QUALITY ASSURANCE PLAN			Document No.: MIL-OFCH-OAP-125MM HE-EX-12-2023			
		Dovision	00	Data		
issue:01	Date	Dec-	Revision	00	Date:	
		2023	No.			
Component / Assembly		Steel Pa	ickage	for 125mm l	HE	

# Quality Assurance Plan

# of

# Steel Package for 125mm HE

# (PROVISIONAL)

			1			
QUALITY ASSURANCE PLAN			Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023			
Issue:01 Date Dec-		Revision	00	Date:		
		2023	No.			
Component / Assembly			Steel Pa	ckage	for 125mm l	ΗE

### **INDEX**

Sr. No.	Content	Page No.
0.0	General Information	04
	Detailed Quality Assurance Plan	
1.	Steel Package (125mm HE)	9
2.	Steel Box Assembly	13
3.	Steel Box sub Assembly	14
4.	Base Plate	15
5.	Side Plate	16
6.	Side handle assembly	17
7.	Side handle plate	18
8.	Side handle	19
9.	Top cover assembly	20
10.	Top cover	21
11.	Gasket 1	22
12.	Gasket 2	23
13.	Hook holder top plate	24
14.	Top cover handle assembly	25
15.	Top cover handle plate	26
16.	Top cover handle	27
17	Hinge assembly	28
18.	Foam top	29
19.	Foam bottom	30
20.	Limit Bar	31
21.	Hook assembly	32
22.	Hook Base Plate	33
23.	Hook Handle	34
24.	Hook Pin	35
25.	Hook link	36
26.	LP container assembly primary	37
27.	Sleeve lid sub assembly primary	40
28.	Sleeve lid outer primary	41
29.	Washer millboard 1	42
30.	End cap primary	43
31.	Sleeve sub assembly primary	44
32.	Sleeve inner primary	45
33.	Sleeve outer primary	46
34.	Sleeve inner 2 primary	47
35.	Paper disc primary	48

QUALITY ASSURANCE PLAN			Document	No.: N	/IL-OFCH-QA	P-125MM HE-EX-12-2023
Issue:01 Date Dec-		Revision	00	Date:		
		2023	No.			
Component / Assembly		Steel Pa	ckage	for 125mm l	HE	

### AMENDMENT RECORD

Sr. No.	Page no.	Amendment Details	Authority & Date	Remarks

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

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	
	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
	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
1	Steel Package (125mm HE)DRG NO: PROP/SK-845-01
1.	Steel hev assembly DRD No: PROP/SK-845-01
2.	Steel box assembly DRD NO: PROP/SK-845-02
з. Л	Base plate DRG No : PROP/SK-845-04
- <del>1</del> . 5	Side plate DRG No: PROP/SK-845-04
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

QUALITY ASSURANCE PLAN			Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023				
lssue:01	ssue:01 Date Dec-		Revision	00	Date:		
		2023	No.				
Component / Assembly			Steel Pa	ckage	for 125mm H	ΗE	

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.

QUALITY ASSURANCE PLAN			Document	No.: N	/IIL-OFCH-QA	P-125MM HE-EX-12-2023
Issue:01	Date	Dec-	Revision 00 Date:			
		2023	No.			
Component / Assembly			Steel Pa	ckage	for 125mm H	HE

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

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 neat/lot number in order to ensure trace ability, where possible. The facilities for
0.7.7	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/
070	specifications.
0.7.8	Any component/pattern sent to the supplier shall be used only as guide to manufacturer and not for
079	All components/ stores shall be manufactured using the same process. Material, procedure and
0.7.5	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
017120	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
	homogeneity without exceeding the maximum quantity mentioned in the specification
092	Defect Classification, Critical, Major and Minor
0.0.2	Critical Defect
	A defect that would render the item totally unfits for use or could result in hazardous or unsafe
	conditions for individuals using or maintaining the item
	Maior Defect
	A defect, other than critical defect that result in failure. or materially reduces the usability of the item
	or product for its intended purposes.
	Minor Defect

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

	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	n size, sample s	ize shall be in accordance with the general inspection level II and single					
	sampling AQL pl	ans, given in "I	nspection by attributes and by count defects" as per specification no.					
	IS: 2500 (Part-I)	– 2000.						
0.8.5	Acceptance Qua	ality Levels: D	uring the initial production inspection will be carried out as per the					
	sample size give	n in QAPs. If a	ny deviation occurred than 100% inspection clause shall be decide at					
	the discretion of	Inspecting age	ency wherever applicable.)					
	The acceptable of	quality levels to	or defects shall be as follows:					
	Defect Class	Percent						
	Critical	None						
	Major	4.0						
	Minor	10.0						
0.9	MARKING							
0.9.1	Raw materials: a	ll the raw mat	erial shall be identified suitably with the following information					
	Source of supply	<i>r</i> :						
	Order No.:							
	Batch No.:							
	Identification co	de:						
0.9.2	Components and	d Assembly: Al	I the Packages from the acceptable batch shall be marked with a serial					
	number/lot num	ber wherever	it is mentioned in this specification. All the accepted components shall					
	be grouped in	suitable batc	hes 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							
	Manufacturor's	codo: www./Ma	w four lattors)					
	Lot no : for evan	nle 01 to 99	ix lour letters)					
	Date / Year of m	anufacturing	ΜΝΑ/ΥΥ					
	Package Serial N	o: 1 to 1000						
0.9.3	Marking can be e	either stencille	d. inked painted, etched unless otherwise mentioned, such that it does					
	not vanish during handling, storage, transportation.							
0.10	PACKING / TRANSPORTATION & STORAGE							
	Unless otherwis	e specified he	rein or in relevant documents, between various works centres the					
	manufacturer is	responsible for	or transportation/ storage of components/ empty sub-assemblies in					
	suitable transit p	backages in suc	h a way that the components are protected from abrasion, corrosion,					
	mishandling and	l other environ	mental effects.					
0.11	AHSP: Authority	Holding Seale	ed Particulars					
	CP: Control Poin	t (Witness by r	ep AHSP)					
	SP: Surveillance	point (many b	e witnessed by rep AHSP)					
	Audit: Inspection	n reports may	be audited					

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

## 1. STEEL PACKAGE (125mm HE)

1.1	Drawi	ng No			: PRC	)P/SK	-845-01		
1.2	Metho	od of N	lanufacturing		Assembly				
1.2.1	One s	et of St	eel Package Assembly consis						
	SI. No		Components	Drawi	ng Nu	mber		Qty	
	1.		Steel Box Assembly	PROP/	/SK-84	5-02		01	
	2.		LP container Assy Primary	PROP/	/SK-84	5-26		01	
1.3	Raw N	/lateria	l : Nil						
1.4	Test/	checks	and Acceptance Criteria for F	Raw mat	terial:	Nil			
1.5	In-Pro	cess In	spection	: N	il				
1.6	Stage	Inspec	tion	: Nil					
1.7	Final I	nspect	ion :						
1.8	Visual	Inspec	ction :						
1.8.1	Featu	res for	Visual Inspection and accepta	ance crit	teria				
	Sampl	e Size:	100& by manufacturer and a	is per A0	QL by	AHSP	/SQAE		
	Sr.	Featu	ures	Acce	eptano	ce	Defect	AHSP	
				Crite	Criteria Class		Class	Intervention	
	1.	Dama	age of the outer Surface	Not	Not Accepted Major				
	2.	Paint	ing and Coating to be uniforn	n Ensi	Ensured Minor				
	3.	Sharp	o edges	Not	Not Accepted Minor				
1.8.2	Dimer	nsional	Inspection						
1.8.2.1	Critica	l Dime	nsions	:Nil					
1.8.2.2	Geom	etrical	Features	:Nil					
1.8.2.3	Major	Dimer	nsions :	1		1		1	
	Sr. No		Dimensions/ Features	Drawi	Drawing Inspection		pection	AHSP Interve	ention
				Zone		Me	thod		
	1.		740±3			Stee	el Rule/Tape	SP	
	2.		393±2			Stee	el Rule/Tape		
	3. 250±2					Stee	el Rule/Tape		
1.8.2.4	Minor :Nil								
	Dimensions								
1.9.1	Test on : Details of test/checks on f				items,	Acce	ptance criter	ria and other	
	Finish information.								
	Items	1.0		<i>h</i> · <i>c</i>			,		
	The Q	ualitica	ation tests in vendor premises	/test fa	cilities	shal	be carried o	ut with LP cont	tainers
	duly p	ackage	ed with 125mm shell with Re	sin base	d Con	nbust	ible cartridge	e case and fille	d with
	dummy propellant and dummy primer.								

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023				
Issue:01	Date	Dec-	Revision	00	Date:		
		2023	No.				
Component / Assembly			Steel Pa	ckage	for 125mm H	ΗE	

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.

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023				
Issue:01	Date	Dec-	Revision	00	Date:		
		2023	No.				
Compone	ent / Asse	mbly	Steel Pa	ickage	for 125mm I	HE	

	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.								
1 1	Note	s on Tests/Checks:	1								
	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 the integrated Handle Assembly for 5 mi	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 <sup>2</sup> 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)	by road, rail, sea and air. 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									

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

(h)	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 begiven 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.								
(i)	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 though the handle/lifting hook for a period of 5 minutes.								
	No deformation or cracks shall be observed on the package.								
2.	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								
	• "Rd 125mm HE"								
	YEAR OF MANUFACTURE (MM/YYYY)								
	MANUFACUTURES INITIALS								
	2. Check the condition of Rust Proof Painting								
	3. Check embossing for stacking arrangement								

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

### 2. STEEL BOX ASSEMBLY

2.1	Drawir	ng No	: PROP/SI	<-845-02			
2.2	Metho	d of Manufacturing	:Assembly	y using welding proce	SS		
2.2.1	One se	t of the steel box sub assembly con	sist of follo	wing components			
	Sr.	Components	Drawing	g Number	Qty		
	No.						
	1.	Steel Box Sub Assembly	PROP/S	K-845-03	01		
	2.	Side Handle Assembly	PROP/S	K-845-14	02		
	3.	Top cover Assy	PROP/S	K-845-06	01		
	4.	Hook Assy	PROP/S	K-845-21	02		
	5.	Foam Top	PROP/S	K-845-18	01		
	6.	Foam Bottom	PROP/S	K-845-19	01		
	7.	Limit Bar	PROP/S	K-845-20	02		
2.3	Raw N	laterial : Nil					
2.4	Test/ C	Checks and Acceptance Criteria for F	Raw Materi	al: Nil			
2.5	In-Pro	cess Inspection	:Nil				
2.6	Stage I	nspection	:Nil				
2.7	Final Ir	nspection	:				
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.	Features	Defect	Criteria	AHSP		
	No		Level		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	Dimen	sional Inspection					
2.8.2.1	Critica	Dimensions	:Nil				
2.8.2.2	Geom	etrical Features	:Nil				
2.8.2.3	Major	Dimensions:	:Nil				
2.8.2.4	Minor	Dimensions	:Nil				
2.9.1	Test o	n Finish Items	:				
	a)	Visually check the hook assembly	and side ha	andle assembly for pr	oper weld.		
	b)	Check for sharp corners at weld lo	cations.				
	c)	Test certificates of powder coatir	ng to be sub	omitted.			
2.10.1	Details	of any other information:					
	•	Bottom foam should not come ou	t with the	ifting of LP Container	s from box		
	•	Embossing/ painting on front face	!				
		"Rd 125MM HE"					

