

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	5351220							QAP No: OFT/QAP/M2HB/5351220	
Nomenclature	SLIDE SEAR, OOW50BMG :REQD FOR BOLT ASSEMBLY BREECH (5428322)								
Material	ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 6150, 4340, 4140; ALLOY STEEL BARS, COLD FINISHED, ASTM A331, GRADES 6150, 4340, 4140. ALT.MATL: ALLOY STEEL BARS, HOT WROUGHT, ASTM A322, GRADES 6150, 4340, 4140. ALLOY STEEL PLATES, ASTM A829, GRADES 6150, 4340, 4140. ALLOY STEEL SHEET STRIP PLATE, AMS 6359 (GRADE 4340); ALLOY STEEL SHEET, STRIP, PLATE AMS 6395 (GRADE 4140); ALLOY STEEL SHEET, PLATE STRIP , SAE AMS 6455 (GRADE 6150)								
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
Slide Sear (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 6150, 4340, 4140; ALLOY STEEL BARS, COLD FINISHED, ASTM A331, GRADES 6150, 4340, 4140. ALT.MATL: ALLOY STEEL BARS, HOT WROUGHT, ASTM A322, GRADES 6150, 4340, 4140. ALLOY STEEL PLATES, ASTM A829, GRADES 6150, 4340, 4140. ALLOY STEEL SHEET STRIP PLATE, AMS 6359 (GRADE 4340); ALLOY STEEL SHEET, STRIP, PLATE AMS 6395 (GRADE 4140); ALLOY STEEL SHEET, PLATE STRIP , SAE AMS 6455 (GRADE 6150)		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%		FOR 6150: HEAT AT 843°C TO 871°C. OIL QUENCH. TEMPER FOR 1 HOUR MINIMUM TO HARDNESS SPECIFIED (RH C45-51) FOR 4340: HEAT AT 815.5°C TO 843°C. OIL QUENCH. TEMPER FOR 1 HOUR MINIMUM TO HARDNESS SPECIFIED (RH C45-51)	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 5351220	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5351220		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5351220		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.

P. Anandaram
 P. Anandaram
 NAI
 Civilian Technical Officer (Mech)
 for Principal Inspector Of Naval Armament
 Murchirappalli

OFT
 G. DEVENDIRANE, I.O.F.S.
 ASST. WORKS MANAGER
 GOVT. OF INDIA, MIN. OF DEFENCE
 ORDNANCE FACTORY
 MURCHIRAPPALLI