

QUALITY ASSURANCE PLAN			Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023			
Issue:01	Date	Dec-2023	Revision No.	00	Date:	
Component / Assembly			Steel Package for 125mm HE			

Quality Assurance Plan
of
Steel Package for 125mm HE
(PROVISIONAL)

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0.0	GENERAL INFORMATION
0.1	SCOPE
	This specification provides guidelines for manufacturing, selection of material, inspection and testing of Steel package for 125 mm HE Ammunition.
0.2	INTRODUCTION
	The Steel Package is used to pack 125mm HE Ammunition during transit and storage.
0.3	GENERAL
0.3.1	This specification is the property of the Ministry of Defence and must be returned to the Department from which it is issued immediately after the tender has been declined or on completion of the contract or on demand.
0.3.2	This specification or any other information issued in connection therewith may only be issued for specific enquiries, tenders or orders place by a competent authority on behalf of the Ministry of Defence. It is not to be used for any other purpose whatsoever without the written sanction of the MIL/OFCH. Any enquiries regarding this specification should be addressed to the inspecting Authority named in the tender or contract.
0.3.3	Contractor before commencement of bulk production shall submit requisite number of sample, test pieces as directed by the inspector for qualifying material/process/component as the case may be. All the tests including hardness check of components/assemblies shall be undertaken by the manufacturer in presence of the representative of inspection agency.
0.3.4	The firm shall fabricate initial 05 samples (prototype), which shall be taken up for various qualification testing. Only on clearance of the same the bulk clearance shall be accorded.
0.4	APPLICABLE DOCUMENT
	This specification should be read in conjunction with the
1.	Steel Package (125mm HE)DRG NO: PROP/SK-845-01
2.	Steel box assembly DRD No: PROP/SK-845-02
3.	Steel box sub assembly DRG No: PROP/SK-845-03
4.	Base plate DRG No : PROP/SK-845-04
5.	Side plate DRG No: PROP/SK-845-05
6.	Side handle assembly DRG No: PROP/SK-845-14
7.	Side handle plate DRG No. PROP/SK-845-12
8.	Side handle DRG No PROP/SK-845-13
9.	Top cover assembly DRD No. PROP/SK-845-06
10.	Top cover DRG No. PROP/SK-845-07
11.	Gasket 1 DRG No PROP/SK-845-11
12.	Gasket 2 DRG No PROP/SK-845-10
13.	Hook Holder top plate DRG No PROP/SK-845-15
14.	Top cover handle assembly DRG No PROP/SK-845-16
15.	Top cover handle plate DRG No PROP/SK-845-17

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16.	Top cover handle DRG No PROP/SK-845-08
17	Hinge assembly DRG No PROP/SK-845-09
18.	Foam top DRG No PROP/SK-845-18
19.	Foam bottom DRG No PROP/SK-845-19
20	Limit Bar DRG No PROP/SK-845-20
21	Hook assembly DRG No PROP/SK-845-21
22	Hook base plate DRG No PROP/SK-845-22
23	Hook handle DRG No PROP/SK-845-23
24	Hook pin DRG No PROP/SK-845-24
25	Hook link DRG No PROP/SK-845-25
26.	LP container assembly primary DRG No PROP/SK-845-26
27.	Sleeve lid sub assembly primary DRG No PROP/SK-845-27
28.	Sleeve lid outer primary DRG No PROP/SK-845-28
29.	Washer Millboard 1 DRG No PROP/SK-845-36
30.	Sleeve sub assembly primary DRG No PROP/SK-845-30
31.	End cap primary DRG No PROP/SK-845-31
32.	Sleeve inner primary DRG No PROP/SK-845-32
33.	Sleeve outer DRG No PROP/SK-845-33
34.	Sleeve inner-2 primary DRG No PROP/SK-845-29
35.	Paper Disc Primary DRG No PROP/SK-845-34

0.5	RAW MATERIAL
0.5.1	All the raw materials must be procured from the reputed vendors as per the requirements given on the relevant drawings/ specifications. The manufacturer shall undertake chemical and mechanical testing of raw material in accordance with the relevant specification quoted in the manufacturing drawing. Acceptance of raw materials shall be as per the material tests certificate produced by the reputed vendor. Tested quantity of material with lot homogeneity shall be procured in suitable batches and these shall be sealed by the inspecting agency after inward goods inspection. Once the raw material has been accepted for the internal use for manufacture of components in shall not be changes, altered, modified during the process. No other material in lieu of already sealed one shall be permitted without the written approval.
0.5.2	Contractor is responsible for the procurement of raw material conforming to the specification n the requisite sizes.
0.5.3	Raw material lots that do not correspond to the specifications must be rejected. The supplier has the right to be convinced about the justification of the rejection. The results of the inward goods inspection shall be communicated in writing to the supplier (contractor).
0.5.4	If there is any dispute in acceptance of material on the supplier's test certificate, inspector reserves the right to get it tested from a neutral test agency and satisfy the requirements as per specification.
0.5.5	If the lot of raw material is rejected at the discretion of the inspection authority, it should be discarded and care should be taken to avoid mixing of the rejected lot with accepted lots. A proper rejection control/system shall be adopted by the contractor.

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0.5.6	The raw materials procured should be stamped duly by the inspection agency. Inspection agency should also ensure that the same material is being processed for the subsequent cutting or machining operation. The traceability of the material shall be ensured to the inspecting agency, whenever required.
0.5.7	Wherever the specification or drawing permits a choice of alternative materials(s), the contractor must inform in writing to the Inspecting Authority, which of the permitted alternatives he chooses to produce and once the choice has been granted to the event of this choice requiring further amendment, the fabricator/contractor is bound to get the prior approval of inspecting agency & Inspection Authority for such a change over.
0.6.0	MANUFACTURE/FABRICATION
0.6.1	The contractor may subcontract the fabrication of sub assembly or part thereof wit prior permission and approval of inspection authority.
0.6.2	Wherever the specification or drawing permits a choice of alternative method(s) of manufacture, the contractor must inform in writing to the Inspecting agency, which of the permitted alternatives he chooses to produce and once the choice during course of manufacture. In the event of this choice requiring further amendment, the fabricator/contractor is bound to get the prior approval of inspecting agency & Inspection Authority for such a change over.

0.6.3	The contractor shall submit the manufacturing / fabrication process with relevant control points for stage inspection and quality assurance plan to the inspecting authority for approval before starting any process. Once the process of manufacture/fabrication has been documented, process sheets prepared and approval granted, no change should be allowed without the written approval of the Inspecting Authority.
0.6.4	All details of workmanship shall be consistent with the requirement. There shall be no cracks, burrs, dents, scratches, sharp edges, loose parts, foreign matter or any other evidence of poor workmanship that will render components/subassemblies unsuitable for its internal use. Cleaning methods used shall not be injurious to any of the parts. No parts shall be contaminated by cleaning agent.
0.6.5	Components shall be manufactured as per the approved plan from the specified materials and should meet all physical, chemical, metallurgical and geometrical requirements as indicated by relevant document/specification.
0.6.6	No mechanical work, heat treatment or any other operation, which may modify, alter the metallurgical or physical properties of the material will be carried out after it has been submitted for approval.
0.6.7	All tolerances specified are absolute with no allowance made for manufacturing process, machine inaccuracies (or measuring instruments inaccuracies). All components are to be manufactured within the tolerance limits specified.
0.7.0	INSPECTION
0.7.1	Unless otherwise stated in the contract or purchase order, supplier is responsible for the performance of inspection requirement as per relevant drawing/specification using his in-house facility or as per the directive issued by the Inspecting agency.
0.7.2	The right to perform any inspection, testing at any stage during course of production or at the completion of manufacture rests with the Inspecting Agency. Contractor shall inform Inspection Agency of his readiness to commence manufacture at his place or at the place where sub-contracting has been made and make available all facilities and access to all places of work to undertake inspection task.
0.7.3	All the test fixture, tools, gauges, equipment, instrument etc., required to undertake inspection/testing along with calibration certificate shall be made available by the supplier.

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0.7.4	Any component, sub-assembly or assembly spent/damaged during the course of transit etc., shall be replaced free of cost by the supplier.
0.7.5	Contractor before commencement of bulk production shall submit requisite number of samples, test pieces as directed by the inspector for qualifying material/process/component as the case may be.
0.7.6	Inspection Agency representatives shall also draw samples of raw materials and carry out the chemical/mechanical testing independently. The representative is at his / her liberty to select more than one rod, plate etc. The manufacturer shall also provide the certificate of purchase of raw material with heat/lot number in order to ensure trace ability, where possible. The facilities for testing will be provided/arranged by the contractor.
0.7.7	Supplier (Manufacturer) and inspector shall mutually agree on the requirement of online inspection during the processing of the components and inspection criteria. Further, manufacturer shall submit only those components/ parts, which meet all the requirements as stipulated on the drawings/specifications.
0.7.8	Any component/pattern sent to the supplier shall be used only as guide to manufacturer and not for details.
0.7.9	All components/ stores shall be manufactured using the same process. Material, procedure and equipment approved prior to the start of manufacturer.
0.7.10	Prior to submission, manufacturer in his own interest shall inspect all the components to the degree necessary to ensure that they confirm to the requirement and submit his documents/records/test results along with the statement of findings for material, test standards etc., to the inspector for his scrutiny/vetting.
0.7.11	All tests including hardness check of components /assemblies shall be undertaken by the manufacturer in presence of the representative of Inspection Agency.
0.7.12	Samples containing known defects shall not be submitted.
0.7.13	Fresh samples shall be submitted for inspection/testing whenever there is a change in material, specification, process, and drawings or if there is a lapse of more than one year in production. These repeat samples shall be subjected to the severity of test/ inspection criteria as in the case of original sample.
0.7.14	During production, any major component, subassembly and final assembly not meeting the requirements stipulated in this specification or relevant drawings, shall be referred to the Inspecting authority, who in turn on the merits of deviations observed will seek the approval of waiver board or any such competent authority either for acceptance, rectification and resubmission or rejection as the case may be.
0.7.15	All the rejected components/ subassemblies/ final assemblies shall be segregated and destroyed under instructions to Inspection Agency & Inspection Authority.
0.7.16	Inspection Agency will prepared inspection note of accepted/rejected cable assemblies and forward to procurement agency, user/depot & supplier.
0.8.0	DEFINITIONS
0.8.1	Lot/ Batch formation: Unless otherwise specified, a lot is that quantity which is produced according to the same production basis and production process in a unbroken continuous sequence by the manufacturer and with the same lot/batch of material received fulfilling the condition of homogeneity without exceeding the maximum quantity mentioned in the specification
0.8.2	Defect Classification- Critical, Major and Minor <u>Critical Defect</u> A defect that would render the item totally unfit for use or could result in hazardous or unsafe conditions for individuals using or maintaining the item. <u>Major Defect</u> A defect, other than critical defect that result in failure, or materially reduces the usability of the item or product for its intended purposes. <u>Minor Defect</u>