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

### **3. STEEL BOX SUB ASSEMBLY**

3.1	Drawin	g No		: PROP/Sk	(-845-03		
3.2	Metho	d of Manufacturing		:Assembly	using welding process		
3.2.1	One set	t of the steel box sub asser	nbly cons	sist of follow	wing components		
	Sr.	Components		Drawing	Number	Qty	
	No.						
	1.	Base Plate		PROP/SI	<-845-04	01	
	2.	Side Plate		PROP/SI	<-845-05	01	
				1			
3.3	Raw Ma	aterial : Nil					
3.4	Test/ C	hecks and Acceptance Crite	eria for R	aw Materia	al: Nil		
3.5	In-Proc	ess Inspection		:Nil			
3.6	Stage Ir	nspection		:Nil			
3.7	Final In	spection		:			
3.8	Visual I	nspections		:			
3.8.1	Feature	es for Visual Inspection and	l accepta	nce Criteria	1:		
	Sample	size: 100% by manufactur	er and as	per AQL by	y AHSP/SQAE		
	Sr.	Features		Defect	Criteria	AHSP	
	No			Level		Intervention	
	1.	Damage of the outer surfa	ace	Major	Not accepted		
	2.	Painting to be uniform		Major	Ensured		
	3.	No Sharp edges		Minor	Ensured		
	4.	No sharp corners of welde	ed joints	Minor	Ensured		
3.8.2	Dimens	sional Inspection					
3.8.2.1	Critical	Dimensions		:Nil			
3.8.2.2	Geome	trical Features		:Nil			
3.8.2.3	Major [	Dimensions:	1			1	
	Sr. No.	Dimensions/Features	Drawin	g Zone	Inspection Method	AHSP	
						Intervention	
	1.	740±3			Steel Rule/Tape	SP	
	2.	250±2			Steel Rule/Tape	_	
	3.	393±2		1	Steel Rule/Tape		
3.8.2.4	Minor I	Dimensions		:Nil			
3.9.1	Test on	Finish Items		:			
	d)	Check for sharp corners a	t weld loo	cations.			
3.10.1	Details of any other information: Nil						

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

### 4. BASE PLATE

4.1	Drawing	g No.				: PROP/SK-845-04				
4.2	Method	of Man	ufacturin	g		: She	: Sheet Metal Operations			
4.3	Raw Ma	aterial		-		: Col	: Cold Rolled Low Carbon Steel sheets and strips-			
						specification to IS 513: 1993, reaffirmed 2003,				
						any	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									
	specific	ation.								
4.5	In-Proce	ess Inspe	ection			:Nil				
4.6	Stage Ir	ispectio	n			:Nil				
4.7	Final In	spection	1:							
4.7.1	Visual li	nspectio	on:			<u> </u>				
	Feature	s for vis	ual Inspec	tion and	acceptan	ce Crit	eria:			
	Sample Size: 100% by manufacturer and as						L by AH:	SP/SQAE		
	Sr.	Feature	es			Crite	eria	Defect Level	A	SHP
	1	Nocha	rn odgoc				urad	Minor		
	1. ว		rp euges	p eages			ired	Minor		F
172	Z. Dimons	ional Inc	es lo be n	Junueu		Elisu	iieu	WIIIOI		
4.7.2	Critical	Dimonsi	ions			·Niil				
4.7.2.1	Geometrical Features									
4.7.2.2	Maior Dimensions :									
1.7.2.5	Sample Size: 100% by manufacturer and as per AOL by AHSP/SOAF									
	Sr. No. Dimensions/ Features Drawi					ng Zon	<u>~-~, / / / / / / / / / / / / / / / / / / /</u>	Inspection		AHSP
						0		Method		Intervention
	1.	740±	:3					Steel Tape/ Rul	e	SP
	2.	393±	:2					Steel Tape/Rule	9	
	3.	250±	:2					Steel Tape/Rule	۲ ا	
4.7.2.4	Minor E	Dimensio	ons	:						
	Sample	Size: To	be check	ed at rav	v material	stage	by AHSP,	/SQAE		
	Sr. No.		Dimen	sional/Fe	eatures	Drav	ving	Inspection		AHSP
						Zone	2	Method		Intervention
	1.		Thickn	ess 1.2 n	nm			Micrometre		SP
	2.		570					Steel Tape/Rule	5 J	
	3.		200					Steel Tape/Rule	5 J	
	4.		260					Steel Tape/Rule	Ĵ	
4.0	5.	<b>F</b> 1 - 1 - 1 - 1	105					Steel Tape/Rule	5	
4.8	Test on	Finish It	ems		+	: 	tab			
	Sample	Size: 10	% of samp	ble or tes	a coupon	per ba	Defect	Demerika		ALICD
	Sr. NO.		Dimension	15/	Accepta	nce	Class	Remarks		AHSP
	1		Phoenbati	ing to			Major	Supplier shall		
	<u>1</u> .		F 105PHati	118 LU 196	specifica	tion	iviajui	submit the test	F	
			.5 5010.13		Class A7			report of the	L	
					0.000 / 12			entire batch		
4.9	Details	of anv o	ther infor	mation :	Nil		1			1

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

### 5. SIDE PLATE

5.1	Drawin	g No		:PROP/SK-	845-05				
5.2	Metho	d of manufacturing		:Sheet Me	tal opera	ations			
5.3	Raw ma	aterial		:Cold Rolle	ed Low C	arbon Steel	sheets	and strips-	
				specification to IS 513 : 1993 reaffirmed 2003, any of					
				Grade O/D/DD of thickness 1.2mm					
5.4	Test/Cl	necks and acceptance	e Criter	ria for raw	material	:			
	Mecha	nical properties and	chemic	nical composition of the material to be checked as per					
	above s	specification and NA	3L test	Certificate	s to be s	ubmitted by	the m	anufacture as per	
	specific	cation.							
5.5	In-Proc	ess Inspection		:Nil					
5.6	Stage I	nspection		:Nil					
5.7	Final In	spection:							
5.7.1	Visual Inspection :								
	Feature	es for Visual Inspection	on and	acceptanc	e Criteri	a:			
	Sample	Size: 100% by manu	facture	er and as p	er AQL b	V AHSP/SQA	١E		
	Sr.	Features		Criteria		Defect Lev	el	AHSP	
	No.						-	intervention	
	1.	No sharp edges		Ensured		Minor		SP	
	2.	All edges to be rou	nded	Ensured		Minor		•	
5.7.2	Dimens	sional Inspection							
5.7.2.1	Critical	Dimensions		:Nil					
5.7.2.2	Geome	trical Features		:Nil					
5.7.2.3	Maior I	Dimensions		:Nil					
5.7.2.4	Minor	Dimensions							
0171211	Sample	Size:100% by manuf	facture	and as ne	r AOL by	AHSP/SOAF	:		
	Sr.	Dimensions/Featur	°es	Drawing Zone Inspection AHSP					
	No			Drawing Zone		Method		intervention	
	1.	380+2		Steel Tane/Rule			/Rule	SP	
	2	250+2			Steel Tape/Rule				
	3	300				Steel Tane	/Rule	•	
	1	160				Steel Tape			
	5	Emboss 7+1				Steel Tape/Rule			
5 8 1	J. Test on	Einich Itoms		•		Steeriape	/nuie		
5.6.1	Sample	Size: 10% of comple	ortoc	t coupon n	or batch				
	Sample	Dimonsions	Acco	ntanco		Bomark	<b>c</b>		
	SI.	Dimensions		plance	Class	Relliark	5	intonuontion	
	1	Phasehoting to IC	Value	3	Class	Cumplin	الممام	Intervention	
	1.	Phosphating to IS	AS	fination	iviajor	Supplie	r snall		
		3018:1990	speci			Submit	the art of		
				AZ		test rep			
						the enti	re		
5.0	<b>D</b>		<u> </u>			patch			
5.9	Details	of any other informa	ition: N	111					

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

### 6. SIDE HANDLE ASSEMBLY

6.1	Draw	ing No		:PROP/SK-845-14								
6.2	Meth	od of r	nanufacturing	:Sheet Metal								
	One s	set of t	he side handle as	sembly consist of f	ollowing com	ponents and as	sembly					
	Sr. No	Э.	Components		Drawing Nu	ımber	Qty					
	1.		Side handle plat	te	PROP/SK-84	15-12	01					
	2.		Side handle		PROP/SK-845-13 0		01					
6.3	Raw material			:NA								
6.4	Test/	Checks	and acceptance	Criteria for raw ma	Criteria for raw material: NA							
6.5	In-Pro	ocess li	nspection	:Nil								
6.6	Stage	Inspec	ction	:Nil								
6.7	Final Inspection:											
6.7.1	Visual Inspection :											
	Features for Visual Inspection and acceptance Criteria:											
	Samp	le Size	: 100% by manufa	AQL by AHSP,	/SQAE							
	Sr.	Featu	res	Criteria	Defect Leve	l	AHSP					
	No.						intervention					
	1.	No sharp edges		Ensured	Minor		Audit					
	2.	All edges to be		Ensured	Minor							
		rounded										
6.7.2	Dime	nsiona	I Inspection									
6.7.2.1	Critic	al Dime	ensions	:Nil								
6.7.2.2	Geon	netrica	Features	:Nil								
6.7.2.3	Majo	r Dime	nsions	:Nil								
6.7.2.4	Mino	r Dime	nsions	:								
6.8.1	Test	of Finis	h Items	:								
	Samp	le Size	:10% of samples	or test coupon per	batch							
	Sr.	Dime	nsions/Features	Drawing Zone	Inspection	Remark	AHSP					
	No.				Method		intervention					
	1.	Phosp	phating to IS	As specification	Major	Supplier shall	Audit					
		3618:	1996	Class A2		submit the						
						test report of						
						the entire						
						batch or						
						sample						
	2.	Free I	novement of	Movement of	Major		Audit					
		handl	e	handle shall be								
				normal	1							

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

### 7. SIDE HANDLE PLATE

71	Drawing	No	·PR	OP/SK-845-1	2					
7.1	Method	of manufacturing	·She	et Metal	2					
7.2	Raw ma	torial	·Co	:Cold Rolled Low Carbon Steel sheets and strips- specification						
7.5		terial	to l	S 513 · 1993 i	reaffi	rmed '	2003 any of $6$	Grad		
74	Test/Ch	ecks and accentance Cr	iteria	for raw mat	orial	inicu i	2003, any or c	Jiau		
/	Mechan	ical properties and che	mical	l composition	of th	he mat	erial to be ch	ocka	ad as ner above	
	specifica	ation and NARI test Cer	tifica	ites to he sub	mitte	ed hy t	he manufacti	ILE 2	as ner	
	specifica	ation.	tined			cubyt				
7.5	In-Proce	ss Inspection	:Nil							
7.6	Stage In	spection	:Nil							
7.7	Final Ins	pection	:							
	Features	s for Visual Inspection a	and a	cceptance Cr	iteria	:				
	Sample	Size: 100% by manufac	turer	and as per A	QL b	V AHSF	P/SQAE			
	Sr. No.	Features		Criteria		, Defe	ect Level	A۲	ISP intervention	
	1.	No sharp edges		Ensured		Min	or	SP		
	2.	All edges to be round	ed	Ensured		Min	or	SP		
7.7.2	Dimensional Inspection									
7.7.2.1	Critical [	Dimensions	:Nil							
7.7.2.2	Geomet	rical Features	:Nil							
7.7.2.3	Major D	imensions								
	Sample	Size: 100% by manufac <sup>-</sup>	turer	and as per A	QL b	y AHSF	P/SQAE			
	Sr. No.	Dimensions/Features	D	rawing Zone		Inspe	ction	A⊦	ISP Intervention	
						Meth	od			
	1.	90±2				GE				
	2.	Thickness 2				Micro	ometre	SP		
7.7.2.4	Minor D	imensions								
	Sample	Size:100% by manufact	ure a	ind as per AQ	L by	AHSP/	SQAE			
	Sr. No.	Dimensions/Features		Drawing Zo	ne	Insp	ection	AF	ISP intervention	
						Met	hod			
	1.	90				GE		SP		
7.8.1	Test on	Finish Items	:							
	Sample	Size: 10% of sample or	test o	coupon per b	atch					
	Sr. No.	Dimensions	ACC	eptance	Def	ect	Remarks		AHSP	
	1	Features	vait	le	Clas	SS :	Currenti e ma le e		Intervention	
	1.	Phosphating to IS	AS	a:f:aat:aa	ıvıa <sub>.</sub>	jor	Supplier sna	11	58	
		3018	spe				submit the	.t		
				S AZ			test report t	ונ		
							hatch or			
							sample			
791	Details	l of any other informatio	n∙ Nil				Jampie			
1.2.1	Details	n any other iniorindlio	11. INH							

