-W	PROV SEALING CANCELLED & DRG SEALED	
30-9-93	30467-CQAW-QA-4	PART No ADDED		18/08/94	23-8-94	18020-W	DRG SEALED PROV	
29-12-92	30823-CQAW-W4	MATL AMENDED.		18/08/94				
04-1-90		NEW POLY NEG PREPARED						
DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO	C/D'MAN	DO FOR CQA(W)	AHSP
AMENDMENTS				MATL: AS SHOWN				
DRG SEALED :- 18844-W				PROTECTIVE FINISH:				
03-01-04				DO CQA(W)				

LID

ASSY DRG :- ICM 320A
DATE: 12-5-89
SCALE: 1:2 (1:1)
ESTD MASS:

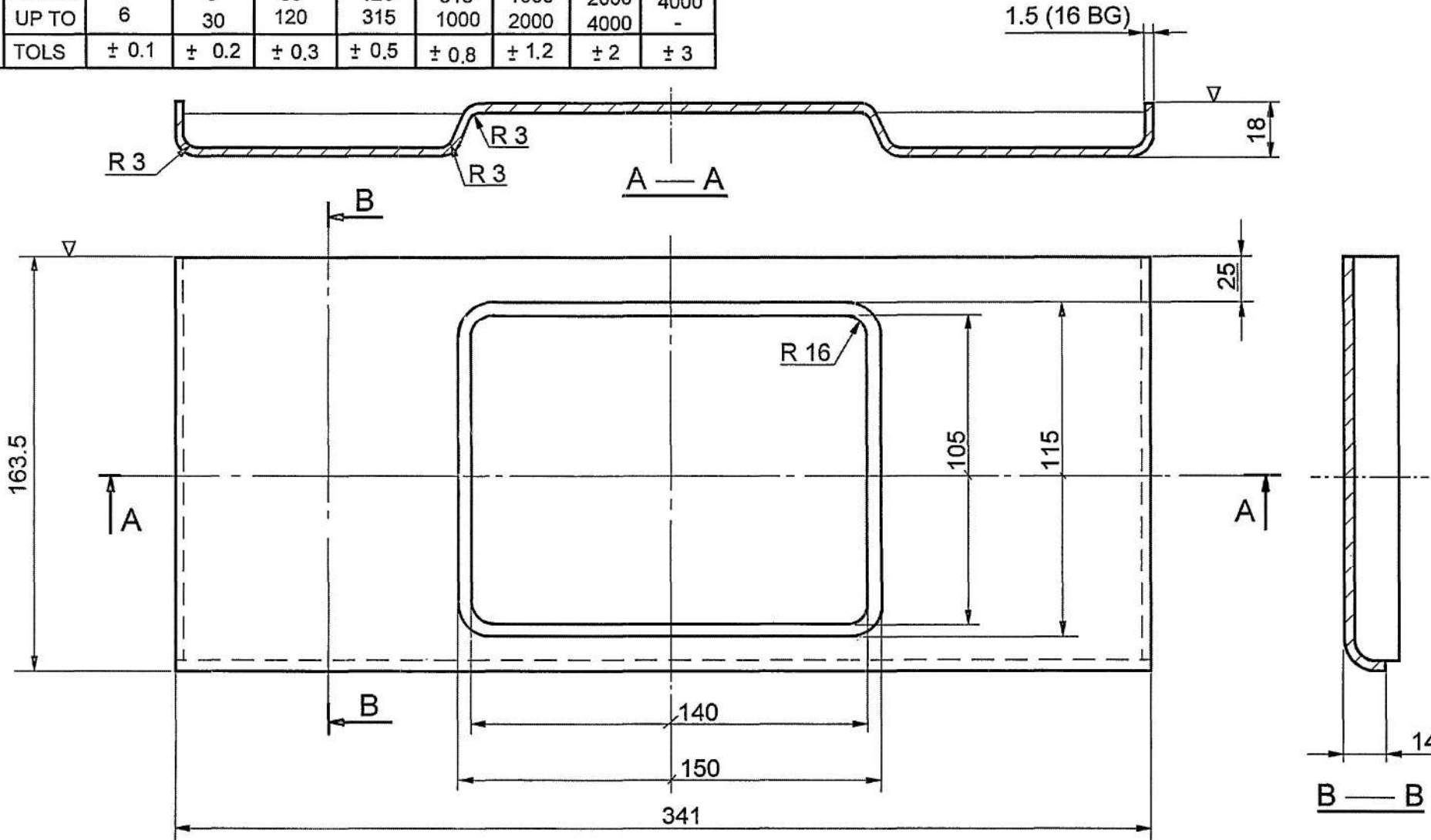
CQA(W) JABALPUR
DESIGN No. 12 SHTS
ILG-TA-039 SHT 3
PART No.
IWP-2091
DS CAT No.