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	A defect other than critical and major defect that does not materially reduce the usability of the product for its intended purpose.								
0.8.3	Lot size for components: Unless otherwise mentioned hereinafter, the lot size shall be 500 up to 1000 Nos (for reference during mass production only).								
0.8.4	Sampling: During production unless otherwise specified hereafter or by the inspecting authority, for a given lot/batch size, sample size shall be in accordance with the general inspection level II and single sampling AQL plans, given in “Inspection by attributes and by count defects” as per specification no. IS: 2500 (Part-I) – 2000.								
0.8.5	<p>Acceptance Quality Levels: During the initial production inspection will be carried out as per the sample size given in QAPs. If any deviation occurred than 100% inspection clause shall be decide at the discretion of Inspecting agency wherever applicable.) The acceptable quality levels for defects shall be as follows:</p> <table border="1" data-bbox="252 728 619 878"> <thead> <tr> <th>Defect Class</th> <th>Percent</th> </tr> </thead> <tbody> <tr> <td>Critical</td> <td>None</td> </tr> <tr> <td>Major</td> <td>4.0</td> </tr> <tr> <td>Minor</td> <td>10.0</td> </tr> </tbody> </table>	Defect Class	Percent	Critical	None	Major	4.0	Minor	10.0
Defect Class	Percent								
Critical	None								
Major	4.0								
Minor	10.0								
0.9	MARKING								
0.9.1	Raw materials: all the raw material shall be identified suitably with the following information Source of supply: Order No.: Batch No.: Identification code:								
0.9.2	<p>Components and Assembly: All the Packages from the acceptable batch shall be marked with a serial number/lot number wherever it is mentioned in this specification. All the accepted components shall be grouped in suitable batches and shall be identified on their package with the following information. This information shall also be recorded on the inspection reports and be move along with the batch.</p> <p>Manufacturer’s code: xxxx (Max four letters) Lot no.: for example, 01 to 99 Date / Year of manufacturing: MM/YY Package Serial No: 1 to 1000</p>								
0.9.3	Marking can be either stencilled, inked painted, etched unless otherwise mentioned, such that it does not vanish during handling, storage, transportation.								
0.10	PACKING / TRANSPORTATION & STORAGE								
	Unless otherwise specified herein or in relevant documents, between various works centres the manufacturer is responsible for transportation/ storage of components/ empty sub-assemblies in suitable transit packages in such a way that the components are protected from abrasion, corrosion, mishandling and other environmental effects.								
0.11	<p>AHSP: Authority Holding Sealed Particulars CP: Control Point (Witness by rep AHSP) SP: Surveillance point (many be witnessed by rep AHSP) Audit: Inspection reports may be audited</p>								

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1. STEEL PACKAGE (125mm HE)

1.1	Drawing No		: PROP/SK-845-01			
1.2	Method of Manufacturing		Assembly			
1.2.1	One set of Steel Package Assembly consist of following					
	Sl. No.	Components	Drawing Number		Qty	
	1.	Steel Box Assembly	PROP/SK-845-02		01	
	2.	LP container Assy Primary	PROP/SK-845-26		01	
1.3	Raw Material : Nil					
1.4	Test/ checks and Acceptance Criteria for Raw material: Nil					
1.5	In-Process Inspection		: Nil			
1.6	Stage Inspection		: Nil			
1.7	Final Inspection :					
1.8	Visual Inspection :					
1.8.1	Features for Visual Inspection and acceptance criteria Sample Size: 100& by manufacturer and as per AQL by AHSP/SQAE					
	Sr.	Features	Acceptance Criteria	Defect Class	AHSP Intervention	
	1.	Damage of the outer Surface	Not Accepted	Major		
	2.	Painting and Coating to be uniform	Ensured	Minor		
	3.	Sharp edges	Not Accepted	Minor		
1.8.2	Dimensional Inspection					
1.8.2.1	Critical Dimensions		:Nil			
1.8.2.2	Geometrical Features		:Nil			
1.8.2.3	Major Dimensions :					
	Sr. No	Dimensions/ Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	740±3		Steel Rule/Tape	SP	
	2.	393±2		Steel Rule/Tape		
	3.	250±2		Steel Rule/Tape		
1.8.2.4	Minor Dimensions	:Nil				
1.9.1	Test on Finish Items	: Details of test/checks on finished items, Acceptance criteria and other information.				
	The Qualification tests in vendor premises/test facilities shall be carried out with LP containers duly packaged with 125mm shell with Resin based Combustible cartridge case and filled with dummy propellant and dummy primer.					

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Sl. No.	Test/Check	Sample Size and Defect class	Acceptance Values
1.	Fitment Check using LP containers (with dummy cartridge assemblies)	100% (Major)	The LP containers (with dummy cartridge assemblies) shall be accommodated in the Package satisfactorily. The LP containers shall rest on the cavity walls/ surfaces of the foam. Opening and closing of the package shall be easy.
2.	Pull Load Test: Hook Assembly {for details see note (a), of below}	02 Nos (Major)	35kgf
3.	Pull Load Test: Handle Assembly {for details see note (b), of below}	02 Nos (Major)	100kgf
4.	Pull Load Test: Hinge Assembly {for details see note (c), of below}	02 Nos (Major)	100kgf
5.	Impact Drop Vertical Test as per JSG 0102 (Test 14P) {For details see note (d) of below}	02 Nos (Major)	After completion of test round packed in LP containers should be serviceable or safe for disposal.
6.	Bounce test/Rough Usage/Travel as per JSG 0102 (Test 18P/19P) {For details see note (e) of below}	02 Nos (Major)	After completion of test round packed in LP containers should be serviceable or safe for disposal.
7.	Vibration test as per JSG 0102 (Test 20P (a)) {For details see note (f) of below}	02 Nos (Major)	After completion of test round packed in LP containers should be serviceable or safe for disposal.

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8.	Water Immersion Test as per JSG 0102 (Test 9P) {For details see note (g) of below}	02 Nos (for information)	After completion of test round packed in LP containers should be serviceable or safe for disposal.
9.	Stacking as per JSG 0102 (Test 22P) {For details see note (h) of below}	06Nos (Major)	The container and its contents should be intact after the test.
10.	Lifting Test as per JSG 0102 (Test 25P) {For details see note (i) of below}	02 Nos (Major)	The container and its contents should be serviceable.
Notes on Tests/Checks:			
a)	Pull Load Test: Hook Assembly Each hook Assembly shall be subjected to vertical tensile load of 35kgf applied in line to the integrated hook Assembly for 5 minutes' duration. There shall not be any deformation at Hook section.		
b)	Pull Load Test: Handle Assembly Each handle assembly shall be subjected to tensile load of 100 kgf applied perpendicular to the integrated Handle Assembly for 5 minutes' duration. There shall not crack.		
c)	Pull Load Test: Hinge Assembly Each hinge assembly shall be subjected to tensile load of 100 kgf applied perpendicular to the integrated Hinge Assemble for 5 minutes' duration. There shall not be any deformation at hinge & engaging plate section of the hinge assembly. Package shall not crack.		
d)	Impact Drop Vertical Test as per JSG 0102 (Test 14P): (Packages accepted in water immersion test): complete Package along with round packed in LP containers shall be dropped on the bottom side where, from a height of 1.5m on 6mm thick steel plate. The package shall also be dropped on each of its other faces from a height of 0.3m on 6mm thick steel plate.		
e)	Bounce Test/ Rough Usage/Travel Test as per JSG 0102 (Test 15U): Bump /Jolt Test shall be carried out at frequency 5 bumps per second and 12.5 mm displacement for 1000 bumps on the transport surface of the package. (Test to be carried in packed condition only).		
f)	Vibration Test as per JSG 0102 (Test 20P (a)): The package shall be vibrated for 2 hours in each of 3 mutually perpendicular planes at a constant peak to peak displacement of 12mm over the frequency range 5 to 11Hz and at constant peak acceleration of 30 m/s ² over the frequency range 11 to 350Hz. This test is intended to assess the effects of the application of vibrations representative in amplitude and frequency of those which the package will encounter in the course of transportation by road, rail, sea and air.		
g)	Water Immersion Test as per JSG 0102 (Test 9P): (Package accepted in vibration should be used) Complete Package along with Round packed in LP container shall be immersed in the water to a depth of 0.15m measured from its top surface for duration of 20 minutes. There shall not be trace of any water inside the LP containers after the test.		