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023					
Issue:01	Date	Dec-	Revision	00	Date:			
		2023	No.					
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	ΗE		

### 8. SIDE HANDLE

8.1	Drawing	Drawing No : PROP/SK-845-13								
8.2	Method	of manu	facturing	:Sheet I	Metal	<u> </u>				
8.3	Raw mat	erial		: Hot Ro	: Hot Rolled Medium high Tensile Structure Steel to Spec IS					
				2062:20	011. Grad	e E250.				
8.4	Test/Che	cks and	acceptance Cr	iteria for	raw mat	erial:				
	Mechani	cal prop	erties and che	mical cor	npositior	of the m	naterial to be checl	ked as per above		
	specifica	tion and	NABL test Cer	rtificates	to be sub	mitted b	y the manufacture	as per		
	specifica	tion.								
8.5	In-Proces	ss Inspec	tion	:Nil						
8.6	Stage Ins	pection		:Nil						
8.7	Final Inspection :									
8.8.1	Visual Ins	spection	:							
	Features	for Visu	al Inspection a	and accep	otance Cr	iteria:				
	Sample S	Size: 100	% by manufac <sup>-</sup>	turer and	l as per A	QL by AH	ISP/SQAE			
	Sr. No. Features Criteria Defect Level AHSP									
	intervention									
	1.No sharp edgesEnsuredMinorSP							SP		
	2.	All edg	es to be round	ded	ed Ensured Minor SP					
8.8.2	Dimensio	onal Insp	ection							
8.8.2.1	Critical D	imensio	ns	:Nil						
8.8.2.2	Geometr	ical Feat	ures	:Nil						
8.8.2.3	Major Di	mension	IS							
	Sample S	Size: 100	% by manufac	turer and	l as per A	QL by AH	ISP/SQAE			
	Sr. No.		Dimensions/	Features	Drawir	ng Zone	Inspection	AHSP		
							Method	Intervention		
	1.		130±2				Vernier Caliper	SP		
	2.		80±1				Vernier Caliper	SP		
	3.		Ø10				Vernier Caliper	SP		
8.8.2.4	Minor Di	mensior	ns: Nil							
8.8.1	Test on F	inish Ite	ms	:						
	Sample S	ize: 10%	of sample or	test coup	oon per b	atch				
	Sr. No.	Dimen	sions	Accepta	ance	Defect	Remarks	AHSP		
		Featur	es	Value		Class		intervention		
	1.	Phosph	nating to IS	As		Major	Supplier shall	Audit		
		3618		specific	ation		submit the			
				Class A	2		test report of			
							the entire			
							batch or			
							sample			
8.9.1	Details o	t any oth	ner informatio	n: Nil						

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023					
Issue:01	Date	Dec-	Revision	00	Date:			
		2023	No.					
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	HE		

### 9. TOP COVER ASSEMBLY

	1											
9.1	Drawing	No		: PROP/	/SK-845-06							
9.2	Method	of manu	facturing	:Assem	bly and welding							
	One set o	of the to	o cover assem	bly consi	st of following cor	nponents and	assem	bly				
	Sr. No.	Cor	nponents		Drawing Number	Qty	Qty					
	1.	Тор	Cover		PROP/SK-845-07		1					
	2.	Gas	sket 1		PROP/SK-845-11		2					
	3.	Gas	sket 2		PROP/SK-845-10		2					
	4.	Но	ok Holder Top	plate	PROP/SK-845-15		2					
	5.	Hin	ge Assy		PROP/SK-845-09		2					
	6.	Тор	Cover Handle	e Assy	PROP/SK-845-16		1					
9.3	Raw mat	erial :	NA									
9.4	Test/Checks and acceptance Criteria for raw material: NA											
9.5	In-Proces	ss Inspec	tion	:Nil								
9.6	Stage Ins	pection		:Nil	Nil							
9.7	Final Insp	pection		:								
9.7.1	Visual In	spection		:								
	Features for Visual Inspection and acceptance Criteria:											
	Sample S	ize: 1009	% by manufact	urer and	as per AQL by AH	SP/SQAE						
	Sr. No.	Feature	es		Criteria	Defect Level		AHSP				
								Intervention				
	1.	No sha	rp edges		Ensured	Minor		SP				
	2.	All edg	es to be round	led	Ensured Minor			SP				
9.7.2	Dimensio	onal Insp	ection									
9.7.2.1	Critical D	imensio	าร	:Nil								
9.7.2.2	Geometr	ical Feat	ures	:Nil								
9.7.2.3	Major Di	mension	s :									
	Sr. No.		Dimensions/	Features	Drawing Zone	Inspection		AHSP				
						Method		Intervention				
	1.		750±3			GE		SP				
	2.		405±2			GE		SP				
	3.		26±2			GE		SP				
9.7.2.4	Minor Di	mension	s: Nil		1	1	I					
9.8	Test on Finish Items : Nil											
9.9.1	Details o	f any oth	er information	n: All the	welded parts to l	be checked vis	ually					

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	Revision 00 Date:					
		2023	No.						
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm I	ΗE			

### 10. TOP COVER

10.1	Drawing No · PROP/SK-845-07										
10.2	Method	of manufacturing		:Sheet n	Sheet metal						
10.3	Raw mat	erial		:Cold Ro	:Cold Rolled Low Carbon Steel sheets and strips-						
				specifica	specification to IS 513:1993, reaffirmed 2003, any of						
				Grade C	Grade O/D/DD						
10.4	Test/Che	ecks and acceptance (	Crite	ria for raw n	nater	ial: Mec	hanical proper	ties	s and chemical		
	composi	tion of the material to	o be	checked as	per a	bove spe	ecification and	NA	ABL test		
	certificat	ed to be submitted b	y the	e manufactu	ire as	per spe	cification.				
10.5	In-Proce	ss Inspection		:Nil							
10.6	Stage Ins	pection		: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 S	Size: 100% by manufa	cture	er and as pe	r AQI	by AHS	P/SQAE	-			
	Sr. No.	Features			Crite	eria	Defect	A	HSP Intervention		
							Level				
	1.	No cut marks and te	ear		Ensi	ured	Minor	S	Р		
10.7.2	Dimensional Inspection										
10.7.2.1	Critical D	Dimensions		:Nil							
10.7.2.2	Geometi	rical Features		:Nil							
10.7.2.3	Major Di	mensions :									
	Sample size: 100% by manufacturer and as per AQL by AHSP/SQAE										
	Sr. No.	Dimensions/Featu	Drawing Zo	one	Inspec	tion Method	A	HSP Intervention			
	1.	750±3				Steel I	Rule/Tape	5	P		
	Ζ.	405±2				Steer	Rule/Tape	3	٢		
	3.	Thick 1.2+0.05				Steel I	Rule/Tape	S	Р		
	4.	26±2		Steel Rule/Tape SP					Р		
10.7.2.4	Minor Di	mensions									
	Sample s	ize: 100% by manufa	cture	er and as pe	r aql	by AHS	P/SQAE				
	Sr. No.	Dimensions/Featu	ires	Drawing zo	one	Inspec	tion Method	A	HSP Intervention		
	1.	105				Steel <sup>-</sup>	Гаре/Rule	A	udit		
	2.	260				Steel <sup>-</sup>	Гаре/Rule	A	udit		
	3.	545				Steel <sup>-</sup>	Гаре/Rule	A	udit		
10.8.0	Test on F	inish Items	:								
	Sample S	ize: test coupon per b	atch				I		I		
	Sr. No.	Dimensions	Aco	ceptance	D	efect	Remarks		AHSP		
		Features	Val	ue	CI	ass			intervention		
	1.	Phosphating to IS	As		M	lajor	Supplier shall	I	Audit		
		3618	spe	ecification			submit the	-			
				SS AZ			test report of	Г			
							batch or				
							sample				
10.8.1	Details of	any other informatic	n. N	il			Jampie				
10.0.1	Dectans 01	any other mornatic									

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023					
Issue:01	Date	Dec-	Revision	00	Date:			
		2023	No.					
Compone	ent / Asse	mbly	Steel Pa	ckage	for 125mm l	ΗE		

### 11. GASKET-1

11.1	Drawing	No		: PROP/	′SK-845	-11				
11.2	Method	of manufa	octuring	:Moldin	:Molding					
11.3	Raw mat	erial		:EPDM Sponge						
11.4	Test/che	cks and ac	cceptance Cri	iteria for	raw ma	terial:				
	NABL tes	t Certifica	tes to be sub	mitted b	y the m	anufactur	er as per speci	ficatio	on or certificates	
	from Ori	ginal man	ufacture (To	be cleare	d on O	EM certific	ate).			
	Sr. No.		Paramo	eter		Acceptar	ce criteria	AHS	P Intervention	
	1.		Specifi	c gravity		0.6 to 0.9	95	Aud	it	
	2.		Hardne	ess shore	А	28±5		Aud	it	
11.5	In-Proces	ss Inspecti	ion	:Nil						
11.6	Stage Ins	pection		:Nil						
11.7	Final Insp	pection		:						
11.7.1	Visual Inspection :									
	Sample Size: 100% by manufacturer and AQL by AHSP/SQAE of order at random selection.									
	Sr. No.	Features	5	Criter		a	Defect Level		AHSP	
			Intervention						Intervention	
	1.	No cut n	narks and tea	ar	Ensure	d	Minor		СР	
	2.	No forei	gn material	Ensur		d	Minor		СР	
	3.	No swell	s	Ensured M			Minor		СР	
11.7.2	Dimensic	onal Inspe	ction							
11.7.2.1	Critical D	imensions	S	:Nil						
11.7.2.2	Geometr	ical Featu	res	:Nil						
11.7.2.3	Major Di	mensions	:							
	Sample s	ize: 100%	by manufact	urer and	AQL by	AHSP/SQ	AE of order at	rando	om selection.	
	Sr. No.		Dimensions/	Features	Draw	ing Zone	Inspection		AHSP	
							Method		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 o	f any othe	er informatio	n: Nil						

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023					
Issue:01	Date	Dec-	Revision	00	Date:			
		2023	No.					
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	ΗE		

### 12. GASKET 2

12.1	Drawing No	)	: PROP/SK-8	345-10					
12.2	Method of	Manufacturing	: Moulding						
12.3	Raw Mater	al	: EPDM Sponge						
12.4	Test/Check	s and acceptance Criteria	a for raw material:						
	NABL test c	ertificates to be submitte	ed by the manufacture as per specification or Certificate						
	from Origin	al manufacture (to be cle	ared on OEM	certificate).					
	Material pr	operties :							
	Sr. No.	Parameter	Acceptance	criteria	AHSP Intervention				
	1.	Specific Gravity	0.6 to 0.95		Audit				
	2.	Hardness Shore A	28 <u>+</u> 5		Audit				
12.5	In – Process	s Inspection	:Nil						
12.6	Stage Inspe	ction	: Nil						
12.7	Final Inspec	tion:							
12.7.1	Visual Inspections :								
	Features for visual inspection and acceptance criteria-to be carried before the final wielding.								
	Sample Size : 100 % by manufacturer and AQL by AHSP/SQAE of order at random se								
	Sr. No.	Features	Criteria	Defect Level	AHSP Intervention				
	1	No cut marks and tear	Ensured	Minor	СР				
	2	No foreign materials	Ensured	Minor	СР				
	3	No swells	Ensured	Minor	СР				
12.7.2	Dimensiona	al Inspection :							
12.7.2.1	Critical Dim	ensions	: Nil						
12.7.2.2	Geometrica	l Features	: Nil						
	Major Dime	ensions							
	Sample Size	e : 100 % by manufacture	r and AQL by A	AHSP/SQAE of o	rder at random selection				
	Sr. no.	Dimension/	Drg. Zone	Inspection	AHSP Intervention				
		Features		Method					
	1.	349 <u>+</u> 1		G E Method	SP				
	2.	25 <u>+</u> 1		GE	SP				
12.7.2.3	3.	5		GE					
	Minor Dime	ensions	: Nil						
	Test on Fini	sh Items	: Nil						
	Details of any other information : Nil								