PART No.
IWP 2092

DRG CONVENTIONS CONFORM TO IS : 696
DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED

TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS

ABOVE UP TO	- 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 -
TOLS	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3



MATL :-
IS:5986-2011 GRADE 205
OR
IS:513-2008 GRADE CR2 ANNEALED

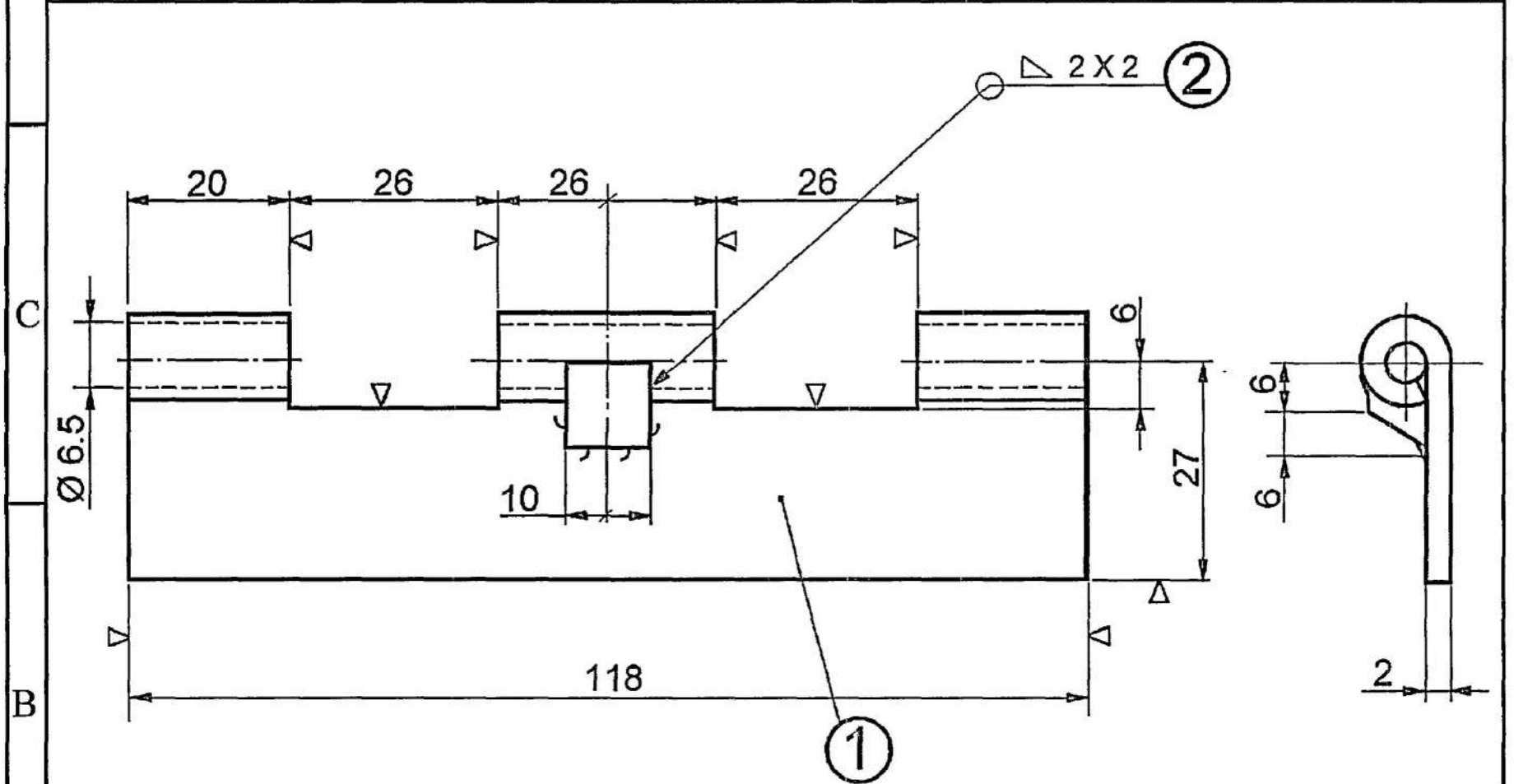
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09-2-17	19574-W	B/c-3/5	MATL AMENDED		
26-5-17			SCANNED & PRINTED WITHOUT CHANGE		
DATE	AUTHORITY	ZONE	AMENDMENTS	SIG AHSP	SIG DO
PREV DC Nos:- 18020-W & 18844-W DT 03-01-04			PROTECTIVE FINISH:-		
DRG SEALED:- 18844-W DT 03-01-04			DO CQA(W)		