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	(h)	<p>Stacking Test as per JSG 0102 (Test 22P): This test shall be conducted to see the effect of stacking on the package by stacking the packages in six tier position. Ensure that the grooves/ribs of package on the top get engaged in the corresponding mating surface of the package on the bottom side. Intentional disturbances and shake shall be given to the package placed on top tier. The package shall remain in its position within the grooves/ribs engaging in the mating surface of lower package. The package shall not bulge/de-shape, crush or partial collapse against compression. The lower package shall also be seen to be intact.</p>
	(i)	<p>Lifting Test as per JSG 0102 (Test 25P): Load the Package to three times the gross packaging weight maintaining the C. G. and allow the package to hand freely through the handle/lifting hook for a period of 5 minutes. No deformation or cracks shall be observed on the package.</p>
2.		<p>Painting: 1. Check for marking on the package: Following to be checked for Embossing/Painting on the Plain surface of the package Letter Size to be 20 millimeters, Font: Arial Details to be embossed/painted</p> <ul style="list-style-type: none"> • "Rd 125mm HE" • YEAR OF MANUFACTURE (MM/YYYY) • MANUFACTURES INITIALS <p>2. Check the condition of Rust Proof Painting 3. Check embossing for stacking arrangement</p>

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2. STEEL BOX ASSEMBLY

2.1	Drawing No		: PROP/SK-845-02			
2.2	Method of Manufacturing		:Assembly using welding process			
2.2.1	One set of the steel box sub assembly consist of following components					
	Sr. No.	Components	Drawing Number		Qty	
	1.	Steel Box Sub Assembly	PROP/SK-845-03		01	
	2.	Side Handle Assembly	PROP/SK-845-14		02	
	3.	Top cover Assy	PROP/SK-845-06		01	
	4.	Hook Assy	PROP/SK-845-21		02	
	5.	Foam Top	PROP/SK-845-18		01	
	6.	Foam Bottom	PROP/SK-845-19		01	
	7.	Limit Bar	PROP/SK-845-20		02	
2.3	Raw Material : Nil					
2.4	Test/ Checks and Acceptance Criteria for Raw Material: Nil					
2.5	In-Process Inspection		:Nil			
2.6	Stage Inspection		:Nil			
2.7	Final Inspection		:			
2.8	Visual Inspections		:			
2.8.1	Features for Visual Inspection and acceptance Criteria: Sample size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No	Features	Defect Level	Criteria	AHSP Intervention	
	1.	Damage of the outer surface	Major	Not accepted		
	2.	Painting to be uniform	Major	Ensured		
	3.	No Sharp edges	Minor	Ensured		
	4.	No sharp corners of welded joints	Minor	Ensured		
2.8.2	Dimensional Inspection					
2.8.2.1	Critical Dimensions		:Nil			
2.8.2.2	Geometrical Features		:Nil			
2.8.2.3	Major Dimensions:		:Nil			
2.8.2.4	Minor Dimensions		:Nil			
2.9.1	Test on Finish Items		:			
	a) Visually check the hook assembly and side handle assembly for proper weld. b) Check for sharp corners at weld locations. c) Test certificates of powder coating to be submitted.					
2.10.1	Details of any other information: <ul style="list-style-type: none"> • Bottom foam should not come out with the lifting of LP Containers from box • Embossing/ painting on front face "Rd 125MM HE" 					

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3. STEEL BOX SUB ASSEMBLY

3.1	Drawing No		: PROP/SK-845-03			
3.2	Method of Manufacturing		: Assembly using welding process			
3.2.1	One set of the steel box sub assembly consist of following components					
	Sr. No.	Components	Drawing Number		Qty	
	1.	Base Plate	PROP/SK-845-04		01	
	2.	Side Plate	PROP/SK-845-05		01	
3.3	Raw Material : Nil					
3.4	Test/ Checks and Acceptance Criteria for Raw Material: Nil					
3.5	In-Process Inspection		: Nil			
3.6	Stage Inspection		: Nil			
3.7	Final Inspection		:			
3.8	Visual Inspections		:			
3.8.1	Features for Visual Inspection and acceptance Criteria: Sample size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No	Features	Defect Level	Criteria	AHSP Intervention	
	1.	Damage of the outer surface	Major	Not accepted		
	2.	Painting to be uniform	Major	Ensured		
	3.	No Sharp edges	Minor	Ensured		
	4.	No sharp corners of welded joints	Minor	Ensured		
3.8.2	Dimensional Inspection					
3.8.2.1	Critical Dimensions		: Nil			
3.8.2.2	Geometrical Features		: Nil			
3.8.2.3	Major Dimensions:					
	Sr. No.	Dimensions/Features	Drawing Zone		Inspection Method	AHSP Intervention
	1.	740±3			Steel Rule/Tape	SP
	2.	250±2			Steel Rule/Tape	
	3.	393±2			Steel Rule/Tape	
3.8.2.4	Minor Dimensions		: Nil			
3.9.1	Test on Finish Items		:			
	d) Check for sharp corners at weld locations.					
3.10.1	Details of any other information: Nil					

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4. BASE PLATE

4.1	Drawing No.		: PROP/SK-845-04			
4.2	Method of Manufacturing		: Sheet Metal Operations			
4.3	Raw Material		: Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513: 1993, reaffirmed 2003, any of Grade O/D/DD.			
4.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
4.5	In-Process Inspection		:Nil			
4.6	Stage Inspection		:Nil			
4.7	Final Inspection:					
4.7.1	Visual Inspection:					
	Features for visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No	Features	Criteria	Defect Level	ASHP Intervention	
	1.	No sharp edges	Ensured	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor		
4.7.2	Dimensional Inspection					
4.7.2.1	Critical Dimensions		:Nil			
4.7.2.2	Geometrical Features		:Nil			
4.7.2.3	Major Dimensions : Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/ Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	740±3		Steel Tape/ Rule	SP	
	2.	393±2		Steel Tape/Rule		
	3.	250±2		Steel Tape/Rule		
4.7.2.4	Minor Dimensions		:			
	Sample Size: To be checked at raw material stage by AHSP/SQAE					
	Sr. No.	Dimensional/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Thickness 1.2 mm		Micrometre	SP	
	2.	570		Steel Tape/Rule		
	3.	200		Steel Tape/Rule		
	4.	260		Steel Tape/Rule		
	5.	105		Steel Tape/Rule		
4.8	Test on Finish Items		:			
	Sample Size: 10% of sample or test coupon per batch					
	Sr. No.	Dimensions/ Features	Acceptance value	Defect Class	Remarks	AHSP intervention
	1.	Phosphating to IS 3618:1996	As specification Class A2	Major	Supplier shall submit the test report of the entire batch	
4.9	Details of any other information : Nil					

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5. SIDE PLATE

5.1	Drawing No	:PROP/SK-845-05				
5.2	Method of manufacturing	:Sheet Metal operations				
5.3	Raw material	:Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513 : 1993 reaffirmed 2003, any of Grade O/D/DD of thickness 1.2mm				
5.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
5.5	In-Process Inspection	:Nil				
5.6	Stage Inspection	:Nil				
5.7	Final Inspection:					
5.7.1	Visual Inspection :					
	Features for Visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor		
5.7.2	Dimensional Inspection					
5.7.2.1	Critical Dimensions		:Nil			
5.7.2.2	Geometrical Features		:Nil			
5.7.2.3	Major Dimensions		:Nil			
5.7.2.4	Minor Dimensions Sample Size:100% by manufacture and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP intervention	
	1.	380±2		Steel Tape/Rule	SP	
	2.	250±2		Steel Tape/Rule		
	3.	300		Steel Tape/Rule		
	4.	160		Steel Tape/Rule		
	5.	Emboss 7±1		Steel Tape/Rule		
5.8.1	Test on Finish Items		:			
	Sample Size: 10% of sample or test coupon per batch					
	Sr. No.	Dimensions Features	Acceptance Value	Defect Class	Remarks	AHSP intervention
	1.	Phosphating to IS 3618:1996	As specification Class A2	Major	Supplier shall submit the test report of the entire batch	
5.9	Details of any other information: Nil					

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6. SIDE HANDLE ASSEMBLY

6.1	Drawing No		:PROP/SK-845-14			
6.2	Method of manufacturing		:Sheet Metal			
	One set of the side handle assembly consist of following components and assembly					
	Sr. No.	Components	Drawing Number		Qty	
	1.	Side handle plate	PROP/SK-845-12		01	
	2.	Side handle	PROP/SK-845-13		01	
6.3	Raw material		:NA			
6.4	Test/Checks and acceptance Criteria for raw material: NA					
6.5	In-Process Inspection		:Nil			
6.6	Stage Inspection		:Nil			
6.7	Final Inspection:					
6.7.1	Visual Inspection :					
	Features for Visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level		AHSP intervention
	1.	No sharp edges	Ensured	Minor		Audit
	2.	All edges to be rounded	Ensured	Minor		
6.7.2	Dimensional Inspection					
6.7.2.1	Critical Dimensions		:Nil			
6.7.2.2	Geometrical Features		:Nil			
6.7.2.3	Major Dimensions		:Nil			
6.7.2.4	Minor Dimensions		:			
6.8.1	Test of Finish Items		:			
	Sample Size:10% of samples or test coupon per batch					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	Remark	AHSP intervention
	1.	Phosphating to IS 3618:1996	As specification Class A2	Major	Supplier shall submit the test report of the entire batch or sample	Audit
	2.	Free movement of handle	Movement of handle shall be normal	Major		Audit

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7. SIDE HANDLE PLATE

7.1	Drawing No	: PROP/SK-845-12				
7.2	Method of manufacturing	:Sheet Metal				
7.3	Raw material	:Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513 : 1993 reaffirmed 2003, any of Grade O/D/DD.				
7.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
7.5	In-Process Inspection	:Nil				
7.6	Stage Inspection	:Nil				
7.7	Final Inspection	:				
	Features for Visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor	SP	
7.7.2	Dimensional Inspection					
7.7.2.1	Critical Dimensions	:Nil				
7.7.2.2	Geometrical Features	:Nil				
7.7.2.3	Major Dimensions Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	90±2		GE	SP	
	2.	Thickness 2		Micrometre	SP	
7.7.2.4	Minor Dimensions Sample Size:100% by manufacture and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP intervention	
	1.	90		GE	SP	
7.8.1	Test on Finish Items	:				
	Sample Size: 10% of sample or test coupon per batch					
	Sr. No.	Dimensions Features	Acceptance Value	Defect Class	Remarks	AHSP intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch or sample	SP
7.9.1	Details of any other information: Nil					