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	Revision 00 Date:					
		2023	No.						
Compone	ent / Asse	embly	Steel Pa	ickage	for 125mm I	HE			

### **13. HOOK HOLDER TOP PLATE**

13.1	Drawin	g No				: PROP/SK-	845-1	5					
13.2	Metho	d of Ma	anufacturing			: Sheet Met	tal/Ma	achinii	ng				
13.3	Raw M	aterial				: Cold Rolle	d Law	/ Carbo	on Stee	l sheets a	nd stri	ps-	
						Specificatio	on to Is	S 513:	1993, r	eaffirmed	1 2003,	any of	
						Grade O/D/DD.							
13.4	Test/Cl	necks a	nd acceptan	ce Criteria fo	or ra	aw material	l: Mec	hanica	al prope	erties and	l chemi	ical	
	compo	sition c	of the materi	al to be cheo	ckec	l as per abo	ove sp	ecifica	tion an	d NABL t	est cer	tificates	
	to be s	ubmitte	ed by the ma	anufacture a	s pe	per specification.							
13.5	In-Proc	ess Ins	pection		: Nil								
13.6	Stage I	nspecti	on			:Nil							
13.7	Final Inspection												
13.7.1	Visual Inspections					:	<u> </u>						
	Feature	es for v	isual inspect	ion and acce	epta	nce criteria	a-to be	e carri	ed befo	re the fin	al wiel	ding.	
	Sample	Size :	100 % by Ma	inufacturer a	and	as per AQL	by SU	AE/AI			1		
	Sr. NO.	Fea	itures			Criteria		Detec	t Level		Interve	ention	
	1.		snarp edges			Ensured		Nino	r 	SP CD			
1272	Z. Dimon	All	euges to be		Ensureu		IVIIIIO	ſ	58				
13.7.2	Critical	Dimon	sions			• NI:I							
12722	Critical	trical E				. INII • NIII							
13.7.2.2	Major	Dimone				. 1111							
15.7.2.5	Sample	size · '	100% hv Mai	nufacturer a	nd a	as ner ΔΟΙ	hv SO	ΔΕ/ΔΗ	ISP				
	Sr. No.	. 5120	Dimension	s/ Features		Drawing	lr Ir	nspect	ion	AHSP			
				o, . ca.ca. co		Zone Metho		d	Interven	tion			
	1.		58.5+2				Vernier		~	SP			
			_				c	Caliper					
13.7.2.4	Minor I	Dimens	ions : Samp	e Size : 100 9	% by	y Manufact	urer a	and as	per AQ	L by SQA	e/ahsf	, ,	
	Sr. No.	Di	mensions/ F	eatures	Dr	awing zone	5		Inspec	tion	AHSF	)	
									Metho	ods	Inter	vention	
	1.	Th	ickness 2						Vernie	er	SP		
									Calipe	r			
13.7.3	Test	on Fin	ish Items						: Nil				
	Sam	ple Siz	e : 10% or Te	est coupon p	er b	batch	-						
	Sr.	Dime	nsions/	Acceptance	e	Defect	Rem	narks		AHSP	Interve	ention	
	No.	Featu	res	criteria		class	-						
	1.	Phosp	phating to	As .c		Major	Supp	plier sl	hall	Audit			
		12 361	.ŏ	specificatio			subr	nit the	e test				
				II CIASS AZ				n of t	ne ch				
1374	Details	ofany	other inform	nation		• Nil	entit	ie bal					
1 10.7.4		UT ally		auon									

QUALITY ASSURANCE PLAN			Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:					
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	HE				

### **14. TOP COVER HANDLE ASSEMBLY**

14.1	Drawing	g No					: PROP/SK-845	-16		
14.2	Method	l of N	lanufacturing	5			: Assembly			
	One set	of th	e top cover h	andle	assembly c	ons	ist of following c	omponents	s and assembly	
	Sr. No.		Component	/Asse	mbly	Dr	awing No.		Quantity	
	1		Top cover h	over handle plate			ROP/SK-845-17			
	2		Top cover h	andle		PROP/SK-845-08				
14.3	Raw Ma	iteria				Ni	Ι			
14.4	Test / cł	hecks	and accepta	nce cr	iteria for ra	w n	naterial : NA			
14.5	In Proce	ess In	spection			Ni	I			
14.6	Stage In	spect	tion			Ni	l			
14.7	Final Ins	spect	ion :							
14.7.1	Visual Inspection									
	Features for visual inspection and acceptance criteria to be carried before the final wielding									
	Sample	size :	100 % by Ma	anufac	turer and a	s pe	er AQL by SQAE/	AHSP		
	Sr. No.	Fea	tures		Criteria		Defect Level	AHSP Inte	ervention	
	1.	Dan	nage of the o	uter	Not		Major	SP		
		surf	ace		Accepted					
	2.	No :	sharp edges		Ensured		Major	SP		
14.7.2	Dimensi	ional	Inspection							
14.7.2.1	Critical I	Dime	nsion	: Nil						
14.7.2.2	Geomet	trical	features	: Nil						
14.7.2.3	Major D	imer	sions : Nil							
14.7.2.4	Minor D	Dimer	nsions	: Nil						
14.8.0	Test on	finisł	n items	: Nil						
	1.	Chec	k the proper	move	ment of the	ha	ndle			
14.8.1	Details of any other information				: Nil					

QUALITY	ASSURA	NCE PLAN	Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:					
		2023	No.	No.						
Compone	ent / Asse	mbly	Steel Pa	ickage	for 125mm l	HE				

## **15. TOP COVER HANDLE PLATE**

15.1	Drawin	ig No				: PROP/SK-845-17					
15.2	Metho	d of Manufacturing					: Sheet M	etal/Machini	ng		
15.3	Raw m	aterial					: Cold Rol	led low Carbo	on ste	els and strips	
10.0							specificat	ion to $15513$	: 199	3. reaffirmed	
							2003. any	of Grade O/	D/DD	o, reaminea	
15.4	Test/cł	necks and accentance	e cr	iteria fo	or raw ma	ater	ial: Mechar	nical properti	, es an	d chemical	
10.1	compo	sition of the materia	alto	be che	cked as p	er a	above speci	fication and I	NABL	test	
	certific	ate to be submitted	bv t	the mai	nufacture	as	per specific	cation			
15 5	In proc	In process inspection									
15.5	Stagel	nspection					Nil				
15.0	Final In	spection									
15.7	Visuali	inspections ·									
13.7.1	Featur	es for visual inspecti	on a	nd acc	entance	rite	ria to he ca	arried before	tha fi		
	Sample	size · 100 % by Mai	nufa	cturer:	and as ne	$r \Delta ($		AHSP	the h	inal weiding.	
	Jumpic	- 512C . 100 /0 5y 101	india	eturer				, , , , , , , , , , , , , , , , , , , ,	r		
	Sr.	Features			Criteria		Defect	level	AHS	SP	
	No.								Inte	ervention	
	1.	Sharp edges No					Minor		SP		
				accepte	d						
15 5 0	2.	All edges to be rou	unde	d	Ensured	1	Minor		SP		
15.7.2	Dimen	sional Inspection									
15.7.2.1	Critical	Dimension		: N	<u>   </u>						
15.7.2.2	Geome	etrical features		: N	Nil						
15.7.2.3	Major	Dimensions:									
	Sample	e size : Tool report to	o be	submit	ted by ve	enac	or Line and the				
	Sr.	Dimension/ Featu	res	Draw	ing zone		Inspectio	n method	AHS	or contion	
	10.	05.0					CE mothe				
	1.	85 <u>+</u> 2					GE metho	ba	SP		
	2.	Thickness 1.2							SP		
15.7.2.4	Minor	Dimensions					: Nil				
	Sr. no.		Dir	mensio	ns		Drawing	Inspection	AHS	SP	
							zone	Method	Inte	ervention	
	1		23					GE	Auc	lit	
15.8.0	Test or	n finish items:									
	Sample	e size : Test coupon	per k	batch							
	Sr.no.	Dimensions/Featu	res	Accep	otance	De	efect class	Remarks		AHSP	
				criter	ia					Intervention	
	1.	Phosphating to IS	As			M	ajor	Supplier sh	nall	Audit	
		3618		specif	fication			submit the	2		
				class	A2			test report	of		
								the entire			
								batch			
15.8.1	Details	ils of any information					:Nil				

QUALITY	ASSURAN	NCE PLAN	Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:					
		2023	No.	No.						
Compone	ent / Asse	mbly	Steel Package for 125mm HE							

### 16. TOP COVER HANDLE

16.1	Drawin	Drawing No					: PROP/SK-845-08					
16.2	Metho	d of Manufacturin	g			: Sheet N	/leta	l/Machining				
16.3	Raw m	aterial				: Hot Ro	lled	medium and	high	n te	nsile s	tructural
					:	steel to I	S 20	62:2011, Gra	ide E	: 25	0	
16.4	Test/ch	necks and accepta	nce crit	eria for ı	aw	v materia	al: M	echanical				
	proper	ties and chemical	compos	sition of	the	e materia	al to	be				
	checke	d as per above spe	ecificati	on and I	NA	BL test ce	ertifi	cate to be				
	submit	ted by the manufa	acture a	s per sp	eci	ification						1
16.5	In proc	ess inspection							Nil			
16.6	Stage I	nspection							Nil			
16.7	Final In	spection										
16.7.1	Visual i	nspections :										
	Sample	e size : 100 % by N	lanufact	turer an	d a	is per AQ	<u>L</u> by	SQAE/ AHSP				
	Sr. no.	Features	0	rit	teria		Defect lev	/el	AH	ISP Int	ervention	
	1	No cut marks,	Not present minor SP									
16.7.2	Dimens	sional Inspection		1								
16.7.2.1	Critical	Dimension		: Nil								
16.7.2.2	Geome	etrical features	: Nil									
16.7.2.3	Major I	Dimensions:										
	Sample	e size : 100 % by m	anufact	turer and	d a	is per AQ	L by	SQAE/ AHSP				
	Sr. no.	Dimension/ Fe	atures	Drawir	ng z	g zone Inspection				AH	ISP Int	ervention
						method						
	1.	106 <u>+</u> 2					Vei	rnier/steel ru	ile SP			
	2.	60 <u>+</u> 2					Vei	rnier/steel ru	le			
16724	Sample	size · Test coupo	n ner ha	atch		·Nil						
	oumpre		i pei be									
16.8.0	Test on	n Finish Items				:Nil						
	Sr.no.	Dimensions/	Accep	tance		Defect	:	Remarks			AHSP	)
		Features	criteri	а		class					Inter	vention
	1.	Phosphating to	As spe	ecificatio	n	Major		Supplier sha	II		Audit	:
		IS 3618	class A2					submit the t				
								report of the	е			
							entire batch	1				
16.8.1	Details	Details of any other information : Nil										

QUALITY	ASSURA	NCE PLAN	Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
lssue:01	Date	Dec-	Revision	00	Date:					
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	HE				