DRAWN:-	CHD:-	ASSY DRG:- ICM 320 A
SCANNED:- PKA	CHD:- <i>Shikhar</i>	DATE:- 11-5-89
<i>ST</i>	AHSP	SCALE:- 1:2
JTO(D)	DO	FOR CQA(W)
MATERIAL:- AS ABOVE		ESTD mass:-
SIDE		

CQA(W), JABALPUR	
DESIGN No.	12 SHTS
ILG-TA-039	SHT 4
PART No. IWP 2092	
DS CAT No.	

4	3	2	1					
IWP 2093	PART No.							
	DRG CONVENTIONS CONFORM TO IS : 696 DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED							
	TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS							
ABOVE	-	6	30	120	315	1000	2000	4000
UP TO	6	30	120	315	1000	2000	4000	-
TOLS	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 3



NOTES :-

1. TOLERANCE FOR UNTOLERANCED HOLE + 0.2 mm
2. WELDING CONVENTIONS CONFORM TO IS : 813 - 1961

MATL :-

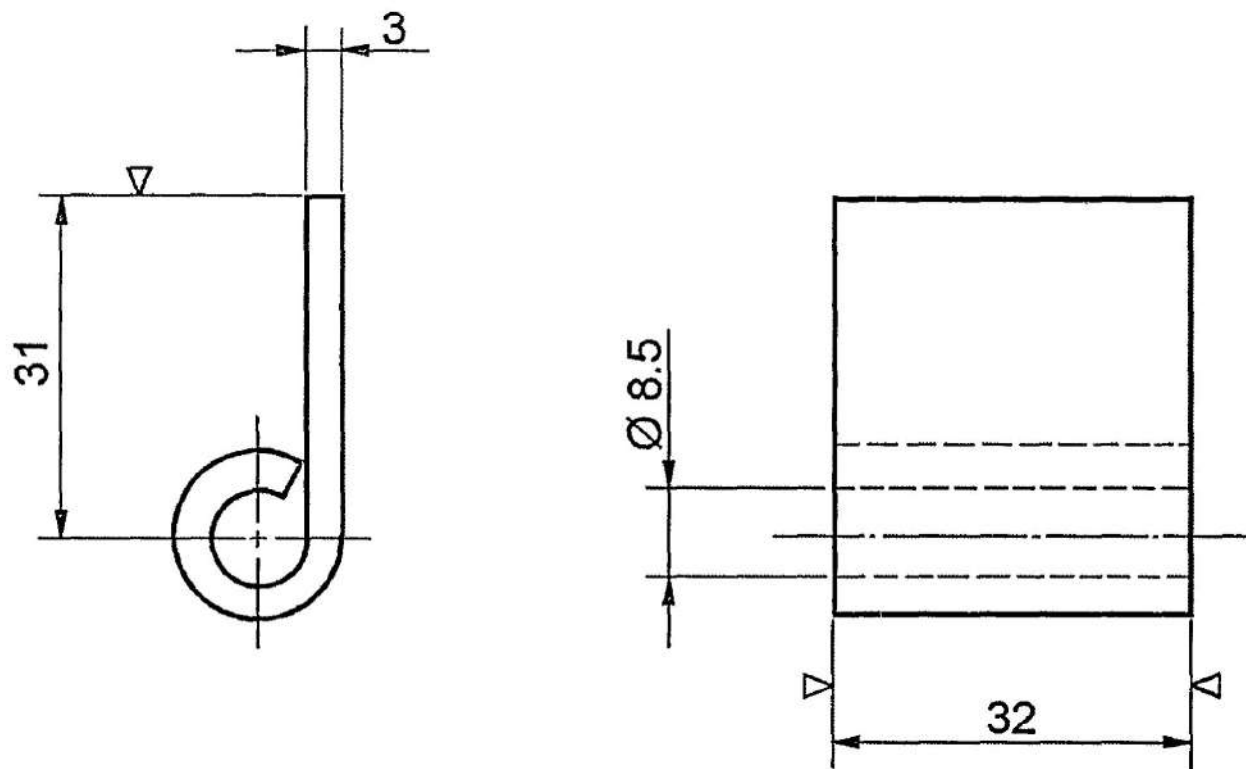
- ITEM 1 - IS : 5986 - 2011 GRADE 205
OR
IS : 513 - 2008 GRADE CR 2 ANNEALED
- ITEM 2 - IS : 5517 - 1993, GRADE 40 C 8