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8. SIDE HANDLE

8.1	Drawing No	: PROP/SK-845-13				
8.2	Method of manufacturing	:Sheet Metal				
8.3	Raw material	: Hot Rolled Medium high Tensile Structure Steel to Spec IS 2062:2011, Grade E250.				
8.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
8.5	In-Process Inspection	:Nil				
8.6	Stage Inspection	:Nil				
8.7	Final Inspection	:				
8.8.1	Visual Inspection: Features for Visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor	SP	
8.8.2	Dimensional Inspection					
8.8.2.1	Critical Dimensions	:Nil				
8.8.2.2	Geometrical Features	:Nil				
8.8.2.3	Major Dimensions Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	130±2		Vernier Caliper	SP	
	2.	80±1		Vernier Caliper	SP	
	3.	Ø10		Vernier Caliper	SP	
8.8.2.4	Minor Dimensions: Nil					
8.8.1	Test on Finish Items	:				
	Sample Size: 10% of sample or test coupon per batch					
	Sr. No.	Dimensions Features	Acceptance Value	Defect Class	Remarks	AHSP intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch or sample	Audit
8.9.1	Details of any other information: Nil					

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9. TOP COVER ASSEMBLY

9.1	Drawing No	: PROP/SK-845-06			
9.2	Method of manufacturing	:Assembly and welding			
	One set of the top cover assembly consist of following components and assembly				
	Sr. No.	Components	Drawing Number	Qty	
	1.	Top Cover	PROP/SK-845-07	1	
	2.	Gasket 1	PROP/SK-845-11	2	
	3.	Gasket 2	PROP/SK-845-10	2	
	4.	Hook Holder Top plate	PROP/SK-845-15	2	
	5.	Hinge Assy	PROP/SK-845-09	2	
	6.	Top Cover Handle Assy	PROP/SK-845-16	1	
9.3	Raw material :	NA			
9.4	Test/Checks and acceptance Criteria for raw material:	NA			
9.5	In-Process Inspection	:Nil			
9.6	Stage Inspection	:Nil			
9.7	Final Inspection	:			
9.7.1	Visual Inspection	:			
	Features for Visual Inspection and acceptance Criteria: Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE				
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention
	1.	No sharp edges	Ensured	Minor	SP
	2.	All edges to be rounded	Ensured	Minor	SP
9.7.2	Dimensional Inspection				
9.7.2.1	Critical Dimensions	:Nil			
9.7.2.2	Geometrical Features	:Nil			
9.7.2.3	Major Dimensions :				
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention
	1.	750±3		GE	SP
	2.	405±2		GE	SP
	3.	26±2		GE	SP
9.7.2.4	Minor Dimensions: Nil				
9.8	Test on Finish Items : Nil				
9.9.1	Details of any other information: All the welded parts to be checked visually				

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10. TOP COVER

10.1	Drawing No		: PROP/SK-845-07			
10.2	Method of manufacturing		:Sheet metal			
10.3	Raw material		:Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513:1993, reaffirmed 2003, any of Grade O/D/DD			
10.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test certificated to be submitted by the manufacture as per specification.					
10.5	In-Process Inspection		:Nil			
10.6	Stage Inspection		:Nil			
10.7	Final Inspection :					
10.7.1	Visual Inspection:					
	Features for Visual Inspection and acceptance Criteria to be carried before the final welding. Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	No cut marks and tear	Ensured	Minor	SP	
10.7.2	Dimensional Inspection					
10.7.2.1	Critical Dimensions		:Nil			
10.7.2.2	Geometrical Features		:Nil			
10.7.2.3	Major Dimensions :					
	Sample size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	750±3		Steel Rule/Tape	SP	
	2.	405±2		Steel Rule/Tape	SP	
	3.	Thick 1.2+0.05		Steel Rule/Tape	SP	
	4.	26±2		Steel Rule/Tape	SP	
10.7.2.4	Minor Dimensions					
	Sample size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing zone	Inspection Method	AHSP Intervention	
	1.	105		Steel Tape/Rule	Audit	
	2.	260		Steel Tape/Rule	Audit	
	3.	545		Steel Tape/Rule	Audit	
10.8.0	Test on Finish Items		:			
	Sample Size: test coupon per batch					
	Sr. No.	Dimensions Features	Acceptance Value	Defect Class	Remarks	AHSP intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch or sample	Audit
10.8.1	Details of any other information: Nil					

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11. GASKET-1

11.1	Drawing No	: PROP/SK-845-11				
11.2	Method of manufacturing	:Molding				
11.3	Raw material	:EPDM Sponge				
11.4	Test/checks and acceptance Criteria for raw material: NABL test Certificates to be submitted by the manufacturer as per specification or certificates from Original manufacture (To be cleared on OEM certificate).					
	Sr. No.	Parameter	Acceptance criteria	AHSP Intervention		
	1.	Specific gravity	0.6 to 0.95	Audit		
	2.	Hardness shore A	28±5	Audit		
11.5	In-Process Inspection	:Nil				
11.6	Stage Inspection	:Nil				
11.7	Final Inspection	:				
11.7.1	Visual Inspection	:				
	Sample Size: 100% by manufacturer and AQL by AHSP/SQAE of order at random selection.					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	No cut marks and tear	Ensured	Minor	CP	
	2.	No foreign material	Ensured	Minor	CP	
3.	No swells	Ensured	Minor	CP		
11.7.2	Dimensional Inspection					
11.7.2.1	Critical Dimensions	:Nil				
11.7.2.2	Geometrical Features	:Nil				
11.7.2.3	Major Dimensions :					
	Sample size: 100% by manufacturer and AQL by AHSP/SQAE of order at random selection.					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	745±2		GE Method	SP	
2.	25±1		Template	SP		
3.	5		GE Method	SP		
11.7.2.4	Minor Dimensions: Nil					
11.8	Test on Finish Items : Nil					
11.8.1	Details of any other information: Nil					

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12. GASKET 2

12.1	Drawing No		: PROP/SK-845-10			
12.2	Method of Manufacturing		: Moulding			
12.3	Raw Material		: EPDM Sponge			
12.4	Test/Checks and acceptance Criteria for raw material: NABL test certificates to be submitted by the manufacture as per specification or Certificate from Original manufacture (to be cleared on OEM certificate).					
	Material properties :					
	Sr. No.	Parameter	Acceptance criteria	AHSP Intervention		
	1.	Specific Gravity	0.6 to 0.95	Audit		
	2.	Hardness Shore A	28 +5	Audit		
12.5	In – Process Inspection		:Nil			
12.6	Stage Inspection		: Nil			
12.7	Final Inspection:					
12.7.1	Visual Inspections :					
	Features for visual inspection and acceptance criteria-to be carried before the final welding. Sample Size : 100 % by manufacturer and AQL by AHSP/SQAE of order at random selection					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1	No cut marks and tear	Ensured	Minor	CP	
	2	No foreign materials	Ensured	Minor	CP	
	3	No swells	Ensured	Minor	CP	
12.7.2	Dimensional Inspection :					
12.7.2.1	Critical Dimensions		: Nil			
12.7.2.2	Geometrical Features		: Nil			
	Major Dimensions Sample Size : 100 % by manufacturer and AQL by AHSP/SQAE of order at random selection					
	Sr. no.	Dimension/ Features	Drg. Zone	Inspection Method	AHSP Intervention	
	1.	349+1		G E Method	SP	
	2.	25+1		G E	SP	
	12.7.2.3	3.	5		GE	
	Minor Dimensions		: Nil			
	Test on Finish Items		: Nil			
	Details of any other information : Nil					

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13. HOOK HOLDER TOP PLATE

13.1	Drawing No		: PROP/SK-845-15			
13.2	Method of Manufacturing		: Sheet Metal/Machining			
13.3	Raw Material		: Cold Rolled Low Carbon Steel sheets and strips- Specification to IS 513:1993, reaffirmed 2003, any of Grade O/D/DD.			
13.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test certificates to be submitted by the manufacture as per specification.					
13.5	In-Process Inspection		: Nil			
13.6	Stage Inspection		: Nil			
13.7	Final Inspection		:			
13.7.1	Visual Inspections		:			
	Features for visual inspection and acceptance criteria-to be carried before the final welding. Sample Size : 100 % by Manufacturer and as per AQL by SQAE/AHSP					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	No sharp edges	Ensured	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor	SP	
13.7.2	Dimensional Inspection					
13.7.2.1	Critical Dimensions		: Nil			
13.7.2.2	Geometrical Features		: Nil			
13.7.2.3	Major Dimensions: Sample size : 100% by Manufacturer and as per AQL by SQAE/AHSP					
	Sr. No.	Dimensions/ Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	58.5 \pm 2		Vernier Caliper	SP	
13.7.2.4	Minor Dimensions : Sample Size : 100 % by Manufacturer and as per AQL by SQAE/AHSP					
	Sr. No.	Dimensions/ Features	Drawing zone	Inspection Methods	AHSP Intervention	
	1.	Thickness 2		Vernier Caliper	SP	
13.7.3	Test on Finish Items		: Nil			
	Sample Size : 10% or Test coupon per batch					
	Sr. No.	Dimensions/ Features	Acceptance criteria	Defect class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification class A2	Major	Supplier shall submit the test report of the entire batch	Audit
13.7.4	Details of any other information		: Nil			

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14. TOP COVER HANDLE ASSEMBLY