#### **17. HINGE ASSEMBLY**

17.1	Drawin	g No.			: PROP/SK-	845-09			
17.2	Metho	d of Manufacturing			: STD Assen	nbly : ste	el butt hinge as per IS : 1341 size		
					75mm as p	er table 3	1		
17.3	Raw Ma	aterial			: MS				
17.4	Test/ch	ecks and acceptance	e criteria	a for	or raw material :				
17.5	In- Proc	ess Inspection		Nil	Jil				
17.6	Stage Inspection N								
1.7	Final Inspection								
17.7.1	Visual I	nspections							
	Feature	es for visual inspection	on and a	iccep	tance criteri	ia to be ca	arried before the final welding		
	Sample	size :100 % by Man	ufacture	er an	d as per AQL	by SQAE	/AHSP		
	Sr.	Features			teria	Defect	AHSP Intervention		
	No.					Level			
	1.	Damage of any su	rface	No	t accepted	Major	SP		
	3.	Sharp edges Not		No	t accepted	Minor	SP		
		Accepted							
17.7.2	Dimens	ional Inspection :							
17.7.2.1	Critical	Dimensions	: Ni	I					
17.7.2.2	Geome	trical Features	: Ni	I					
1.7.2.3	Major [	Dimension : Nil							
	Sr. no	Dimensions/	Drawir	ng	Inspection	ı	AHSP Intervention		
		Features	zone		Method				
	1	75			Vernier		SP		
17.7.2.4	Minor [	Dimension	Nil						
17.8.0	Test on	finish items	:						
	1.	Check for the free r	noveme	ent o	of the hinge assembly.				
17.8.1	Details of any other information				: Nil				

QUALITY	ASSURAN	NCE PLAN	Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:					
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	ΗE				

### <u>18. FOAM TOP</u>

18.1	Drawin	g No.	:	PROP/SK-845-18	3					
18.2	Method	of Manufacturing	: :	Moulding/Cutt	ing in	n moulding sh	lape			
18.3	Raw Ma	aterial	:	PU or Antistati		anded polvet	hylene Foam as per			
			s	pecification IN	D/ME	/913 (a)Prov	isional : 2004			
18.4	Test / C	hecks and accepta	nce (	Criteria for raw	mate	erial:				
	NABL te	est Certificates to b	e sul	bmitted by the	man	ufacture as p	er specification or			
	Certifica	ate from original m	nanuf	acture (to be c	leare	d on OEM ce	rtificate).			
	Sr. No.	Parameter	Acce	eptance criteria	1	AHSP Interv	ention			
	1.	Density 30 <u>+</u> kg/m <sup>3</sup> Audit								
18.5	In-proc	ess Inspection				Nil				
18.6	Stage Ir	nspection				Nil				
18.7	Final In:	spection								
18.7.1	Visual Inspection									
	Feature	s for visual inspect	ion a	and acceptance	crite	eria to be carr	ied before the final			
	wieldin	wielding.								
	Sample	Size : 100 % by ma	nufa	cture and as A	QL by	AHSP/SQAE				
	Sr. No.	Features		Criteria	De	fect level	AHSP Intervention			
	1	No cut marks and tear	d	Ensured IVI		nor	SP			
	2.	No foreign mate	rials	Ensured	Ensured Mi		SP			
	3.	No swells		Ensured	Mi	nor	SP			
	4.	No De-laminatio	n	Ensured	Mi	nor	SP			
18.7.2	Dimens	ional Inspection								
18.7.2.1	Critical	Dimension	:	Nil						
18.7.2.2	Geome	tric Features	:	Nil						
18.7.2.3	Major D	imensions : Nil								
18.7.2.4	Minor D	Dimension								
	Sample	Size : 100 % By ma	anufa	icturer and as p	ber A	QL by AHSP/S	QAE			
	Sr.	Dimensions/	Drav	wing zone	Insp	ection	AHSP Intervention			
	NO.	Features			Met	hod	CD.			
	1.	<u>730+2</u>			Stee	el rule	SP			
	2.	<u>380+2</u>			Stee	el Rule	SP			
	<u>з</u> .	Ø 120			GE		5P			
	4.	Ψ184.5 440+ 2			GE		5r 5p			
10 0 0	D.	44U+-Z			Stee		זר			
10.0.0	Details of any other information :									
10.0.1	a) Eitm	ant check using LP	cont	niner:						
	ചി	Al foil thickness mi	in 25	micron to be v	vranr	hed around th	e foam with proper			
	adhesion									
	auresion.									

QUALITY	ASSURAN	NCE PLAN	Document	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:					
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm I	ΗE				

### 19. FOAM BOTTOM

19.1	Drawir	ig No.	: P	ROP/SK-845	-19				
19.2	Metho	d of Manufacturing	: N	/loulding/Cu	uttin	g in moulding	shape		
19.3	Raw M	aterial	: P	U or Antist	atic E	Expanded poly	yethylene Foam as per		
			sp	ecification l	IND/	ME/913 (a)Pr	ovisional : 2004		
19.4	Test / 0	Checks and accepta	nce Crite	ria for raw ı	mate	erial:			
	NABL t	est Certificates to b	e submit	ted by the r	manı	ufacture as pe	er specification or		
	Certific	ate from original m	anufactu	ire (to be cl	eare	d on OEM cer	tificate).		
	Sr. No.	Parameter	Accep	otance crite	ria	AHSP Inte	ervention		
	1.	Density	30 <u>+</u> 5	kg/m³		Audit			
19.5	In-proc	cess Inspection				Nil			
19.6	Stage I	nspection Nil							
19.7	Final Ir	al Inspection							
19.7.1	Visual	Inspection							
	Sample	e Size : 100 % by ma	nufactur	e and as AC	)L by	AHSP/SQAE			
	S.N.	Features		Criteria	De	efect level	AHSP Intervention		
	1	No cut marks and	d tears	Ensured	Mi	inor	SP		
	2.	No foreign mater	ials	Ensured	Mi	inor	SP		
	3.	No swells		Ensured	Mi	inor	SP		
	4.	No De-lamination	า	Ensured	Mi	inor	SP		
19.7.2	Dimen	sional Inspection							
19.7.2.1	Critical	Dimension	: Nil						
19.7.2.2	Geome	etric Features	: Nil						
19.7.2.3	Major	Dimensions : Nil							
19.7.2.4	Minor	Dimension							
	Sample	e Size : 100 % By ma	nufactur	er and as p	er AC	QL by AHSP/S	QAE		
	Sr.	Dimensions/	Drawing	zone	Insp	ection	AHSP Intervention		
	No.	Features			Met	:hod			
	1.	730 <u>+</u> 2			Stee	el rule	SP		
	2.	380 <u>+</u> 2			Stee	el Rule	SP		
	3.	440 <u>+</u> 2			GE		SP		
	4.	120+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 mi	n 25 mic	ron to be w	rapp	ed around the	e foam with proper		
	adhesion.								

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

### **20. LIMIT BAR**

20.1	Drawin	ig No.			: PRC	)P/SK-84	5-20				
20.2	Metho	d of Manufacturin	g		: STD BAR or Machining						
20.3	Raw M	aterial	0		: Hot	Rolled	Medium and High	Ten	sile structural		
					steel to IS 2062 : 2011, Grade E 250						
20.4	Test / (	Checks and accept	ance C	riteria	eria for raw material: Chemical composition of the						
	materi	al to be checked a	s per a	bove	specif	ication a	and NABL test Cer	tifica	ates to be		
	submit	ted by the manufa	acture	as pei	r spec	ification					
20.5	In-proc	ess Inspection					Nil				
20.6	Stage I	nspection					Nil				
20.7	Final In	spection									
20.7.	Visual	Inspection									
1											
	Featur	es for visual inspec	ction a	nd ac	ceptai	nce crite	ria to be carried b	efoi	re the final		
	wieldir	ıg.									
	Sample	e Size : 100 % by m	anufa	cture	and a	s AQL by	AHSP/SQAE				
	S.N. Features Criteria Defect level								AHSP		
									ntervention		
	1	No sharp edges	5		Ensu	red	Minor	S	P		
20.7.	Dimen	sional Inspection									
2											
20.7.	Critical	Dimension			: Nil						
2.1											
20.7.	Geome	etric Features			: Nil						
2.2											
20.7.	Major	Dimensions : Nil									
2.3											
20.7.	Minor	Dimension									
2.4											
	Sr.	Dimensions/ Fea	tures	Draw	ving zo	one	Inspection	A	ISP Intervention		
	NO.	4.05					Method	<u> </u>	1		
	1.	125					GE	AL	Judit		
20.0	2.	10			•	<b>-</b> .	GE	Αι	Jdit		
20.8.	lest Or	n finish items	: 5	ample	e size	: Test co	upon per batch				
0	<u> </u>	Dimensional	A		•	Defect	Demerika				
	Sr.	Dimensions/	Accep	otance	e	Derect	Remarks		AHSP		
·	NO.	Phasebating	criter	Ia		Class	Cupalianshall				
	1.	to IS 2618	AS	ficatio	20	wajor	Supplier shall		Audit		
		10 13 3018	speci	ncatic	ווכ		roport of the				
			CIDSS				entire batch				
20.8	Details	of any other infor	matio	n · Nil					1		
1	Details	er any other mor	matio								

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

### 21. HOOK ASSEMBLY

21.1	Drawin	g No.		: PROP/SK-8	345-21			
21.2	Metho	d of Manufacturing	5	: Assembly				
21.2.1	One set	t of the steel packa	ige ass	embly consist of following components and assembly				
	Sr. No.	Component/Asse	embly	Drawing N	Qty.			
	1.	Hook base plate		PROP/SK-84	45-22		01	
	2.	Hook pin		PROP/SK-8	45-24		01	
	3.	Hook Handle		PROP/SK-8	45-23		01	
	4.	Hook Link		PROP/SK-84	45-25		01	
21.3	Raw Ma	aterial		: NA				
21.4	Test/Ch	ecks and acceptar	nce Cri	teria for raw	material : NA			
21.5	In-proc	ess Inspection		Nil				
21.6	Stage Inspection			Nil				
21.7	Final In	spection :						
21.7.1	Visual I	nspections :						
	Sample	size : 100 % by ma	anufac	turer and as per AQL by AHSP/ SQAE				
	Sr.	Features	Crite	ria	Defect Level	AHSP I	ntervention	
	No.							
	1.	No sharp edges	Ensu	red	Minor	SP		
21.7.2	Dimens	ional Inspection						
21.7.2.1	Critical	Dimension		: Nil				
21.7.2.2	Geome	trical Features		: Nil				
21.7.2.3	Major [	Dimensions : Nil						
21.7.2.4	Minor [	Dimensions : Nil						
21.8.0	Test Or	finish items : Nil						
21.8.1	Details	of any other inforr	nation		: Nil			

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

### 22. HOOK BASE PLATE

22.1	Drawin	g No		: PROP/SK-845	5-22							
22.2	Metho	d of manufacturing		:Forming/mac	hining							
22.3	Raw ma	aterial		:Cold Rolled Low Carbon Steel sheets and strips-								
				specification t	specification to IS 513 : 1993 reaffirmed 2003. any of Grade							
				O/D/DD.								
22.4	Test/Cl	necks and acceptance Cr	ite	ria for raw mate	erial:							
	Mecha	nical properties and che	mi	cal composition	of the m	aterial to be ch	ecked	as per above				
	specification and NABL test Certificates to be submitted by the manufacture as per											
	specification.											
22.5	In-Proc	ess Inspection		:Nil								
22.6	Stage I	nspection		:Nil								
22.7	Final In	spection	:									
22.7.1	Visual I	nspections										
	Feature	Features for Visual Inspection and acceptance Criteria to be carried before the welding.										
	Sample	Size: 100% by manufact	tur	er and as per A		SP/SQAE						
	Sr. No.	Features		Criteria	Defect	Level	AHS	P intervention				
	1.	No sharp edges		Ensured Minor SP								
22.7.2	Dimensional Inspection											
22.7.2.1	Critical Dimensions :Nil											
22.7.2.2	Geome	trical Features		:Nil								
22.7.2.3	Major I	Dimensions :										
	Sample	Size: 100% by manufact	tur	er and as per A		SP/SQAE						
	Sr.	Dimensions/Features	D	rawing Zone Inspection Method				Anse intervention				
	1 1	60		Vernier Caliner				SD				
	1. 2	20			Vernier	Caliper						
	2.	15				Calipei						
	3.	15			GE		58					
	4.	Thickness 2			GE		SP					
	5.	Ø5			GE		SP					
22.7.2.4	Minor I	Dimensions :Nil										
22.8.0	Test on	Finish Items		:								
	Sample	size: Test coupon per b	atc	h	1	1		1				
	Sr. No.	Dimensions/Feature	S	Acceptance	Defect	Remarks		AHSP				
				criteria	Class			Intervention				
	1.	Phosphating to IS		As	Major	Supplier shall		Audit				
		3618		specification		submit the te	st					
				Class A2		report of the						
701						entire batch						
7.9.1	Details	of any other informatio	n: I	NII								

