

आयुध विकास केन्द्र

आयुध निर्माणी कानपुर
कालपी रोड कानपुर - 208009

ORDNANCE DEVELOPMENT CENTRE

ORDNANCE FACTORY KANPUR
KALPI ROAD KANPUR - 208 009



भारत सरकार
रक्षा मंत्रालय
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GOVERNMENT OF INDIA,
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ORDNANCE FACTORY BOARD

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15818/Sharang

Date: 06.06.2018

To,
The Sr. General Manager
OFC, Kanpur

(Kind Attn: Shri Alok Kumar, Jt.GM/MMG-I)

QAP for Rammer Assembly

Rammer Assembly of "Sharang" is a unit which is used for ramming of projectile (projectile weight \approx 45 Kg) during firing and is a critical assembly.

Testing and acceptance criteria for Rammer Assembly-

The inspection method includes:-

- Visual Inspection including Dimensional reports, Testing of materials as per applicable drawings and specifications.
- Compressed Gas supply properly installed.
- Proper functioning of loading Tray & rammer.
- Conduct 3 ramming operations at 40° elevation.
- No lack of parts and proper securing. No cracks or burrs. Parts need to be properly welded together.

Pneumatic Rammer

- Telescopic type with stroke length 1200mm.
- Operating pressure 7 to 8 bar, and pressure in main cylinder must be at least 150 bar and associated pipings.
- Pneumatic circuit should include high pressure cylinder with regulator valve, baby cylinder and lubrication system all connected by quick change couplings. Pneumatics must have a capability of at least 200 bars.

Testing of Rammer at Firms Premises

- The complete Rammer Assy/including Pneumatic cylinder, tubing, pipes, fasteners, Loading tray assy & Rammer cylinders assy is to be set up at firms premises duly integrated.
- The system will be charged for design pneumatic and will left be open for operation. There should be no leakages from any points/pressure valves/connections etc.

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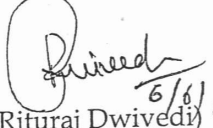
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3. The rammer will be tested by actual ramming of a 45 Kg (approx) cylindrical object of dia 155mm at shop floor level (0° elevation) for 10 times
4. When the rammer is installed on the Gun, the ramming at 40° elevation will be done three times. There should not be any leakages/sticking up at rammer.

VERY IMPORTANT:- The above acceptance criteria is "over-and-above" the individual QC aspects wherein all the relevant parts/components are to be made as per drawings. In other words, this is a final acceptance criteria "presuming" that all components are as per drawing.


(Rituraj Dwivedi)
6/6/18
Director