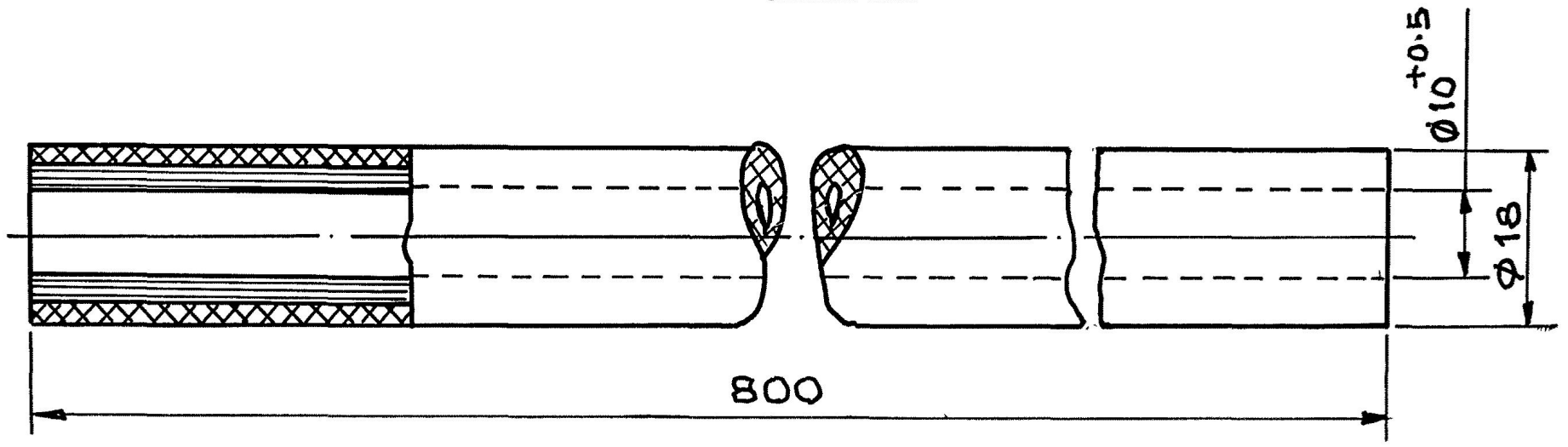


4 3 2 1
 DS CAT NO. 4720-003007
 FOR EXPLANATION OF DIMENSIONING ETC, SEE ARDE
 NOTE SHT. NO.1
 DIMNS. ARE IN mm, UNLESS OTHERWISE STATED

DETAIL OF MTL BG 20-7 PERBUNAN RUBBER

1	COLOUR	BLACK
2	SPECIFIC GRAVITY	MAX 1.6
3	TS MPa	12.25
4	TS AFTER AGEING MPa	8.82
5	ELONGATION AT RUPTURE%	250
6	ELONGATION AT RUPTURE AFTER AGEING	175
7	REMAINING ELONGATION %	MAX 8
8	HARDNESS AT +20°C. °SHORE	70-79
9	HARDNESS AFTER AGEING SHORE	MAX 85

CONSTRUCTION AS PER IS: 911, TYPE-3



NOTE:-

HOSE (INA-0413) TO M/S SUNDARAM & CLAYTON MAKE NO.M 901460 (MX914000) MAY BE USED IN PLACE OF HOSE TO DS CAT NO.4720-003007 AND CLIP HOSE FOR HOSE TO DS CAT NO.LV6/MT1/1A-34191 QTY-2.

TEST PRESSURE 1961 KPa MIN.

