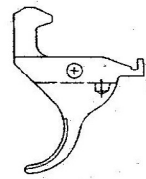


QUALITY ASSURANCE PLAN

RIFLE 5.56 mm. INSAS.

(METALLIC COMPONENT)



1	NOMENCLATURE		TRIGGER			
2	DRG. NO./D.S.CAT.NO.		1005-560044 RFI SK. 7057*-S			
3	MATERIAL SPECIFICATION		STEEL BS:970 PT.1:1983 GRD.655 M13. IS:4432-1988, DESIG 13Ni13Cr3			
4	CHEMICAL COMPOSITION		AS PER SPECIFICATION/DRAWING.			
5	PHYSICAL PROPERTIES		AS PER SPECIFICATION/DRAWING.			
6	THE FOLLOWING DOCUMENTS ARE TO BE VERIFIED/SUBMITTED.					
	a) SUPPLY ORDER.		f) CRACK DETECTION CERTIFICATE.			
	b) MIS.		g) CASE DEPTH CERTIFICATE.			
	c) BATCH NO./HEAT NO.		h) PRE INSPECTION REPORT.			
	d) CHEMICAL TEST CERTIFICATE.		i) BATCH SIZE.			
	e) MECHANICAL TEST CERTIFICATE.					
7	VISUAL CHECKING.		I) COMPONENT SHOULD BE FREE FROM CRACKS, SHARP EDGES & BURRS.			
	SAMPLE SIZE, AS PER GENERAL INSPECTION LEVEL 1 & 2 OF IS:2500 (PT.I):2000.		II) MARKINGS :- AS PER DRG.			
8	DIMENSIONAL CHECKING, SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL I OF IS:2500 (PT.I):2000.					
	SL. NO.	AUDIT POINTS	DRG. ZONE	GAUGE NO./METHOD	CLASS OF DEFECT (DCL)	ACCEPTANCE (AQL AS PER IS:2500)
	1	+0.05 ±5° 16.6 AT 18°	C-4 D-4	* RFG-21667-S	CRITICAL	1.5
	2	±0.1 8.5 AT 15°	B-3 B-1	* RFG-21078-S * RFG-21079-S	MAJOR	2.5
	3	-0.1 3.9,7.3 AT 20°	D-4 D-3	RFG-22482-S	-DD-	-DD-
	4	+0.05 5.0ø	C-4	RFG-22313-S RFG-22314-S	-DD-	-DD-
	5	4.0 +0.1	D-6	RFG-21243-S RFG-21244-S	-DD-	-DD-
	6	-0.01 +0.1 19.6, 7.0, -0.01 19.0 & 2.0	C-2 C-3 D-4	* RFG-22486/1-S RFG-22134-S	-DD-	-DD-
	SHT. 1 OFF 2					