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

### 23. HOOK HANDLE

23.1	Drawir	ng No		: PROP/SK-845	5-23					
23.2	Metho	d of manufacturing		:Forming/Shee	et metal					
23.3	Raw m	aterial		:Cold Rolled Low Carbon Steel sheets and strips- specification						
				to IS 513 : 1993 reaffirmed 2003, any of Grade O/D/DD.						
23.4	Test/C	hecks and acceptance	Crit	teria for raw ma	aterial:					
	Chemi	cal composition of the	ma	aterial to be che	cked as p	er above specif	ication	and NABL test		
	Certific	cates to be submitted	by t	the manufacture	e as per s	pecification.				
23.5	In-Proc	cess Inspection		:Nil						
23.6	Stage I	nspection		:Nil						
23.7	Final Inspection :									
23.7.1	Visual	Inspections								
	Sample	e Size: 100% by manuf	act	urer and as per	AQL by A	HSP/SQAE				
	Sr. No.	Features	Cri	iteria	Defect	Level	AHSP	intervention		
	1.	No sharp edges	En	sured	Minor		SP			
23.7.2	Dimen	sional Inspection								
23.7.2.1	Critical	Dimensions		:Nil						
23.7.2.2	2 Geometrical Features :Nil									
23.7.2.3	3 Major Dimensions :									
	Sample	e Size: 100% by manuf	act	urer and as per	AQL by A	HSP/SQAE				
	Sr.	Dimensions/Features	;	Drawing Inspection Method AHS			AHSP	Intervention		
	No.			Zone						
	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 or	n Finish Items		:						
	Sample	e size: 10% or Test cou	por	n per batch						
	Sr. No.	Dimensions/Feature	es	Acceptance	Defect	Remarks		AHSP		
				criteria	Class			Intervention		
	1.	Phosphating to IS		As	Major	Supplier shall		Audit		
		3618		specification		submit the te	st			
				Class A2		report of the	entire			
						batch				
23.8.1	Details	of any other informat	tion	: Nil						

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

### 24. HOOK PIN

24.1	Drawin	ig No		: PROP/SK-845	5-24					
24.2	Metho	d of manufacturing		:Machining	:Machining					
24.3	Raw m	aterial		:Hot Rolled Medium and High Tensile structure steel to IS						
				2026 :2011, Grade E 250						
24.4	Test/Cl	hecks and acceptance	Crit	teria for raw ma	aterial:					
	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 I	nspection		: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	Cri	iteria	Defect Level	AHSP intervention				
	1.	No sharp edges	En	sured	Major	SP				
24.7.2	Dimen	sional Inspection								
24.7.2.1	Critical	Dimensions		:Nil						
24.7.2.2	Geome	etrical Features		:Nil						
24.7.2.3	Major	Dimensions :								
	Sample	e Size: 100% by manuf	actı	urer and as per	AQL by AHSP/SQAE					
	Sr.	Dimensions/Features	5	Drawing	Inspection Method	AHSP Intervention				
	No.			Zone						
	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 informat	tion	: Nil						

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

### 25. HOOK LINK

Drawir	ng No		:PROP/SK-845-25						
Metho	d of manufacturing		:Sheet metal						
Raw m	aterial		:Hot Rolled Medium and High Tensile structure steel						
			to IS 2026 :2011, Grade E 250						
Test/C	hecks and acceptance Crite	eria fo	or raw materia	al:					
Mecha	nical properties and Chem	ical co	composition of the material to be checked as per above						
specifi	cation and NABL test Certif	icate	s to be submi	tted by th	ne manufactur	e as	s per		
specifi	cation.		1						
In-Proc	cess Inspection		:Nil						
Stage I	nspection		:Nil						
Final Ir	spection :								
Visual	Inspections								
Sample	e Size: 100% by manufactur	rer an	id as per AQL	by AHSP,	/SQAE				
Sr. Features Crit			eria	Defect	: Level	A	HSP intervention		
No.									
1.	No sharp edges	Ens	ured	Minor	Ainor		)		
Dimen	sional Inspection		1						
Critica	Dimensions		:Nil						
Geome	etrical Features		:Nil						
Major	Dimensions :								
Sample	e Size: 100% by manufactur	rer an	1d as per AQL by AHSP/SQAE						
Sr.	Dimensions/Features		Drawing	Inspec	tion Method	AHSP Intervention			
No.	~ ~ ~		Zone		o. !!				
1.	64			Vernie	r Caliper	SP			
2.	Ø4			Microi	metre	SP	)		
Minor	Dimensions :Nil		1						
Test or	n Finish Items	l.	:						
Sr.	Dimensions/Features	Acc	eptance	Defect	Remarks		AHSP		
No.		crite	eria	class			Intervention		
1.	Phosphating to IS 3618	As s	pecification	Major	Supplier sha		SP		
		Clas	is A2		submit the	<b>,</b>			
					test report o	DT			
1									
					hatch				
	Drawir Metho Raw m Test/C Mecha specifi In-Proo Stage I Final Ir Visual Sample Sr. No. 1. Dimen Critica Geome Major Sample Sr. No. 1. 2. Minor Test or Sr. No. 1.	Drawing NoMethod of manufacturingRaw materialTest/Checks and acceptance CritedMechanical properties and Chemspecification and NABL test Certificspecification.In-Process InspectionStage InspectionFinal InspectionSample Size: 100% by manufacturesNo.1.No sharp edgesDimensional InspectionCritical DimensionsGeometrical FeaturesMajor DimensionsSample Size: 100% by manufacturesNo.1.No.1.642.Ø4Minor DimensionsSr.Dimensions/FeaturesNo.1.642.Ø4Minor DimensionsSr.Dimensions/FeaturesNo.1.Phosphating to IS 3618	Drawing NoMethod of manufacturingRaw materialTest/Checks and acceptance Criteria for Mechanical properties and Chemical consistenciation and NABL test Certificates specification.In-Process InspectionStage InspectionFinal InspectionFinal InspectionStage InspectionStage InspectionStage InspectionStage InspectionStage InspectionStage InspectionsSample Size: 100% by manufacturer and Sr.Sr.FeaturesNo.1.No sharp edgesDimensional InspectionCritical DimensionsGeometrical FeaturesMajor DimensionsSr.Dimensions/FeaturesNo.1.642.Ø4Minor Dimensions:NilTest on Finish ItemsSr.Dimensions/FeaturesNo.Criter1.Phosphating to IS 3618As s Class	Drawing No:PROP/SK-8Method of manufacturing:Sheet metaRaw material:Hot Rolled to IS 2026 :Test/Checks and acceptance Criteria for raw materiaMechanical properties and Chemical composition or specification and NABL test Certificates to be submi specification.In-Process Inspection:NilStage Inspection:NilFinal Inspection:NilFinal Inspection:NilSample Size: 100% by manufacturer and as per AQLSr.FeaturesCriteriaCriteriaNo.Inspection1.No sharp edgesEnsuredDimensional Inspection:NilGeometrical Features:NilMajor Dimensions:NilSample Size: 100% by manufacturer and as per AQLSr.DimensionsSample Size: 100% by manufacturer and as per AQLSr.DimensionsSample Size: 100% by manufacturer and as per AQLSr.DimensionsSample Size: 100% by manufacturer and as per AQLSr.Dimensions :Sample Size: 100% by manufacturer and as per AQLSr.Dimensions/FeaturesNo.Zone1.642.Ø4Minor Dimensions :NilTest on Finish Items:Sr.Dimensions/FeaturesNo.Acceptance criteria1.Phosphating to IS 3618As specification Class A2	Drawing No:PROP/SK-845-25Method of manufacturing:Sheet metalRaw material:Hot Rolled Medium to IS 2026 :2011, GraTest/Checks and acceptance Criteria for raw material: Mechanical properties and Chemical composition of the mate specification and NABL test Certificates to be submitted by th specification.In-Process Inspection:NilStage Inspection:NilFinal Inspection:NilStage Inspection:NilSample Size: 100% by manufacturer and as per AQL by AHSP, Sr.FeaturesSr.FeaturesCriteriaDimensional Inspection:NilGeometrical Features:NilMajor Dimensions:NilSr.DimensionsSample Size: 100% by manufacturer and as per AQL by AHSP,Sr.FeaturesCritical Dimensions:NilGeometrical Features:NilMajor Dimensions:NilSr.Dimensions/FeaturesI.64Vernie:2.Ø4Minor Dimensions:NilTest on Finish Items:Sr.Dimensions/FeaturesAcceptance criteriaDefectNo.:Acceptance criteriaDefectNo.:I.Phosphating to IS 3618As specification class A2Major	Drawing No       :PROP/SK-845-25         Method of manufacturing       :Sheet metal         Raw material       :Hot Rolled Medium and High Tensito IS 2026 :2011, Grade E 250         Test/Checks and acceptance Criteria for raw material:       Mechanical properties and Chemical composition of the material to be chespecification and NABL test Certificates to be submitted by the manufacture specification.         In-Process Inspection       :Nil         Stage Inspection       :Nil         Final Inspection       :Nil         Stage Inspections       :Nil         Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE         Sr.       Features         No       Criteria         Defect Level         No.       Minor         Dimensional Inspection       :Nil         Geometrical Features       :Nil         Major Dimensions       :Nil         Sr.       Dimensions/Features       Drawing         Sr.       Dimensions/Features       Nicrometre         Minor Dimensions       :Nil       Stage         Sr.       Dimensions/Features       Sneedee         Sr.       Dimensions : Sil       Stage         Sr.       Dimensions/Features       Sneedee         Sr.       Dimensions/Features <td< td=""><td>Drawing No       :PROP/SK-845-25         Method of manufacturing       :Sheet metal         Raw material       :Hot Rolled Medium and High Tensile to IS 2026 :2011, Grade E 250         Test/Checks and acceptance Criteria for raw material:       Mechanical properties and Chemical composition of the material to be checked specification and NABL test Certificates to be submitted by the manufacture a specification.         In-Process Inspection       :Nil         Stage Inspection       :Nil         Final Inspections       :Nil         Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE         Sr.       Features         No.       Inspection         1.       No sharp edges         Ensured       Minor         Sr.       Features         Size: 100% by manufacturer and as per AQL by AHSP/SQAE         Sr.       Features         Major Dimensions       :Nil         Geometrical Features       :Nil         Major Dimensions       :Nil         Sr.       Dimensions/Features       Drawing         No.       Inspection Method       Al         No.       Inspection Method       Al         Sr.       Dimensions/Features       Drawing       Inspection Method         Stample Size: 100% by manufacturer and as per A</td></td<>	Drawing No       :PROP/SK-845-25         Method of manufacturing       :Sheet metal         Raw material       :Hot Rolled Medium and High Tensile to IS 2026 :2011, Grade E 250         Test/Checks and acceptance Criteria for raw material:       Mechanical properties and Chemical composition of the material to be checked specification and NABL test Certificates to be submitted by the manufacture a specification.         In-Process Inspection       :Nil         Stage Inspection       :Nil         Final Inspections       :Nil         Sample Size: 100% by manufacturer and as per AQL by AHSP/SQAE         Sr.       Features         No.       Inspection         1.       No sharp edges         Ensured       Minor         Sr.       Features         Size: 100% by manufacturer and as per AQL by AHSP/SQAE         Sr.       Features         Major Dimensions       :Nil         Geometrical Features       :Nil         Major Dimensions       :Nil         Sr.       Dimensions/Features       Drawing         No.       Inspection Method       Al         No.       Inspection Method       Al         Sr.       Dimensions/Features       Drawing       Inspection Method         Stample Size: 100% by manufacturer and as per A		