14.1	Drawing No		: PROP/SK-845-16			
14.2	Method of Manufacturing		: Assembly			
	One set of the top cover handle assembly consist of following components and assembly					
	Sr. No.	Component /Assembly	Drawing No.		Quantity	
	1	Top cover handle plate	PROP/SK-845-17			
	2	Top cover handle	PROP/SK-845-08			
14.3	Raw Material		Nil			
14.4	Test / checks and acceptance criteria for raw material : NA					
14.5	In Process Inspection		Nil			
14.6	Stage Inspection		Nil			
14.7	Final Inspection :					
14.7.1	Visual Inspection					
	Features for visual inspection and acceptance criteria to be carried before the final welding Sample size : 100 % by Manufacturer and as per AQL by SQAE/ AHSP					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	Damage of the outer surface	Not Accepted	Major	SP	
	2.	No sharp edges	Ensured	Major	SP	
14.7.2	Dimensional Inspection					
14.7.2.1	Critical Dimension		: Nil			
14.7.2.2	Geometrical features		: Nil			
14.7.2.3	Major Dimensions : Nil					
14.7.2.4	Minor Dimensions		: Nil			
14.8.0	Test on finish items		: Nil			
	1. Check the proper movement of the handle					
14.8.1	Details of any other information			: Nil		

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15. TOP COVER HANDLE PLATE

15.1	Drawing No		: PROP/SK-845-17			
15.2	Method of Manufacturing		: Sheet Metal/Machining			
15.3	Raw material		: Cold Rolled low Carbon steels and strips specification to IS 513 : 1993, reaffirmed 2003, any of Grade O/D/DD			
15.4	Test/checks and acceptance criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test certificate to be submitted by the manufacture as per specification					
15.5	In process inspection		Nil			
15.6	Stage Inspection		Nil			
15.7	Final Inspection					
15.7.1	Visual inspections :					
	Features for visual inspection and acceptance criteria to be carried before the final welding. Sample size : 100 % by Manufacturer and as per AQL by SQA/ AHSP					
	Sr. No.	Features	Criteria	Defect level	AHSP Intervention	
	1.	Sharp edges	Not accepted	Minor	SP	
	2.	All edges to be rounded	Ensured	Minor	SP	
15.7.2	Dimensional Inspection					
15.7.2.1	Critical Dimension		: Nil			
15.7.2.2	Geometrical features		: Nil			
15.7.2.3	Major Dimensions: Sample size : Tool report to be submitted by vendor					
	Sr. no.	Dimension/ Features	Drawing zone	Inspection method	AHSP Intervention	
	1.	85 \pm 2		GE method	SP	
	2.	Thickness 1.2			SP	
15.7.2.4	Minor Dimensions		: Nil			
	Sr. no.	Dimensions	Drawing zone	Inspection Method	AHSP Intervention	
	1	23		GE	Audit	
15.8.0	Test on finish items: Sample size : Test coupon per batch					
	Sr.no.	Dimensions/Features	Acceptance criteria	Defect class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification class A2	Major	Supplier shall submit the test report of the entire batch	Audit
15.8.1	Details of any information		:Nil			

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16. TOP COVER HANDLE

16.1	Drawing No		: PROP/SK-845-08			
16.2	Method of Manufacturing		: Sheet Metal/Machining			
16.3	Raw material		: Hot Rolled medium and high tensile structural steel to IS 2062:2011, Grade E 250			
16.4	Test/checks and acceptance criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test certificate to be submitted by the manufacture as per specification					
16.5	In process inspection				Nil	
16.6	Stage Inspection				Nil	
16.7	Final Inspection					
16.7.1	Visual inspections :					
	Sample size : 100 % by Manufacturer and as per AQL by SQAE/ AHSP					
	Sr. no.	Features	Criteria	Defect level	AHSP Intervention	
	1	No cut marks, sharp edges	Not present	minor	SP	
16.7.2	Dimensional Inspection					
16.7.2.1	Critical Dimension		: Nil			
16.7.2.2	Geometrical features		: Nil			
16.7.2.3	Major Dimensions: Sample size : 100 % by manufacturer and as per AQL by SQAE/ AHSP					
	Sr. no.	Dimension/ Features	Drawing zone	Inspection method	AHSP Intervention	
	1.	106 \pm 2		Vernier/steel rule	SP	
	2.	60 \pm 2		Vernier/steel rule		
16.7.2.4	Sample size : Test coupon per batch			:Nil		
16.8.0	Test on Finish Items			:Nil		
	Sr.no.	Dimensions/ Features	Acceptance criteria	Defect class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification class A2	Major	Supplier shall submit the test report of the entire batch	Audit
16.8.1	Details of any other information : Nil					

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17. HINGE ASSEMBLY

17.1	Drawing No.		: PROP/SK-845-09			
17.2	Method of Manufacturing		: STD Assembly : steel butt hinge as per IS : 1341 size 75mm as per table 3			
17.3	Raw Material		: MS			
17.4	Test/checks and acceptance criteria for raw material :					
17.5	In- Process Inspection		Nil			
17.6	Stage Inspection		Nil			
1.7	Final Inspection					
17.7.1	Visual Inspections					
	Features for visual inspection and acceptance criteria to be carried before the final welding Sample size :100 % by Manufacturer and as per AQL by SQAE/AHSP					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	Damage of any surface	Not accepted	Major	SP	
	3.	Sharp edges Not Accepted	Not accepted	Minor	SP	
17.7.2	Dimensional Inspection :					
17.7.2.1	Critical Dimensions		: Nil			
17.7.2.2	Geometrical Features		: Nil			
1.7.2.3	Major Dimension : Nil					
	Sr. no	Dimensions/ Features	Drawing zone	Inspection Method	AHSP Intervention	
	1	75		Vernier	SP	
17.7.2.4	Minor Dimension		Nil			
17.8.0	Test on finish items :					
	1. Check for the free movement of the hinge assembly.					
17.8.1	Details of any other information		: Nil			

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18. FOAM TOP

18.1	Drawing No.	: PROP/SK-845-18			
18.2	Method of Manufacturing	: Moulding/Cutting in moulding shape			
18.3	Raw Material	: PU or Antistatic Expanded polyethylene Foam as per specification IND/ME/913 (a)Provisional : 2004			
18.4	Test / Checks and acceptance Criteria for raw material: NABL test Certificates to be submitted by the manufacture as per specification or Certificate from original manufacture (to be cleared on OEM certificate).				
	Sr. No.	Parameter	Acceptance criteria	AHSP Intervention	
	1.	Density	30 \pm kg/m ³	Audit	
18.5	In-process Inspection				Nil
18.6	Stage Inspection				Nil
18.7	Final Inspection				
18.7.1	Visual Inspection				
	Features for visual inspection and acceptance criteria to be carried before the final welding. Sample Size : 100 % by manufacture and as AQL by AHSP/SQAE				
	Sr. No.	Features	Criteria	Defect level	AHSP Intervention
	1	No cut marks and tear	Ensured	Minor	SP
	2.	No foreign materials	Ensured	Minor	SP
	3.	No swells	Ensured	Minor	SP
	4.	No De-lamination	Ensured	Minor	SP
18.7.2	Dimensional Inspection				
18.7.2.1	Critical Dimension	: Nil			
18.7.2.2	Geometric Features	: Nil			
18.7.2.3	Major Dimensions : Nil				
18.7.2.4	Minor Dimension				
	Sample Size : 100 % By manufacturer and as per AQL by AHSP/SQAE				
	Sr. No.	Dimensions/ Features	Drawing zone	Inspection Method	AHSP Intervention
	1.	730 \pm 2		Steel rule	SP
	2.	380 \pm 2		Steel Rule	SP
	3.	Ø 120		GE	SP
	4.	Ø184.5		GE	SP
5.	440 \pm -2		Steel rule	SP	
18.8.0	Test On finish items				
18.8.1	Details of any other information :				
	a) Fitment check using LP container: e) Al foil thickness min 25 micron to be wrapped around the foam with proper adhesion.				

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19. FOAM BOTTOM

19.1	Drawing No.	: PROP/SK-845-19				
19.2	Method of Manufacturing	: Moulding/Cutting in moulding shape				
19.3	Raw Material	: PU or Antistatic Expanded polyethylene Foam as per specification IND/ME/913 (a)Provisional : 2004				
19.4	Test / Checks and acceptance Criteria for raw material: NABL test Certificates to be submitted by the manufacture as per specification or Certificate from original manufacture (to be cleared on OEM certificate).					
	Sr. No.	Parameter	Acceptance criteria	AHSP Intervention		
	1.	Density	30 \pm 5 kg/m ³	Audit		
19.5	In-process Inspection				Nil	
19.6	Stage Inspection				Nil	
19.7	Final Inspection					
19.7.1	Visual Inspection					
	Sample Size : 100 % by manufacture and as AQL by AHSP/SQAE					
	S.N.	Features	Criteria	Defect level	AHSP Intervention	
	1	No cut marks and tears	Ensured	Minor	SP	
	2.	No foreign materials	Ensured	Minor	SP	
	3.	No swells	Ensured	Minor	SP	
19.7.2	Dimensional Inspection					
	19.7.2.1	Critical Dimension				: Nil
19.7.2.2	Geometric Features				: Nil	
19.7.2.3	Major Dimensions : Nil					
19.7.2.4	Minor Dimension					
	Sample Size : 100 % By manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/ Features	Drawing zone	Inspection Method	AHSP Intervention	
	1.	730 \pm 2		Steel rule	SP	
	2.	380 \pm 2		Steel Rule	SP	
	3.	440 \pm 2		GE	SP	
	4.	120 \pm 2		GE		
	5.	Ø 120		GE		
6.	Ø 184.5		GE			
19.8.0	Test On finish items					
	a) Fitment check using LP container: b) Al foil thickness min 25 micron to be wrapped around the foam with proper adhesion.					

