

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5152869								QAP No: OFT/QAP/M2HB/5152869
Nomenclature	PLATE, BUFFER, OOW50BMG : REQD. FOR WITH SAFETY, SPADE GRIP ASSEMBLY (6535477-S)								
Material	STEEL, ASTM A322 OR A331:4147, 4150, 6150, 41L50								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Plate, Buffer (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A322 OR A331:4147, 4150, 6150, 41L50		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 5152869	HEAT AT 816°C - 843°C IN A PROTECTIVE ATMOSPHERE. OIL QUENCH. TEMPER FOR 1 HOUR MIN TO RH C50-57 (FOR MATL. 4147, 4150)	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171	Finish 5.3.1.2 (or) 5.3.2.2	Test report from NABL lab	R	
In process -As per Drawing 5152869	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5152869		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5152869		Firm Inspection report	W	

(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for out sourced components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.

PNAI

Civilian Technical Officer (Mof)

In-charge Inspector Of Naval Armament

Chennai

OFT

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ASST WORKS MANAGER

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CHENNAI