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					CQA(W), JABALPUR	
16-11-16	19543-W		MATERIAL AMENDED ITEM 1 & 2		DRN:-	CHD:-
10-11-16			SCANNED & PRINTED WITHOUT CHANGE		SCANNED :-PKA	CHD:- <i>PKA</i>
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO.	AHSP
PREV DC Nos:-18020-W & 18844-W DT 03-01-04					JTO (D) FOR CQAW	
DRG SEALED:-18844-W DT 03-01-04					DO CQA(W)	
SCALE:-1 : 1			ESTD mass	DATE :- 30-5-89		ASSY DRG. ICM 320 A
MATERIAL :- AS ABOVE					DESIGN No. 12 SHTS ILG-TA-039 SHT 6	
PROT FINISH :-					PART No. IWP 2093	
HINGE PT - I					DS CAT No.	

4	3	2	1
IWP 2095	PART No.		
	DRG CONVENTIONS CONFORM TO IS : 696 DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED		
	TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS		
ABOVE	-	6	30
UP TO	6	30	120
TOLS	± 0.1	± 0.2	± 0.3
	120	315	1000
	2000	4000	-
	± 0.5	± 0.8	± 1.2
	± 2	± 3	

NOTE :-
TOLERANCE FOR UNTOLERANCED HOLE + 0.2 mm



MATERIAL :-
IS: 5986-2011 GRADE 205
OR
IS: 513-2008 GRADE CR 2 ANNEALED

~ (∇)

					CQA(W), JABALPUR	
09-2-17	19574-W	MATL AMENDED			DRN:-	CHD:-
23-5-17		SCANNED & PRINTED WITHOUT CHANGE			SCANNED :-PKA	CHD:- <i>PKA</i>
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO.	AHSP
PREV DC Nos:-18020-W & 18844-W DT 03-01-04					H O S	
DRG SEALED:-18844-W DT 03-01-04					FOR CQAW	
SCALE :-1 : 1					ASSY DRG.	
ESTD mass					ICM 320 A	
DATE :-30-5-89					DO CQA(W)	
MATERIAL :- AS ABOVE					DESIGN No.	
PROT FINISH :-					ILG-TA-039	
HINGE PLATE					12 SHTS	
					SHT 8	
					PART No	
					IWP 2095	
					DS CAT No.	

PART No.