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20. LIMIT BAR

20.1	Drawing No.	: PROP/SK-845-20				
20.2	Method of Manufacturing	: STD BAR or Machining				
20.3	Raw Material	: Hot Rolled Medium and High Tensile structural steel to IS 2062 : 2011, Grade E 250				
20.4	Test / Checks and acceptance Criteria for raw material: Chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
20.5	In-process Inspection	Nil				
20.6	Stage Inspection	Nil				
20.7	Final Inspection					
20.7.1	Visual Inspection					
	Features for visual inspection and acceptance criteria to be carried before the final welding. Sample Size : 100 % by manufacture and as AQL by AHSP/SQAE					
	S.N.	Features	Criteria	Defect level	AHSP Intervention	
	1	No sharp edges	Ensured	Minor	SP	
20.7.2	Dimensional Inspection					
20.7.2.1	Critical Dimension	: Nil				
20.7.2.2	Geometric Features	: Nil				
20.7.2.3	Major Dimensions : Nil					
20.7.2.4	Minor Dimension					
	Sr. No.	Dimensions/ Features	Drawing zone	Inspection Method	AHSP Intervention	
	1.	125		GE	Audit	
	2.	10		GE	Audit	
20.8.0	Test On finish items	: Sample size : Test coupon per batch				
	Sr. No.	Dimensions/ Features	Acceptance criteria	Defect Class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification class	Major	Supplier shall submit the test report of the entire batch	Audit
20.8.1	Details of any other information : Nil					

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21. HOOK ASSEMBLY

21.1	Drawing No.		: PROP/SK-845-21			
21.2	Method of Manufacturing		: Assembly			
21.2.1	One set of the steel package assembly consist of following components and assembly					
	Sr. No.	Component/Assembly	Drawing No.			Qty.
	1.	Hook base plate	PROP/SK-845-22			01
	2.	Hook pin	PROP/SK-845-24			01
	3.	Hook Handle	PROP/SK-845-23			01
	4.	Hook Link	PROP/SK-845-25			01
21.3	Raw Material		: NA			
21.4	Test/Checks and acceptance Criteria for raw material : NA					
21.5	In-process Inspection		Nil			
21.6	Stage Inspection		Nil			
21.7	Final Inspection :					
21.7.1	Visual Inspections :					
	Sample size : 100 % by manufacturer and as per AQL by AHSP/ SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention	
	1.	No sharp edges	Ensured	Minor	SP	
21.7.2	Dimensional Inspection					
21.7.2.1	Critical Dimension		: Nil			
21.7.2.2	Geometrical Features		: Nil			
21.7.2.3	Major Dimensions : Nil					
21.7.2.4	Minor Dimensions : Nil					
21.8.0	Test On finish items : Nil					
21.8.1	Details of any other information			: Nil		

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22. HOOK BASE PLATE

22.1	Drawing No		: PROP/SK-845-22			
22.2	Method of manufacturing		:Forming/machining			
22.3	Raw material		:Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513 : 1993 reaffirmed 2003, any of Grade O/D/DD.			
22.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
22.5	In-Process Inspection		:Nil			
22.6	Stage Inspection		:Nil			
22.7	Final Inspection :					
22.7.1	Visual Inspections					
	Features for Visual Inspection and acceptance Criteria to be carried before the welding. Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
22.7.2	Dimensional Inspection					
22.7.2.1	Critical Dimensions		:Nil			
22.7.2.2	Geometrical Features		:Nil			
22.7.2.3	Major Dimensions : Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	60		Vernier Caliper	SP	
	2.	20		Vernier Caliper	SP	
	3.	15		GE	SP	
	4.	Thickness 2		GE	SP	
	5.	Ø5		GE	SP	
22.7.2.4	Minor Dimensions		:Nil			
22.8.0	Test on Finish Items :					
	Sample size: Test coupon per batch					
	Sr. No.	Dimensions/Features	Acceptance criteria	Defect Class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch	Audit
7.9.1	Details of any other information: Nil					

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23. HOOK HANDLE

23.1	Drawing No	: PROP/SK-845-23				
23.2	Method of manufacturing	:Forming/Sheet metal				
23.3	Raw material	:Cold Rolled Low Carbon Steel sheets and strips- specification to IS 513 : 1993 reaffirmed 2003, any of Grade O/D/DD.				
23.4	Test/Checks and acceptance Criteria for raw material: Chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
23.5	In-Process Inspection	:Nil				
23.6	Stage Inspection	:Nil				
23.7	Final Inspection	:				
23.7.1	Visual Inspections					
	Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
23.7.2	Dimensional Inspection					
23.7.2.1	Critical Dimensions	:Nil				
23.7.2.2	Geometrical Features	:Nil				
23.7.2.3	Major Dimensions : Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	24.5		Vernier Caliper	SP	
	2.	67		Vernier Caliper	SP	
	3.	Ø5.2		Vernier Caliper	SP	
	4.	Thick 2		Vernier	SP	
23.7.2.4	Minor Dimensions	:Nil				
23.8.0	Test on Finish Items	:				
	Sample size: 10% or Test coupon per batch					
	Sr. No.	Dimensions/Features	Acceptance criteria	Defect Class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch	Audit
23.8.1	Details of any other information: Nil					

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24. HOOK PIN

24.1	Drawing No	: PROP/SK-845-24				
24.2	Method of manufacturing	:Machining				
24.3	Raw material	:Hot Rolled Medium and High Tensile structure steel to IS 2026 :2011, Grade E 250				
24.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and Chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
24.5	In-Process Inspection	:Nil				
24.6	Stage Inspection	:Nil				
24.7	Final Inspection	:				
24.7.1	Visual Inspections					
	Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Major	SP	
24.7.2	Dimensional Inspection					
24.7.2.1	Critical Dimensions		:Nil			
24.7.2.2	Geometrical Features		:Nil			
24.7.2.3	Major Dimensions : Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	26		Vernier Caliper	SP	
	2.	Ø4		Vernier Caliper	SP	
24.7.2.4	Minor Dimensions		:Nil			
24.8.0	Test on Finish Items		:Nil			
24.8.1	Details of any other information: Nil					

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25. HOOK LINK

25.1	Drawing No		:PROP/SK-845-25			
25.2	Method of manufacturing		:Sheet metal			
25.3	Raw material		:Hot Rolled Medium and High Tensile structure steel to IS 2026 :2011, Grade E 250			
25.4	Test/Checks and acceptance Criteria for raw material: Mechanical properties and Chemical composition of the material to be checked as per above specification and NABL test Certificates to be submitted by the manufacture as per specification.					
25.5	In-Process Inspection		:Nil			
25.6	Stage Inspection		:Nil			
25.7	Final Inspection :					
25.7.1	Visual Inspections Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Features	Criteria	Defect Level	AHSP intervention	
	1.	No sharp edges	Ensured	Minor	SP	
25.7.2	Dimensional Inspection					
25.7.2.1	Critical Dimensions		:Nil			
25.7.2.2	Geometrical Features		:Nil			
25.7.2.3	Major Dimensions : Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	64		Vernier Caliper	SP	
	2.	Ø4		Micrometre	SP	
25.7.2.4	Minor Dimensions		:Nil			
25.8.0	Test on Finish Items		:			
	Sr. No.	Dimensions/Features	Acceptance criteria	Defect class	Remarks	AHSP Intervention
	1.	Phosphating to IS 3618	As specification Class A2	Major	Supplier shall submit the test report of the entire batch	SP
25.8.1	Details of any other information: Nil					

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26. LP CONTAINER ASSEMBLY PRIMARY

26.1	Drawing No			: PROP/SK-845-26		
26.2	Method of Manufacturing			: Assembly		
26.2.1	One set of Laminated Paper Container Assembly Primary consist of following components and Assemblies					
	Sr. No.	Components	Drawing number	Qty		
	1.	Sleeve lid sub assembly primary	PROP/SK-845-27	1		
	2.	Sleeve sub assembly primary	PROP/SK-845-30	1		
26.3	Raw Material : Nil					
26.4	Test/Checks and Acceptance Criteria for Raw Material : Nil					
26.5	In-Process Inspection			: Nil		
26.6	Stage Inspection			: Nil		
26.7	Final Inspection			:		
26.8	Visual Inspection			:		
26.8.1	Features For visual inspection and acceptance criteria					
	Sr. No.	Acceptance Criteria	Sample size	Defect Class		
	1.	No cut marks and tear	100%	Major		
	2.	No any foreign materials and lump sticks on inner and outer surfaces	100%	Major		
	3.	No swells	100%	Major		
	4.	No De-lamination	100%	Major		
26.8.2	Dimensional Inspection					
26.8.2 .1.	Critical Dimensions			: Nil		
26.8.2 .2.	Geometrical Features			: Nil		
26.8.2 .3.	Major Dimensions :					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method		
	1.	437.5±3mm		Steel Rule		
	2.	Ø181±2		Vernier		
26.8.2 .4	Minor Dimensions			: Nil		
26.9.1	Test on Finish Items			:		
	Details of test/checks on finished items, Acceptance criteria and other information					
	Sr. No.	Test/Check				
	1	LP Container Fitment Check (Major Defect) Sample Size: 20% or 10 no's whichever is more per lot during manufacture Acceptance Criteria Dummy round shall be accommodated in LP container satisfactorily				
	2	Pull of Test: (Major Defect) Sample Size: 3 nos per lot Method:				

