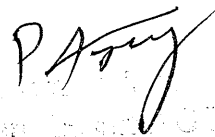


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6008949								
Nomenclature	LATCH, BACK PLATE,OOW50BMG. : REQD. FOR WITH SAFETY, SPADE GRIP ASSEMBLY (6535477-S)								
Material	STEEL,ASTM A331 OR A322: 4140, 4150 OR SPEC MIL-S-22141, IC-4140.								
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
Latch, Back Plate (Raw material)	General appearance	Non Critical	Visual	100%	STEEL,ASTM A331 OR A322: 4140, 4150 OR SPEC MIL-S-22141, IC-4140.		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 6008949	HEAT AT 838°C - 860°C OIL QUENCH. TEMPER ONE HOUR MINIMUM TO RH C38-46.	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 6008949	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 6008949		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 6008949		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.

NAI

 Project Engineer
 Ordnance Factory
 Tiruchirappalli

OFT

G. DEVENDIRANE, I.O.F.S.
ASST WORKS MANAGER
GOVT. OF INDIA, MIN. OF DEFENCE
ORDNANCE FACTORY
TIRUCHIRAPPALLI, TAMIL NADU