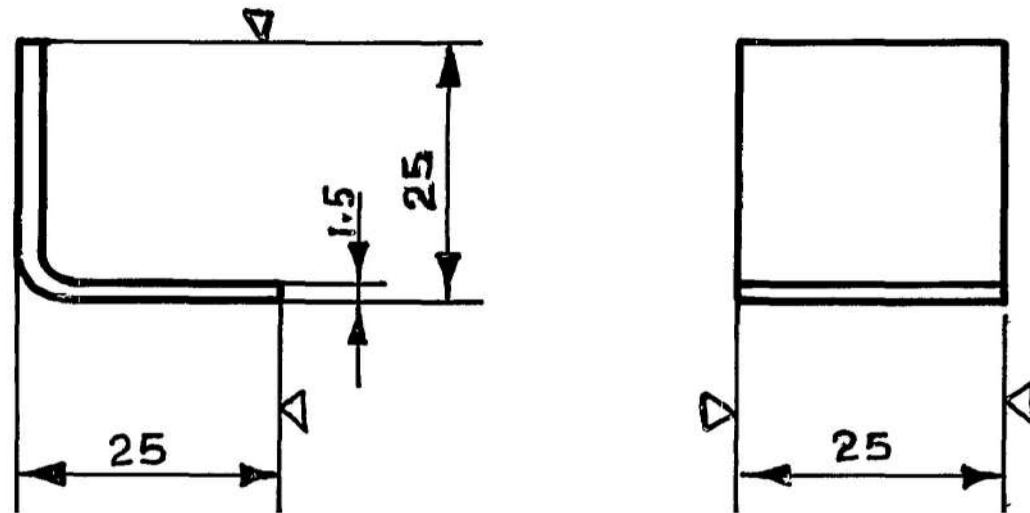
IWP-2097

DRG CONVENTIONS CONFORM TO IS:696

DIMNS ARE IN mm UNLESS OTHERWISE STATED

TOLERANCES FOR UNTOLERANCED LINEAR DIMNS

ABOVE	-	6	30	120	315	1000	2000	4000
UP TO	6	30	120	315	1000	2000	4000	-
TOLS	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	± 2	± 3



MATERIAL:

IS: 5986-2011 GRADE 205

OR

IS: 513-2008 GRADE CR2 ANNEALED

8 ⁷ / ₉₄	30467-CQAW-QA-4	ASSY DRG NO. AMENDED.		KSVW C/D	
18 ² / ₉₄	30467-CQAW-QA-4	PART No. AMENDED		KSVW C/D	
30 ⁹ / ₉₃	30467-CQAW-QA-4	PART No. ADDED			
29 ¹² / ₉₂	30823-CQAW-W4	MATL AMENDED.		KSVW C/D	
27/12-89		NEW POLY NEG PREPARED	b		
DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO

CQA(W) JABALPUR

DRN:	CHD:
TCD:	CHD:

C/D' MAN	DO
AHSP	FOR CQA(W)

DESIGN No.	12 SMTS
ILG-TA-039	SHT 10

PART No. **IWP-2097**

DS CAT No.

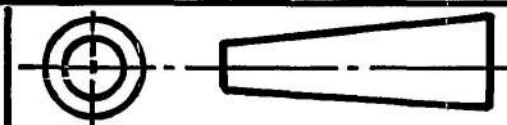
DRG SEALED :- 18844-W
03-01-04 DO CQA(W)