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

### 26. LP CONTAINER ASSEMBLY PRIMARY

26.1	Drawing	No				: PROP/SK-845-26		
26.2	Method	of Manufacturing	5			: Assembly		
26.2.1	One set	of Laminated Pa	per Container	Assembly F	Primary	consist of fo	ollowing components and	
	Assemb	blies						
	Sr. No.	Components		Drawing	numbe	r	Qty	
	1.	Sleeve lid su	ub assembly	PROP/SK	-845-27	7	1	
		primary						
	2.	Sleeve sub asse	mbly primary	PROP/SK	-845-30	)	1	
26.3	Raw Ma	terial : Nil						
26.4	Test/Che	ecks and Accepta	nce Criteria for	Raw Mate	rial : Ni	il		
26.5	In-Proce	ss Inspection	: Nil					
26.6	Stage In	spection	: Nil					
26.7	Final Ins	pection	:					
26.8	Visual In	spection	:					
26.8.1	Features	s For visual inspec	tion and accep	tance crite	eria			
	Sr. No.	Acceptance Crit	eria		Samp	le size	Defect Class	
	1.	No cut marks ar	nd tear		100%		Major	
	2.	No any foreign r	naterials and lu	Imp sticks	100%		Major	
		on inner and ou	ter surfaces					
	3.	No swells			100%		Major	
	4.	No De-laminatio	on		100%		Major	
26.8.2	Dimensi	onal Inspection						
26.8.2	Critical [	Dimensions			: Nil			
.1.								
26.8.2	Geomet	rical Features			: Nil			
.2.								
26.8.2	Major D	imensions :						
.3.	Sr. No.	Dimensions/Fea	tures Draw	ving Zone		Inspection N	/lethod	
	1.	437.5±3mm				Steel Rule		
	2.	Ø181±2				Vernier		
26.8.2	Minor D	imensions				: Nil		
.4								
26.9.1	Test on	Finish Items				:		
	Details o	of test/checks on	finished items,	Acceptanc	e criter	ria and other i	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 s	hall be accomr	nodated in	LP con	tainer satisfa	ctorily	
	2	Pull of Test: (Ma	ajor Defect)					
		Sample Size: 3 n	ios per lot					
		Method:						

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

	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. Acceptance Criteria : 250 kg (minimum)
3	<ul> <li>Crushing Test: (Major Defect)</li> <li>Sample Size: 3 nos per lot</li> <li>Method:</li> <li>Cut the container in such a manner as to obtain circular rings representing maximum and where possible4 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/cm<sup>2</sup></li> </ul>
4	<ul> <li>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. Observations: <ul> <li>a. Any damage to CCC</li> <li>b. Loose CC and Steel cup</li> <li>c. Damage to steel cup</li> <li>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)</li> </ul> </li> </ul>
4	<ul> <li>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.</li></ul>

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

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

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

### 27.SLEEVE LID SUB ASSEMBLY PRIMARY

27.1	Drawing No	) : PROP/	SK-845-27					
27.2	Method of	Manufacturing	3	: Ass	: Assembly			
27.2.1	One set of I	_id sub assemb	oly consist of foll	owing co	mponents	5		
	Sr. No.	Components	;	Drawing number			Qty	
	1.	Sleeve lid ou	ter primary	PROP/S	K-845-28		1	
	2.	Washer mill	ooard I	PROP/S	K-845-36		1	
	3.	End cap prim	nary	PROP/S	K-845-31		1	
27.3	Raw Materi	al : Nil						
27.4	Test/Check	s and Accepta	nce Criteria for R	aw Mate	rial : Nil			
27.5	In-Process I	nspection	: Nil					
27.6	Stage Inspe	ction	: Nil					
27.7	Final Inspec	tion	:					
27.8	Visual Inspe	ection	:					
27.8.1	Features fo	r visual inspec	tion and accepta	ince crite	ria			
	Sample 10	0% by factory/	manufacturing C	QC as per	AQL by A	HSP		
	Sr. No.	Acceptance (	Criteria		Defect	AHSP Inte	rvention	
					Class			
	1.	No cut marks	s and tear		Major	Audit		
	2.	No any fore	ign materials ar	nd lump	Major			
		sticks on inn	er and outer surf	faces				
	3.	No swells			Major			
	4.	No De-lamin	ation		Major			
27.8.2	Dimensiona	al Inspection						
27.8.2	Critical Dim	ensions			: Nil			
.1.								
27.8.2	Geometrica	l Features			: Nil			
.2.								
27.8.2	Major Dime	ensions						
.3.	Sr. No.	Dimensions/	Drawing	Inspe	ection Me	thod		
		Features	Zone					
	1.	117		GE N	1ethod			
	2.	104		GE N	lethod			
27.8.2	Minor Dime	ensions		: Nil				
.4								
27.9.1	Test on Fini	sh Items		: Nil	: Nil			
27.10	Other Infor	mation		: Nil				
	a) Cap end	to be secured	by spinning curle	ed edge i	nto sleeve	lid outer us	sing araldite	
	b) araldite t	o be applied in	n the channel of	the cap e	end imme	diately after	r spinning	
27.10.	Adhesive : /	Adhesive used	in L.P. Containe	r assemb	ly is synth	etic resin er	nulsion based adhesive :	
1	P LAM super bond adhesive							

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

### **28.SLEEVE LID OUTER PRIMARY**

28.1	Draw	ving No		: PROP/SK-845-28				
28.2	Meth	nod of Manufacturing			: Integration/Lamination			
28.3.0	Raw	Material			: Kraft board/paper			
28.3.1	Test/ Raw	Checks and Accept Material	ance Crite	eria for	: 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	Mech	nanical Properties			:			
28.3.2	Sr.	Mechanical Propert	ies	Accept	ance (	Criteria		AHSP Intervention
	No.							
	1.	Grade and GSM (g/	m²)	(300-4	50)±7%	%		CP
	2.	Density(g/cm <sup>3</sup> )		0.742 :	± 7%			
	3.	Average Ply bond(J	′m²)	650 ±7	%			
	4.	Cobb g/m <sup>2</sup>		208 ±7	%			
	5.	Moisture Content(%	6)	7.2 ±79	%			
28.4	In-Pr	ocess Inspection	: Nil					
28.5	Stage	Inspection	: Nil					
28.6	Final	Inspection	:					
28.6.1	Visua	Il Inspection	:					
28.6.1	Features for visual inspection and acceptance					ria		
.1	Samp	ble 100% by factory/	manufactu	ring QC	as per	AQL by A	HSP	
	Sr.	Acceptance Criteria				Defect	AHSP	P Intervention
	NO.						<u> </u>	
	1.	No cut marks and te	ear ariala and h			Major		
	Ζ.	inner and outer sur	facos	ump stic	KS ON	iviajor		
	2		laces			Major	-	
	<u>э</u> . л	No De-lamination				Major		
2862	Dime	no be lamination				Iviajoi		
28.6.2	Critic	al Dimensions				: Nil		
.1								
28.6.2	Geon	netrical Features				: Nil		
.2								
28.6	Majo	r Dimensions						
2.3.	Sr.	Dimensions/Feature	es Drawi	ng	Inspe	ection Me	thod	AHSP Intervention
	No.		Zone					
	1.	Ø181+1			GE N	lethod		SP
	2.	Ø174+1				lethod		
	3.	117±1			GE M	lethod		
28.6.2 .4	Mino	or Dimensions			: Nil			
28.7.0	Prote	ective Finish:						
	To be	e coated externally w	ith two coa	ats of po	lyuret	hane coat	ing pap	per.
28.8.0	Othe	r Information		: Nil				

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

### 29.WASHER MILLBOARD I

29.1	Draw	ving No			:PROP/SK-845-36				
29.2	Meth	nod of Manufacturing	5		: Cutting/Punching				
29.3.0	Raw	Material			:Mill board/paper				
29.3.1	Test/	Checks and Accept	ance Crite	eria for	: To check properties for information only				
	Raw	Material							
	Sr.	Mechanical Proper	ties	Accept	ance Criteria AHS		AH	SP Intervention	
	No.		2.					-	
	1.	Grade and GSM (g/	m²)	(300-4	50)±7%	%	Au	dit	
	2.	Density(g/cm <sup>3</sup> )		0.742 :	± 7%				
	3.	Average Ply bond(J	/m²)	650 ±7	%				
	4.	Cobb g/m <sup>2</sup>		208 ±7	%		_		
	5.	Moisture Content(9	%)	7.2 ±79	%				
29.4	In-Pr	ocess Inspection	: Nil						
29.5	Stage	Inspection	: Nil						
29.6	Final	Inspection	:						
29.6.1	Visua	Il Inspection	:						
29.6.1	Featu	ires for visual inspec	tion and ac	ceptanc	e crite	ria			
.1	Samp	ble 100% by factory/	manufactu	ring QC	as per	AQL by A	HSP		
	Sr.	Acceptance Criteria	eptance Criteria					Intervention	
	INO.						<u> </u>		
	1.	No cut marks and t	ear oriols and h	uma stic	kaon	Major	SP		
	Ζ.	inner and outer sur	faces	ump suc	KS OTI	IVIAJOI	55		
	3.	No swells				Maior	SP		
	4.	No De-lamination				Major	SP		
29.6.2	Dime	nsional Inspection				,	1		
29.6.2	Critic	al Dimensions				: Nil			
.1									
29.6.2	Geon	netrical Features			: Nil				
.2									
29.6	Majo	r Dimensions							
2.3.	Samp	ple : Sample Size : 10	0% by facto	ory QC a	nd as p	per AQL by	y AHSP	1	
	Sr.	Dimensions/Featur	es Drawi	ng	Inspe	ection Me	thod	AHSP Intervention	
	No.		Zone						
	1.	Ø174+1			GE M	lethod		SP	
	2.	Ø60+1			GE M	lethod		SP	
	3. Thickness 4					lethod		SP	
29.6.2	Mino	or Dimensions			: Nil				
29.7.0	Protective Finish:								
	To be	e coated externally w	ats of po	olvurethane coating paper					
29.8.0	Any (	Other Information			: Nil		01-91		

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
lssue:01	Date	Dec-	Revision	Revision 00 Date:					
		2023	No.						
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm I	HE			

### **30.END CAP PRIMARY**

30.1	Draw	ing No		:	PROP/SK-8	845-31			
30.2	Meth	od of Manufacturing	3	: 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 Accept	ance Criteria for	: NABL test Certificates to be submitted by the					
	Raw	Material		m	nanufactu	re as	per specification or Original		
				manufactures Certificate					
30.3.2	Chen	nical Composition	: As per Specificat	ion (For information only)					
30.4	In-Pr	ocess Inspection	: Nil						
30.5	Stage	Inspection	: Nil						
30.6	Final	Inspection	:						
30.6.1	Visua	I Inspection	:						
30.6.1	Featu	ires For visual inspec	tion and acceptant	e crite	eria				
.1	Sr.	Acceptance Criteria	1		Sample	Defe	ct		
	No.				Size	Class			
	1.	No Cracks			100%	Majo	r		
	2.	No sharp Edges			100%	Majo	r		
30.6.2	Dime	nsional Inspection							
30.6.2	Critic	al Dimensions			: Nil				
.1									
30.6.2	Geon	netrical Features			: Nil				
.2									
30.6.2	Majo	r Dimensions							
.3.	Samp	le 100% by factory/	manufacturing QC	and as	per AQL	by AHS	P		
	Sr.	Dimensions/Featur	es Drawing	Inspe	ection Met	thod	AHSP Intervention		
	No.		Zone						
	1.	Ø184.5-1		GE N	lethod		SP		
	2.	Ø175+1		GE N	lethod				
	3.	Sheet Thickness 1m	ım	GE N	lethod		SP		
	4.	Ø57		GE N	lethod		SP		
30.6.2	Mino	r Dimensions		: Nil					
.4									
30.7.0	Prote	ective Finish:	10	~					
	1. Phosphating to specification is 1279, Class II								
20.0.0	2	. Polyster powder	coating of 60-80 mi	cron					
30.8.0	Any (	Other Information		: NII					
	Embo	ossing/Painting:							
	"12ENANA HE BESIN CCC"								
	125MIN HE - RESIN CCC								
	Reco	gnized trade mark							
		or manuracture (MIN	/// T Y Y Y )						
1	Pull C	n idad 250kg minimi	1111						

