

**MANUFACTURING QUALITY PLAN - ROCKET SHELL - RGB 60**

ITEM DESCRIPTION	<b>BODY MOD 1</b>
REF. DOCUMENT	NASK 1134/1/1/1 (P)
RAW MATERIAL	Steel to Spec ASTM 106 Gde.B

Component name/operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI
<b>Body (Raw material)</b>	General finish, appearance	Semi critical	Visual	100% or as per the discretion of inspection authority	ASTM 106 Gde.B	ASTM 106 Gde.B	Inspn. Report	V/s. Inspn.
	Chemical properties	Critical	Chemical lab analysis	Three Samples per lot or as per the discretion of inspection authority			Test report from NABL Lab	Accept. By NAI
	Mechanical properties	Critical	Mechanical lab analysis	Three Samples per lot or as per the discretion of inspection authority			Test report from NABL Lab	Accept. By NAI
<b>In process (Turning)</b>	Dimensions specified in Inspection Report for the Component.	Critical	Dimensional measurement	100% or as per the discretion of inspection authority	Tolerances specified as per Drg. NASK 1134/1/1/1(P)	Tolerances specified as per Drg. NASK 1134/1/1/1(P)	NAI Inspection report	Accept. By NAI
<b>UT Testing</b>		Critical		100% or as per the discretion of inspection authority	IS 8791/98 class 'A' for ferritic steel forging or ASTM E213 for seamless tube cold finished condition & Annealed condition	IS 8791/98 class 'A' for ferritic steel forging or ASTM E213 for seamless tube cold finished condition & Annealed condition	NAI Inspection report	Accept. By NAI
<b>Final finish</b>	PU Paint on external xxx surfaces only.	Critical	Visual & as specified in specification.	100% or as per the discretion of inspection authority	Specification given by NAI	As specified in specification.	NAI Inspection report	Accept. By NAI
	H gh point area dia.211.9 not to be painted	Critical	Visual for no paint in this region	100% or as per the discretion of inspection authority	DRG. NASK 1134/1/1/1(P)	NAI Inspn. Report	NAI Inspn. Report	Accept. By NAI

**VETTED**

*[Signature]*  
14 Feb 2020  
Naval Armament Inspectorate  
Tiruchirappalli