12-11-03	18819-W		HINDI NOMEN ADDED			CQA(W) JABALPUR
8-8-02			RETRACED WITHOUT CHANGE			DRN- CHD-
			PREV.DC(1) NOS-15961-W, 16095-W, 16424-W & 18640-W/DT-5.7.2001.			TCD- Prof. <i>[Signature]</i> CHD-SK1
DATE	AUTHY	ZONE	NATURE	SIG AHSP	SIG DO	for <i>G.P. Shukla</i> C/D' MAN DO
AMENDMENTS						AHSP DO CQA(W)
DRG. SEALED- 16095-W			23.12.83		DO CQA(W)	DO CQA(W)
SCALE- 1:1		ESTD mass-		DATE-15.5.71		DESIGN NO. D6P-020402
MATL- BG 20-7 RUBBER						PART NO.
ASSY. DRG- 1015-000272 1015-000265					IFL 7239	
HOSE होज						DS CAT NO. 4720-003007

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Project : FG

**ACCEPTANCE TEST PROCEDURE (ATP) OF
HOSE**

DRG. NO.- DS CAT NO. 4720-003007

Item Code : 9080079069

Prepared and published by



Gun Carriage Factory

A Unit of Advanced Weapons and Equipments India
Ltd.

Government of India, Ministry of Defence,

Jabalpur (MP) 482011



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QAP/ATP

This quality plan is a general guide to meet the quality requirements of product. It consists of applicable procedures (describing production processes, inspection & testing instructions), applicable workmanship standards, the measurement tolerances acceptable, the description of material standards and so forth. It also mentions the list of documents, test certificates that will be submitted by firm to GCF along with finished component.

1. Nomenclature & Drawing No. – HOSE

DS CAT NO. 4720-003007

2. Material & Condition : As per Standard given in drawing.

2.1 Test/Checks and Acceptance criteria for Material.

Sr.	TEST/CHECK	TYPE/APPLICATION REQUIREMENT		PARAMETER	ACCEPTANCE
1	Functioning parameters	LOW PRESSURE TYPE OR MEDIUN PRESSURE OR HIGH PRESSURE	STATIONARY OR MOVABLE	Grooves,shapes	As per Standard
				Degree of surface smoothness	As per Standard
				Grip	As per Standard
				Maximum working pressure	As per Standard
				Diameters of C/S of o-ring	As per Standard
				Care for damage against EDGES/HOLES/THREAD ETC.	As per Standard
				Bright/scratches & damage free.	As per Standard

Note – The entire material required for manufacture of the store shall be procured as far as possible in bulk to meet the entire quantity. These materials shall be initially tested for functioning parameters and other working condition required before undertaking of manufacture of component.

2.2 Manufacturer to supply one test piece along with bulk supply. (Factory may check chemical and mechanical properties whenever required)

3. Method of manufacture : Machining & other operations as per process. During and after machining, all dimensions and surface finish should be maintained as per specified drawing.

4.0 Inspection: Following methodology is to be followed for inspection.

4.1 Mode of Inspection & Sample Size/Selection:

(a) **At Firm Premises:** Inspection by the manufacturer for 100% quantities of lot size.

(b) **At receipt End:** Inspection by MID/QC (GCF Rep.) at receipt at GCF. Sample selection as per existing IS standard 2500 part-II, 1965.

4.2 Visual Inspection

S.NO.	DETAILS OF FEATURE	ACCEPTANCE CRITERIA
A	Scratches	Not allowed
B	Complete surface of the rubber component	As per drawing

4.3 Dimensional Inspection: all dimensions (critical, major & minor in nature) & geometrical features of drawings are to be covered in check sheet and should be duly inspected by concerned quality control section. Components, having dimensions as per drawing, should only be accepted by inspectorate. No deviation in dimension or in geometrical feature is permitted.

5. Other Test on Semi-finished/finished Component.

5.1 Details of tests /check on Semi-finished/ finished items and acceptance criteria:

S No.	TEST / CHECK	SAMPLE SIZE	ACCEPTANCE CRITERIA
A	Working pressure/ Shaping, placing, surface smoothness of grooves respectively	100%	As per Standard.

6. List of Documents:

(To be submitted by firm along with finished component during factory end inspection)

- (1) Dimensional Acceptance I-note checked by QC (Firm) with check-sheet as per Para 4.3. (Sample-100%)
- (2) NABL/Govt. approved Lab certificate required for material that includes all the test observations.

Date:-29/11/2022

**Prepared By
HOS/SC**

**Approved By
Controlling Officer
(QC Section)**