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023							
Issue:01	Date	Dec-	Revision	Revision 00 Date:						
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm l	HE				

## **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 ass	embly cons	ist of fol	llowing	g compon	ents		
	Sr. No.	Components		Drawii	ng num	g number			Qty
	1.	End cap primary	/	PROP/	SK-845	x-845-31			1
	2.	Sleeve inner pri	mary	PROP/	SK-845	(-845-32			1
	3.	Sleeve outer pri	imary	PROP/	SK-845	5-33		:	1
	4.	Sleeve inner 2 p	rimary	PROP/	SK-845	5-29			1
	5.	Paper disc prim	ary	PROP/	SK-845	5-34		:	1
31.3	Raw Ma	terial : Nil							
31.4	Test/Che	Test/Checks and Acceptance Criteria for Raw Material : Nil							
31.5	In-Proce	ss Inspection	: Nil						
31.6	Stage Ins	spection	: Nil						
31.7	Final Ins	pection	:						
31.8	Visual Inspection :								
31.8.1	Features	s for visual inspec	tion and ac	ceptanc	e crite	ria			
	Sample	100% by factory/	manufactu	ring QC	as per	AQL by A	HSP		
	Sr. No.	Acceptance Crit	eria			Defect	AHSP	Interv	rention
						Class			
	1.	No cut marks ar	nd tear			Major	Audi	t	
	2.	No any foreig	n material	s and	lump	Major			
		sticks on inner a	and outer s	urfaces			-		
	3.	No swells				Major			
	4.	No De-laminatio	on			Major			
31.8.2	Dimensi	onal Inspection				<b>N</b> 111			
31.8.2	Critical L	Dimensions				: NII			
.1.	Coomet	rical Faaturas				• NI1			
21.0.2	Geometi	fical realures				. 1111			
.2.	Maior Di	imensions							
31.0.2	Sr No	Dimensions/Fea	atures Dra	awing	Insne	ection Me	thod	ΔΗSE	Intervention
	51.100.		Zo	ne			liiou		
	1.	96.5			GE N	lethod		SP	
	2.	318.50			GE M	lethod		]	
	3.	Ø 161.50			GE M	lethod			
	4.	Ø 181			GE N	lethod			
	5.	Ø 174			GE N	lethod			
31.8.2	Minor D	imensions		: Nil					
.4									
31.9.1	Test on Finish Items : Nil								
31.10	Other In	formation			:				
	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.	Adhesive	e : Adhesive used	in L.P. Con	tainer a	ssemb	ly is synth	etic res	sin em	ulsion based adhesive :
1	P LAM su	uper bond adhesi	ve						

QUALITY	ASSURA	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	Revision 00 Date:					
		2023	No.						
Compone	ent / Asse	embly	Steel Pa	ckage	for 125mm I	HE			

### **32. SLEEVE INNER PRIMARY**

32.1	Drawing N	No			: PR	OP/SK-845	5-32		
32.2	Method o	of Manufacturing	B		: Inte	egration /	Lamina	ation	
32.3.0	Raw Mate	erial			:Kra	ft board/	paper		
32.3.1	Test/Cheo	cks and Accept	tance Crit	eria for	: NABL test Certificates to be submitted by the				
	Raw Mate	erial			manufacture as per specification or Original				
					man	ufactures	Certifi	cate or Test at vendors place	
					with calibrated equipments				
32.3.2	Mechanic	al Properties		:					
	Sr. No.	Mechanical Pr	operties	Accept	ance (	Criteria		AHSP Intervention	
			• ( 1 2)	(222.4)					
	1.	Grade and GS	VI (g/m²)	(300-4	50)±7%	%		СР	
	2.	Density(g/cm <sup>3</sup>	)	0.742 ±	: 7%				
	3.	Average Ply bo	ond(J/m²)	650 ±7	%				
	4.	Cobb g/m <sup>2</sup>		208 ±7	%				
	5.	Moisture Cont	ent(%)	7.2 ±79	6				
32.4	In-Process	s Inspection	: Nil						
32.5	Stage Insp	pection	: Nil						
32.6	Final Insp	ection	:						
32.6.1	Visual Ins	pection	:						
32.6.1	Features f	for visual inspec	tion and a	cceptance	e crite	ria			
.1	Sample 1	00% by factory/	manufact	uring QC a	as per	AQL by A	HSP		
	Sr. No.	Acceptance Cr	iteria			Defect	AHSP	Intervention	
	1	No cut marks	and toor			Major	CD.		
	1.	No cut marks a	anu tear matari	alc and I	ump	Major	58		
	2.	sticks on inner	and outer	ais anu i surfaces	ump	IVIAJOI			
	3			Surraces		Maior	-		
	۵. ۵	No De-laminat	ion			Major	1		
32.6.2	Dimensio	nal Inspection				major			
32.6.2	Critical Di	mensions				: Nil			
.1									
32.6.2	Geometri	cal Features				: Nil			
.2									
32.6	Major Din	nensions							
2.3.	Sample : S	Sample Size : 10	0% by fact	ory QC ar	nd as p	ber AQL b	y AHSP		
	Sr. No.	Dimensions/Fe	Drawing	Insp	ection Me	ethod	AHSP Intervention		
			Zone						
	1.	Ø174-1			GE			SP	
	2.	Ø161.5			GE			SP	
	3.	406		GE			SP		
32.6.2	Minor Din	or Dimensions							
.4									
32.7.0	Protective	e Finish:			: Nil				
32.8.0	Any Othe	r Intormation			I:Nil				

QUALITY	ASSURAN	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023							
Issue:01	Date	Dec-	Revision	Revision 00 Date:						
		2023	No.							
Compone	ent / Asse	mbly	Steel Pa	ickage	for 125mm I	HE				

#### **33. SLEEVE OUTER PRIMARY**

33.1	Drawing	No		: PROP/SK-845-33					
33.2	Method	of Manufacturing			: Integration /Lamination				
33.3.0	Raw Ma	terial			:k	Kraft boar	d/pape	er	
33.3.1	Test/Cho Raw Ma	ecks and Accepta terial	ance Criteria	a for	<ul> <li>NABL test Certificates to be submitted by the manufacture as per specification or Original manufactures Certificate or Test at vendors place with calibrated equipments</li> </ul>				
33.3.2	Mechan	ical Properties							
	Sr. No.	Mechanical Properties A			Acceptance Criteria				AHSP Intervention
	1.	Grade and GS	(3	300-45	60)±7%			СР	
	2.	Density(g/cm	3)	0	.742 ±	7%			
	3.	Average Ply b	ond(J/m²)	6	50 ±7%	%			
	4.	Cobb g/m <sup>2</sup>		2	08 ±7%	6			
	5.	Moisture Con	tent(%)	7	.2 ±7%	, D			
33.4	In-Proce	ss Inspection	: Nil						
33.5	Stage In	spection	: Nil						
33.6	Final Ins	pection	:						
33.6.1	Visual In	spection	:						
33.6.1	Features	s for visual inspect	ion and acce	ptanc	e crite	ria			
.1	Sample	100% by factory/r	nanufacturir	ig QC	as per	AQL by A	HSP	1	
	Sr. NO.	Acceptance Crite	ria			Class	AHSP	Inter	vention
	1.	No cut marks and	d tear			Major	SP		
	2.	No any foreign m	aterials and	lump	sticks	Major			
		on inner and out	er surfaces				-		
	3.	No swells				Major	-		
	4.	No De-laminatio	n			Major			
33.6.2	Dimensi	onal Inspection							
33.6.2	Critical [	Dimensions				: Nil			
.1	Casara	wing I Frank was							
33.6.2	Geomet	rical Features				: NII			
.2	Major D	imensions							
33.0.2	Sample	· Sample Size · 100	1% hy factory		nd as r		/ ΔΗςρ		
	Sr No	Dimensions/Feat	Drawing	QC u	Inspe	ection Me	thod	AHS	P Intervention
	51.110.	res			mspc		liidu		
	1.	Ø181±1						SP	
	2.	Ø174±1						SP	
	3.	318.5-1		GE			SP		
33.6.2	Minor Dimensions							1	
.4									
33.7.0	Protective Finish:					1:			
	To be co	ated externally wi	th two coats	of po	lyuret	hane coat	ing pap	oer.	
33.8.0	Any Oth	er Information			: Nil				

QUALITY	ASSURA	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023							
Issue:01	Date	Dec-	Revision	Revision 00 Date:						
		2023	No.							
Compone	ent / Asse	embly	Steel Pa	ickage	for 125mm I	HE				

### **34. SLEEVE INNER 2 PRIMARY**

34.1	Drawing	No	: PROP/SK-845	-29						
34.2	Method	of manufacturing	:Integration / I	aminatio	n					
34.3.0	Raw ma	terial	:Kraft paper/Corrugated sheet							
34.3.1	Test/Ch	ecks and acceptance	:NABL test certificates to be submitted by the manufacture							
	Criteria	for raw material	as per specifica	as per specification or, Original manufactures Certificate or						
			Test at vendor	Test at vendors place with calibrated equipments.						
34.3.2	Mechan	ical Properties	:Nil	:Nil						
34.4	In-Proce	ss Inspection	:Nil							
34.5	Stage In	spection	:Nil							
34.6	Final Ins	pection :								
34.6.1	Visual In	spections								
34.6.1.1	Features	s for Visual Inspection ar	nd acceptance Cri	teria.						
	Sample	Size: 100% by factor QC	and as per AQL b	y AHSP						
	Sr. No.	Acceptance Criteria		Defect	AHSP intervention					
				class						
	1.	No cut Marks and Tea	irs	Minor	SP					
	2.	No any foreign matte	rs and lump	Minor	]					
		sticks on inner and ou	iter surfaces							
	3.	No swells		Minor						
	4.	No De-lamination	Minor							
34.6.2	Dimensi	onal Inspection								
34.6.2.1	Critical [	Dimensions	:Nil							
34.6.2.2	Geomet	rical Features	:Nil							
34.6.2.3	Major D	imensions	:Nil							
34.6.2.4	Minor D	imensions								
	Sr.	Dimensions/Features	Drawing Zone		Inspection	AHSP				
	No.				Method	Intervention				
	1.	Ø161			GE	Audit				
	2.	Ø160			GE					
	3.	256			GE					
	4.	Corrugated sheet			GE					
		thickness 0.5	.5							
34.7.0	Protecti	ve finish : Nil								
34.8.0	Any oth	er information: Nil								

QUALITY	ASSURA	NCE PLAN	Document No.: MIL-OFCH-QAP-125MM HE-EX-12-2023						
Issue:01	Date	Dec-	Revision	00	Date:				
		2023	No.						
Compon	ent / Asse	embly	Steel Pa	ckage	for 125mm l	HE			

### 35. PAPER DISC PRIMARY

35.1	Drawing No		: PROP/SK-845-34					
35.2	Method of manufacturing		:Integration / lamination					
35.3	Raw ma	terial	:Mill board	: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		1 <sup>2</sup> )	(300-450) ± 7%				
	2.	Density (g/cm <sup>3</sup> )		0.742 ± 7%				
	3.	Average Ply bond (J/	Average Ply bond (J/m <sup>2</sup> )		650 ± 7%			
	4.	Cobb g/m <sup>2</sup>		208 ±7 %				
	5.	Moisture Content (%)		7.2 ± 7%				
35.5	In-Process Inspection		:Nil	Nil				
35.6	Stage In	ge Inspection :Nil						
35.7	Final Inspection :							
35.7.1	Visual Inspections							
	Features for Visual Inspection and acceptance Criteria to be carried before the final wielding.							
	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 tea	r	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.	Dimensions/Features	Drawing Zone		Inspection	AHSP		
	No.				Method	Interve	ention	
	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							