

QAP FOR TEAR GAS GUN

QAP/TGG/9093/2


DATE: 20/07/2019

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1	NOMENCLATURE	INVESTMENT CASTING FOR TRIGGER		
2	DRG. NO. / D. S. CAT NO.	RFI SK NO-9093-GG/A		
3	MATERIAL SPECIFICATION	BS : 3146 PT-I 1974; TYPE CLASS 12 GP C		
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING		
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING		
6	DOCUMENT VERIFICATION	A) SUPPLY ORDER		E) MECHANICAL TEST CERTIFICATE
		B) MIS		F) CRACK DETECTION CERTIFICATE
		C) BATCH NO.		G) PRE-INSPECTION REPORT
		D) CHEMICAL TEST CERTIFICATE		H) BATCH SIZE
7	VISUAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-1.5 IS:2500(PT. 1):2000.	A) CASTING SHOULD BE FREE FROM CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH. B) MARKINGS :- AS PER DRAWING.		
8	DIMENSIONAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 OF IS:2500(PT. 1):2000.	SL. NO.	AUDIT POINTS/ DIMENSIONS	GAUGE NO. / METHOD
		1.	DIMN. 16.45	GAUGE/ GE METHOD
		2.	DIMN. 9.9	GAUGE/ GE METHOD
		3.	DIMN. 15.25	GAUGE/ GE METHOD
		4.	DIMN. 5	GAUGE/ GE METHOD
		5.	DIMN. 7.5	GAUGE/ GE METHOD
9	TREATMENT	CASTING TO BE SUPPLIED FINALLY AFTER ANNEALING, TEMPERING & HARDENING TO BHN 248-302		
10	PROTECTIVE FINISH	IC SHOULD BE PRESERVED WITH OIL.		
11	OTHER TEST/CHECK	1) FITMENT AND FUNCTIONAL TRIAL 2) FOR OTHER TEST FOLLOW NOTES & INSPECTION CRITERIA IN THE DRAWING.		

NOTE :-

- 1) PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
- 2) TEST REPORT IS TO BE ISSUED FROM NABL APPROVED LAB / DGQA LAB / DGQA APPROVED LAB / ORDNANCE FACTORIES LAB.
- 3) RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
- 4) ENSURE MARKING OF MANUFACTURER'S CODE (IF MENTIONED IN THE DRAWING) ON THE STORE SUITABLY & ENTRY OF LOT NO. & YEAR OF MANUFACTURE IN PRE-INSPECTION REPORT.
- 5) TEST PIECES (ALONGWITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECIFICATION ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.


20/7/19
REP. OF ODC


23/7/19
HOS/ODC


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REP. OF QC