SCALE 1:1 ESTD MASS DATE 30-5-89

MATL: AS ABOVE

ASSY DRG

1CM 320 A



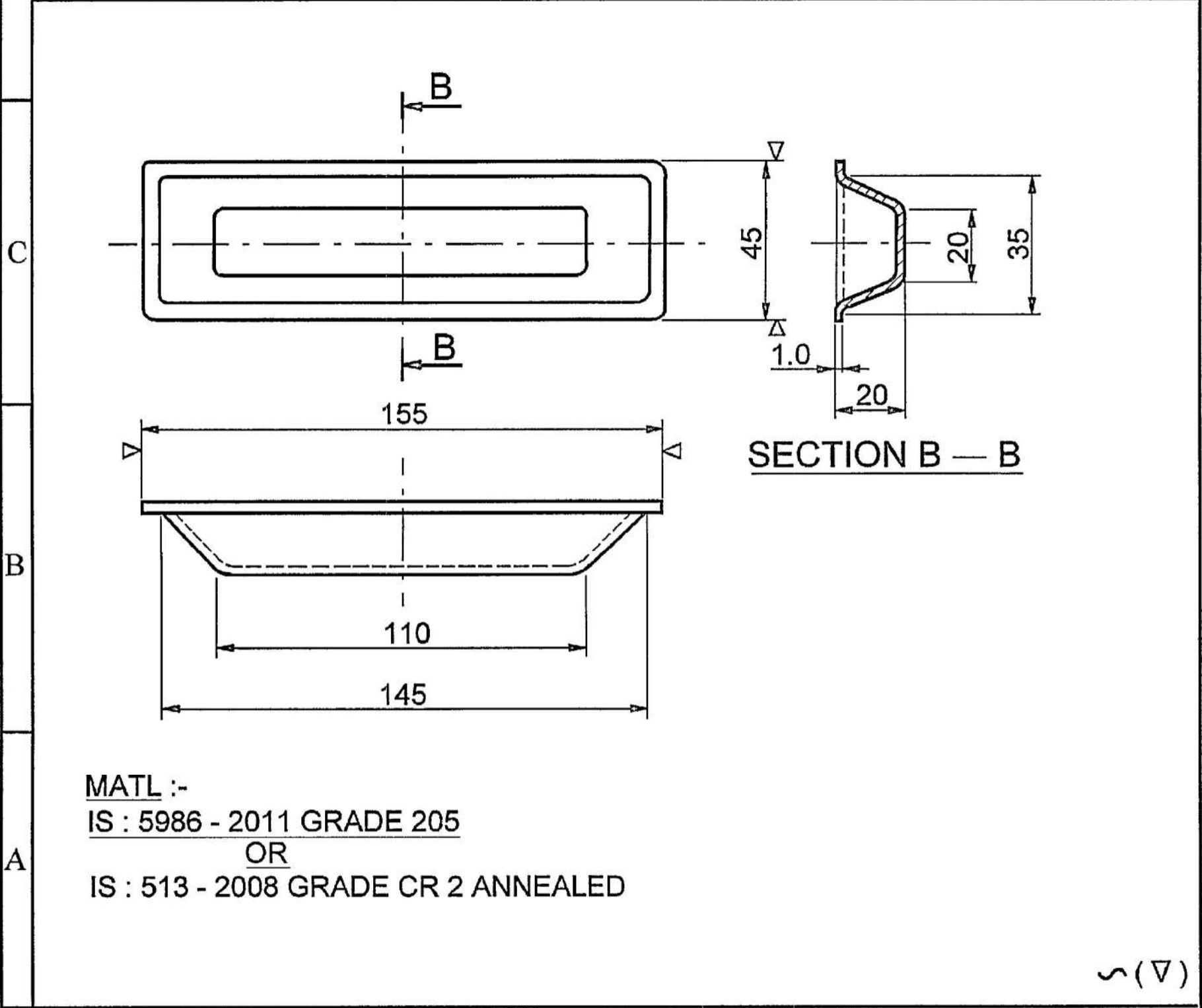
STIFFNER

18844-W PROV SEALING CANCELLED
03-01-04 & DRG SEALED
18020-W
23-8-94 DRG SEALED PROV

9-2-17 19574-W MATL AMENDED

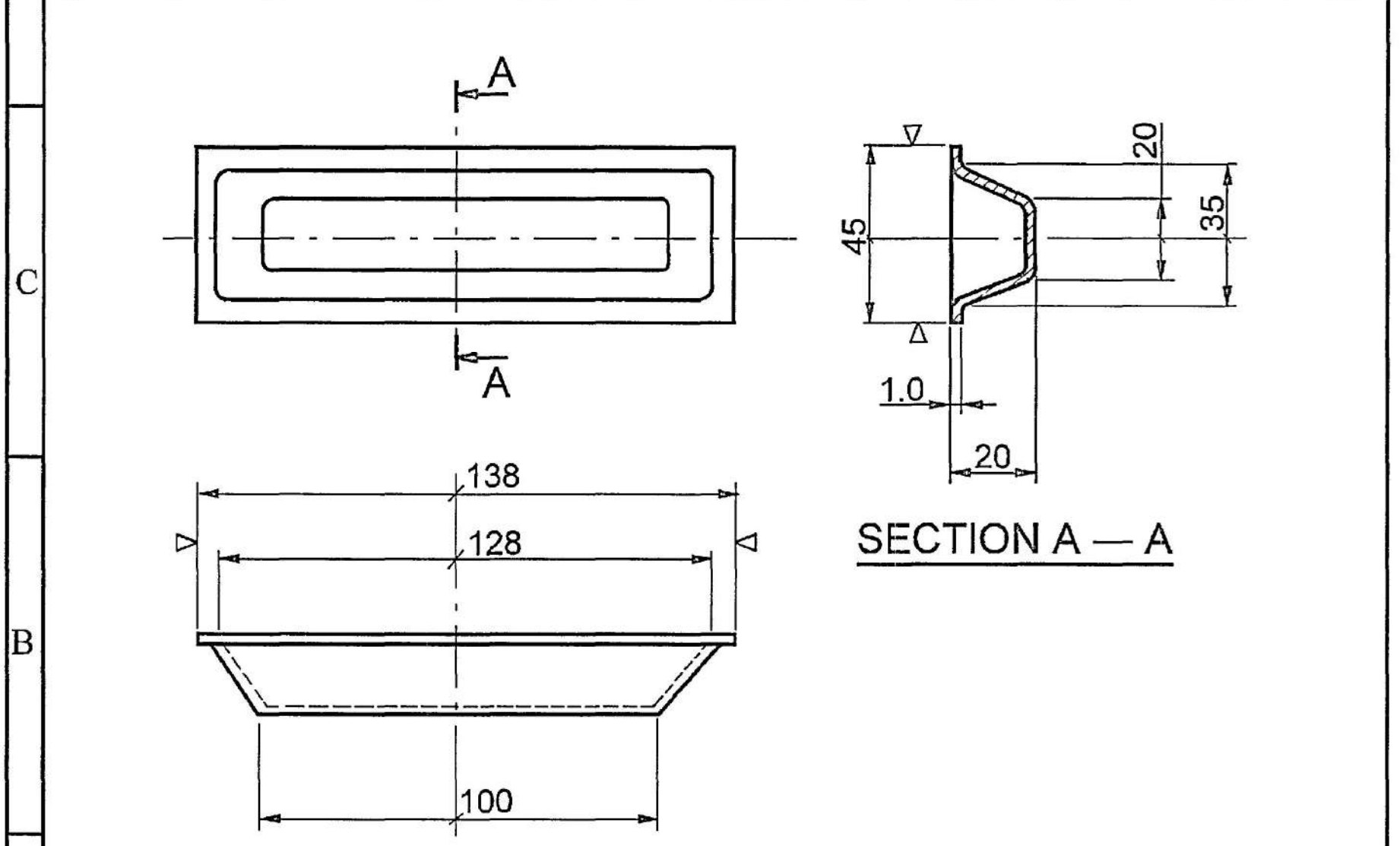
4 3 2 1
D
C
B
A

4	3	2	1
PART No. IWP 2098	DRG CONVENTIONS CONFORM TO IS : 696		
	DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED		
	TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS		
ABOVE	-	6	30
UP TO	6	30	120
TOLS	± 0.1	± 0.2	± 0.3
	120	315	1000
	315	1000	2000
	± 0.5	± 0.8	± 1.2
	2000	4000	4000
	± 2	± 3	-
	4000	-	± 3



						CQA(W), JABALPUR	
16-11-16	19543-W		MATERIAL AMENDED			DRN:-	CHD:-
10-11-16			SCANNED & PRINTED WITHOUT CHANGE			SCANNED :-PKA	CHD:- <i>PKA</i>
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO.	<i>PKA</i>	AHSP
PREV DC Nos:-18020-W & 18844-W DT 03-01-04						JTO (D)	FOR CQAW
DRG SEALED:-18844-W DT 03-01-04						ASSY DRG.	
						ICM 320 A	
SCALE:-1 : 2		ESTD mass		DATE :- 30-5-89		DESIGN No.	12 SHTS