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		<p>The test shall be performed on metal ends of the cover and the body assembly. The assembly shall be prepared for test by cutting the body tube 200mm from metal end and extracting all components parts where necessary, from the cover test may be performed on tensile testing machine of in static arrangement. To determine the load parallel to centreline of the specimen. When using the tensile testing machine the rate of travel of head shall not exceed 0.6mm per minute.</p> <p>Acceptance Criteria : 250 kg (minimum)</p>
	3.	<p>Crushing Test: (Major Defect) Sample Size: 3 nos per lot Method: Cut the container in such a manner as to obtain circular rings representing maximum and where possible 4 intermediate wall thickness. The width of the ring should be approximately 20mm for minimum and 40mm for higher thickness, cut the faces of the ring smooth and parallel. Calculate the cross section area of the ring. Gradually apply an axial compressive load on the ring by any suitable device record the load at which the ring starts crumbling. Calculate the stress value by dividing the above load by area of cross section of the ring, the stress value should not be less than 50kg/cm²</p>
	4.	<p>Drop Test: - for information only Sample Size: 01 minimum and Maximum 03 no's Method: The Container along with suitable package shall be held vertically with low end, kept at a height of 1.5 m from a concrete or steel surface and shall be released to fall freely. Repeat the operation by placing opposite end above 1.5m concrete or steel surface. Observation shall be made for loose or misplaced parts. The drop test shall be carried with filled round assembled with dummy primer and suitable package.</p> <p>Observations:</p> <ul style="list-style-type: none"> a. Any damage to CCC b. Loose CC and Steel cup c. Damage to steel cup <p>Any damage to outer package and LP container to be noted for information and future corrective action (Minor Defect if store found ok otherwise major defect)</p>
	4.	<p>WATERPROOFNESS (Major Defect) The six containers shall be conditioned at ambient condition (23 to 25 °C) for 4 hours. A known mass of 200kg of silica gel in cotton bag shall be placed in each container and in turn the containers shall be properly sealed as specified in the method of pack. The 3 drop test containers and 2 untested containers shall then be tested by total immersion 25mm below the surface of water at a temperature of 4°C for 15 minutes. The remaining sample shall be held as control specimen. After removal from the water, all containers shall be opened and inspected for moisture. The absorption of moisture shall be calculated by checking the initial and final weight of silica gel before and after the end of test.</p> <p>% of moisture of test specimen = (Final weight – Initial weight)/Initial weight % of moisture of controlled specimen = (Final weight – Initial weight)/Initial weight</p> <p>The percentage increase shall not exceed that of control sample. Failure to meet this test shall cause for rejection of represented lot.</p>

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26.10	Other Information	:
26.10.1	Adhesive	:
	Adhesive used in L.P. Container assembly is synthetic resin emulsion based adhesive P LAM Super bond adhesive	

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27.SLEEVE LID SUB ASSEMBLY PRIMARY

27.1	Drawing No	: PROP/SK-845-27				
27.2	Method of Manufacturing	: Assembly				
27.2.1	One set of Lid sub assembly consist of following components					
	Sr. No.	Components	Drawing number	Qty		
	1.	Sleeve lid outer primary	PROP/SK-845-28	1		
	2.	Washer millboard I	PROP/SK-845-36	1		
	3.	End cap primary	PROP/SK-845-31	1		
27.3	Raw Material	: Nil				
27.4	Test/Checks and Acceptance Criteria for Raw Material	: Nil				
27.5	In-Process Inspection	: Nil				
27.6	Stage Inspection	: Nil				
27.7	Final Inspection	:				
27.8	Visual Inspection	:				
27.8.1	Features for visual inspection and acceptance criteria Sample 100% by factory/manufacturing QC as per AQL by AHSP					
	Sr. No.	Acceptance Criteria	Defect Class	AHSP Intervention		
	1.	No cut marks and tear	Major	Audit		
	2.	No any foreign materials and lump sticks on inner and outer surfaces	Major			
	3.	No swells	Major			
	4.	No De-lamination	Major			
27.8.2	Dimensional Inspection					
27.8.2 .1.	Critical Dimensions	: Nil				
27.8.2 .2.	Geometrical Features	: Nil				
27.8.2 .3.	Major Dimensions					
	Sr. No.	Dimensions/ Features	Drawing Zone	Inspection Method		
	1.	117		GE Method		
	2.	104		GE Method		
27.8.2 .4	Minor Dimensions	: Nil				
27.9.1	Test on Finish Items	: Nil				
27.10	Other Information	: Nil				
	a) Cap end to be secured by spinning curled edge into sleeve lid outer using araldite b) araldite to be applied in the channel of the cap end immediately after spinning					
27.10.1	Adhesive	: Adhesive used in L.P. Container assembly is synthetic resin emulsion based adhesive : P LAM super bond adhesive				

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28.SLEEVE LID OUTER PRIMARY

28.1	Drawing No		: PROP/SK-845-28			
28.2	Method of Manufacturing		: Integration/Lamination			
28.3.0	Raw Material		: Kraft board/paper			
28.3.1	Test/Checks and Acceptance Criteria for Raw Material		: NABL test Certificate to be submitted by the manufacture as per specification or, Original manufacturers Certificate or Test at vendors place with calibrated equipments			
28.3.2	Mechanical Properties		:			
28.3.2	Sr. No.	Mechanical Properties	Acceptance Criteria		AHSP Intervention	
	1.	Grade and GSM (g/m ²)	(300-450)±7%		CP	
	2.	Density(g/cm ³)	0.742 ± 7%			
	3.	Average Ply bond(J/m ²)	650 ±7%			
	4.	Cobb g/m ²	208 ±7%			
	5.	Moisture Content(%)	7.2 ±7%			
28.4	In-Process Inspection		: Nil			
28.5	Stage Inspection		: Nil			
28.6	Final Inspection		:			
28.6.1	Visual Inspection		:			
28.6.1	Features for visual inspection and acceptance criteria					
.1	Sample 100% by factory/manufacturing QC as per AQL by AHSP					
28.6.1	Sr. No.	Acceptance Criteria		Defect Class	AHSP Intervention	
	1.	No cut marks and tear		Major	CP	
	2.	No any foreign materials and lump sticks on inner and outer surfaces		Major		
	3.	No swells		Major		
	4.	No De-lamination		Major		
28.6.2	Dimensional Inspection					
28.6.2	Critical Dimensions		: Nil			
.1						
28.6.2	Geometrical Features		: Nil			
.2						
28.6..	Major Dimensions					
2.3.	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method		AHSP Intervention
	1.	Ø181+1		GE Method		SP
	2.	Ø174+1		GE Method		
	3.	117±1		GE Method		
28.6.2	Minor Dimensions		: Nil			
.4						
28.7.0	Protective Finish:					
	To be coated externally with two coats of polyurethane coating paper.					
28.8.0	Other Information		: Nil			

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29.WASHER MILLBOARD I

29.1	Drawing No			:PROP/SK-845-36		
29.2	Method of Manufacturing			: Cutting/Punching		
29.3.0	Raw Material			:Mill board/paper		
29.3.1	Test/Checks and Acceptance Criteria for Raw Material			: To check properties for information only		
	Sr. No.	Mechanical Properties	Acceptance Criteria	AHSP Intervention		
	1.	Grade and GSM (g/m ²)	(300-450)±7%	Audit		
	2.	Density(g/cm ³)	0.742 ± 7%			
	3.	Average Ply bond(J/m ²)	650 ±7%			
	4.	Cobb g/m ²	208 ±7%			
5.	Moisture Content(%)	7.2 ±7%				
29.4	In-Process Inspection			: Nil		
29.5	Stage Inspection			: Nil		
29.6	Final Inspection			:		
29.6.1	Visual Inspection			:		
29.6.1 .1	Features for visual inspection and acceptance criteria Sample 100% by factory/manufacturing QC as per AQL by AHSP					
	Sr. No.	Acceptance Criteria	Defect Class	AHSP Intervention		
	1.	No cut marks and tear	Major	SP		
	2.	No any foreign materials and lump sticks on inner and outer surfaces	Major	SP		
	3.	No swells	Major	SP		
29.6.2 .1	Dimensional Inspection					
	Critical Dimensions			: Nil		
29.6.2 .2	Geometrical Features			: Nil		
	Major Dimensions					
29.6.. 2.3.	Sample : Sample Size : 100% by factory QC and as per AQL by AHSP					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Ø174+1		GE Method	SP	
	2.	Ø60+1		GE Method	SP	
29.6.2 .4	Minor Dimensions			: Nil		
	Protective Finish:			: Nil		
29.7.0	To be coated externally with two coats of polyurethane coating paper.					
	Any Other Information			: Nil		

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30.END CAP PRIMARY

30.1	Drawing No		: PROP/SK-845-31			
30.2	Method of Manufacturing		: Sheet Metal Operation			
30.3.0	Raw Material		:Cold Rolled Low Carbon Steel sheets and strips Specification to IS 513 : 1993, reaffirmed 203, any of grade O/D/DD.			
30.3.1	Test/Checks and Acceptance Criteria for Raw Material		: NABL test Certificates to be submitted by the manufacture as per specification or Original manufactures Certificate			
30.3.2	Chemical Composition		: As per Specification (For information only)			
30.4	In-Process Inspection		: Nil			
30.5	Stage Inspection		: Nil			
30.6	Final Inspection		:			
30.6.1	Visual Inspection		:			
30.6.1	Features For visual inspection and acceptance criteria					
.1	Sr. No.	Acceptance Criteria	Sample Size	Defect Class		
	1.	No Cracks	100%	Major		
	2.	No sharp Edges	100%	Major		
30.6.2	Dimensional Inspection					
30.6.2 .1	Critical Dimensions		: Nil			
30.6.2 .2	Geometrical Features		: Nil			
30.6.2 .3	Major Dimensions					
	Sample 100% by factory/manufacturing QC and as per AQL by AHSP					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Ø184.5-1		GE Method	SP	
	2.	Ø175+1		GE Method	SP	
	3.	Sheet Thickness 1mm		GE Method	SP	
	4.	Ø57		GE Method	SP	
30.6.2 .4	Minor Dimensions		: Nil			
30.7.0	Protective Finish:					
	1. Phosphating to specification IS 1279, Class II					
	2. Polyester powder coating of 60-80 micron					
30.8.0	Any Other Information		: Nil			
	Embossing/Painting: Font Size 20mm, font type: Aerial and colour glossy yellow "125MM HE - RESIN CCC" Recognized trade mark Date of manufacture (MM/YYYY)					
	Pull of load 250kg minimum					

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31.SLEEVE SUB ASSEMBLY PRIMARY

31.1	Drawing No : PROP/SK-845-30				
31.2	Method of Manufacturing				: Assembly
31.2.1	One set of sleeve sub assembly consist of following components				
	Sr. No.	Components	Drawing number	Qty	
	1.	End cap primary	PROP/SK-845-31	1	
	2.	Sleeve inner primary	PROP/SK-845-32	1	
	3.	Sleeve outer primary	PROP/SK-845-33	1	
	4.	Sleeve inner 2 primary	PROP/SK-845-29	1	
	5.	Paper disc primary	PROP/SK-845-34	1	
31.3	Raw Material : Nil				
31.4	Test/Checks and Acceptance Criteria for Raw Material : Nil				
31.5	In-Process Inspection				: Nil
31.6	Stage Inspection				: Nil
31.7	Final Inspection				:
31.8	Visual Inspection				:
31.8.1	Features for visual inspection and acceptance criteria Sample 100% by factory/manufacturing QC as per AQL by AHSP				
	Sr. No.	Acceptance Criteria	Defect Class	AHSP Intervention	
	1.	No cut marks and tear	Major	Audit	
	2.	No any foreign materials and lump sticks on inner and outer surfaces	Major		
	3.	No swells	Major		
	4.	No De-lamination	Major		
31.8.2	Dimensional Inspection				
31.8.2 .1.	Critical Dimensions				: Nil
31.8.2 .2.	Geometrical Features				: Nil
31.8.2 .3.	Major Dimensions				
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention
	1.	96.5		GE Method	SP
	2.	318.50		GE Method	
	3.	Ø 161.50		GE Method	
	4.	Ø 181		GE Method	
	5.	Ø 174		GE Method	
31.8.2 .4	Minor Dimensions				: Nil
31.9.1	Test on Finish Items				: Nil
31.10	Other Information				:
	a) Cap end to be secured by spinning curled edge into sleeve lid outer using araldite b) araldite to be applied in the channel of the cap end immediately after spinning				
31.10.1	Adhesive : Adhesive used in L.P. Container assembly is synthetic resin emulsion based adhesive : P LAM super bond adhesive				

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32. SLEEVE INNER PRIMARY

32.1	Drawing No		: PROP/SK-845-32			
32.2	Method of Manufacturing		: Integration /Lamination			
32.3.0	Raw Material		:Kraft board/paper			
32.3.1	Test/Checks and Acceptance Criteria for Raw Material		: NABL test Certificates to be submitted by the manufacture as per specification or Original manufactures Certificate or Test at vendors place with calibrated equipments			
32.3.2	Mechanical Properties		:			
	Sr. No.	Mechanical Properties	Acceptance Criteria		AHSP Intervention	
	1.	Grade and GSM (g/m ²)	(300-450)±7%		CP	
	2.	Density(g/cm ³)	0.742 ± 7%			
	3.	Average Ply bond(J/m ²)	650 ±7%			
	4.	Cobb g/m ²	208 ±7%			
	5.	Moisture Content(%)	7.2 ±7%			
32.4	In-Process Inspection		: Nil			
32.5	Stage Inspection		: Nil			
32.6	Final Inspection		:			
32.6.1	Visual Inspection		:			
32.6.1.1	Features for visual inspection and acceptance criteria Sample 100% by factory/manufacturing QC as per AQL by AHSP					
	Sr. No.	Acceptance Criteria	Defect Class	AHSP Intervention		
	1.	No cut marks and tear	Major	SP		
	2.	No any foreign materials and lump sticks on inner and outer surfaces	Major			
	3.	No swells	Major			
	4.	No De-lamination	Major			
32.6.2	Dimensional Inspection					
32.6.2.1	Critical Dimensions		: Nil			
32.6.2.2	Geometrical Features		: Nil			
32.6..	Major Dimensions					
2.3.	Sample : Sample Size : 100% by factory QC and as per AQL by AHSP					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Ø174-1		GE	SP	
	2.	Ø161.5		GE	SP	
	3.	406		GE	SP	
32.6.2.4	Minor Dimensions		: Nil			
32.7.0	Protective Finish:		: Nil			
32.8.0	Any Other Information		: Nil			

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33. SLEEVE OUTER PRIMARY

33.1	Drawing No		: PROP/SK-845-33			
33.2	Method of Manufacturing		: Integration /Lamination			
33.3.0	Raw Material		:Kraft board/paper			
33.3.1	Test/Checks and Acceptance Criteria for Raw Material		: NABL test Certificates to be submitted by the manufacture as per specification or Original manufactures Certificate or Test at vendors place with calibrated equipments			
33.3.2	Mechanical Properties		:			
	Sr. No.	Mechanical Properties	Acceptance Criteria		AHSP Intervention	
	1.	Grade and GSM (g/m ²)	(300-450)±7%		CP	
	2.	Density(g/cm ³)	0.742 ± 7%			
	3.	Average Ply bond(J/m ²)	650 ±7%			
	4.	Cobb g/m ²	208 ±7%			
	5.	Moisture Content(%)	7.2 ±7%			
33.4	In-Process Inspection		: Nil			
33.5	Stage Inspection		: Nil			
33.6	Final Inspection		:			
33.6.1	Visual Inspection		:			
33.6.1	Features for visual inspection and acceptance criteria					
.1	Sample 100% by factory/manufacturing QC as per AQL by AHSP					
	Sr. No.	Acceptance Criteria	Defect Class	AHSP Intervention		
	1.	No cut marks and tear	Major	SP		
	2.	No any foreign materials and lump sticks on inner and outer surfaces	Major			
	3.	No swells	Major			
	4.	No De-lamination	Major			
33.6.2	Dimensional Inspection					
33.6.2	Critical Dimensions		: Nil			
.1						
33.6.2	Geometrical Features		: Nil			
.2						
33.6.2	Major Dimensions					
.3.	Sample : Sample Size : 100% by factory QC and as per AQL by AHSP					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Ø181±1		GE	SP	
	2.	Ø174±1		GE	SP	
	3.	318.5-1		GE	SP	
33.6.2	Minor Dimensions		: Nil			
.4						
33.7.0	Protective Finish:		:			
	To be coated externally with two coats of polyurethane coating paper.					
33.8.0	Any Other Information		: Nil			

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34. SLEEVE INNER 2 PRIMARY

34.1	Drawing No		: PROP/SK-845-29			
34.2	Method of manufacturing		:Integration / lamination			
34.3.0	Raw material		:Kraft paper/Corrugated sheet			
34.3.1	Test/Checks and acceptance Criteria for raw material		:NABL test certificates to be submitted by the manufacture as per specification or, Original manufactures Certificate or Test at vendors place with calibrated equipments.			
34.3.2	Mechanical Properties		:Nil			
34.4	In-Process Inspection		:Nil			
34.5	Stage Inspection		:Nil			
34.6	Final Inspection		:			
34.6.1	Visual Inspections					
34.6.1.1	Features for Visual Inspection and acceptance Criteria. Sample Size: 100% by factor QC and as per AQL by AHSP					
	Sr. No.	Acceptance Criteria	Defect class	AHSP intervention		
	1.	No cut Marks and Tears	Minor	SP		
	2.	No any foreign matters and lump sticks on inner and outer surfaces	Minor			
	3.	No swells	Minor			
	4.	No De-lamination	Minor			
34.6.2	Dimensional Inspection					
34.6.2.1	Critical Dimensions		:Nil			
34.6.2.2	Geometrical Features		:Nil			
34.6.2.3	Major Dimensions		:Nil			
34.6.2.4	Minor Dimensions					
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention	
	1.	Ø161		GE	Audit	
	2.	Ø160		GE		
	3.	256		GE		
	4.	Corrugated sheet thickness 0.5		GE		
34.7.0	Protective finish : Nil					
34.8.0	Any other information: Nil					

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35. PAPER DISC PRIMARY

35.1	Drawing No	: PROP/SK-845-34			
35.2	Method of manufacturing	:Integration / lamination			
35.3	Raw material	:Mill board			
35.4.	Test/Checks and acceptance Criteria for raw material:				
	Material Properties : to be checked for information only				
	Sr. No.	Parameter	Acceptance criteria	AHSP Intervention	
	1.	Grade and GSM (g/m ²)	(300-450) ± 7%		
	2.	Density (g/cm ³)	0.742 ± 7%		
	3.	Average Ply bond (J/m ²)	650 ± 7%		
4.	Cobb g/m ²	208 ± 7 %			
5.	Moisture Content (%)	7.2 ± 7%			
35.5	In-Process Inspection	:Nil			
35.6	Stage Inspection	:Nil			
35.7	Final Inspection	:			
35.7.1	Visual Inspections				
	Features for Visual Inspection and acceptance Criteria to be carried before the final welding. Sample Size: 100% by manufacturer and factor AQL by AHSP/SQAE of order at random selection				
	Sr. No.	Features	Criteria	Defect level	AHSP Intervention
	1.	No cut marks and tear	Ensured	Minor	SP
	2.	No foreign material	Ensured	Minor	SP
3.	No swells	Ensured	Minor	SP	
35.7.2	Dimensional Inspection				
35.7.2.1	Critical Dimensions	:Nil			
35.7.2.2	Geometrical Features	:Nil			
35.7.2.3	Major Dimensions	:Nil			
35.7.2.4	Minor Dimensions: Sample size : 100 % by manufacturer and AQL by AHSP/SQAE of order at random selection				
	Sr. No.	Dimensions/Features	Drawing Zone	Inspection Method	AHSP Intervention
	1.	161		GE Method	SP
	2.	Thickness 4		GE method	SP
35.8.0	Test on finish items	:Nil			
35.8.1	Details of Any other information: Nil				