MATERIAL :- AS ABOVE						ILG-TA-039	
PROT FINISH :-						PART No.	SHT 11
SUPPORT REAR						IWP 2098	
						DS CAT No.	

4	3	2	1
PART No. IWP 2099	DRG CONVENTIONS CONFORM TO IS : 696 DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED		
	TOLERANCES FOR UNTOLERANCED LINEAR DIMENSIONS		
	ABOVE UP TO	- 6	6 30
TOLS	± 0.1	± 0.2	± 0.3
			120 315
			315 1000
			1000 2000
			2000 4000
			4000 -
			± 0.5
			± 0.8
			± 1.2
			± 2
			± 3



MATL :-
IS : 5986 - 2011 GRADE 205
 OR
IS : 513 - 2008 GRADE CR 2 ANNEALED

~(∇)

					CQA(W), JABALPUR	
16-11-16	19543-W		MATERIAL AMENDED			DRN:-
10-11-16			SCANNED & PRINTED WITHOUT CHANGE			CHD:-
DATE	AUTH	ZONE	AMENDMENTS	SIG AHSP	SIG DO	AHSP
PREV DC Nos:-18020-W & 18844-W DT 03-01-04					JTO (D)	
DRG SEALED:-18844-W DT 03-01-04					FOR CQAW	
SCALE:-1 : 2					ASSY DRG.	
ESTD mass					ICM 320 A	
DATE :- 30-5-89					DO CQA(W)	
DESIGN No.					12 SHTS	
MATERIAL :- AS ABOVE					ILG-TA-039	
PROT FINISH :-					SHT 12	
SUPPORT FRONT					PART No.	
					IWP 2099	
DS CAT No.						