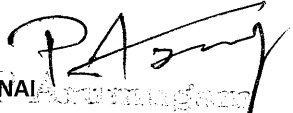



**PAWL ASSEMBLY BELT HOLDING (7313083)**

<u>SL.NO</u>	<u>PART NO.</u>	<u>ASSY/COMPONENT</u>	<u>NOMENCLATURE</u>	<u>PAGE</u>
1	7313081	COMPONENT	PAWL, BELT HOLDING, LEFT HAND	237
2	7313082	COMPONENT	PAWL, BELT HOLDING, RIGHT HAND	238
3	7160627	COMPONENT	SLEEVE, BELT HOLDING PAWL	239

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313083								QAP No: OFT/QAP/M2HB/7313083
Nomenclature	PAWL ASSEMBLY BELT HOLDING , OOW50BMG. REQD FOR HB ASSEMBLY (7265636)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Pawl Assembly Belt Holding (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		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 7313083 & Components		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%	As per Drawing 7313083 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313083 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313083 & Components		Firm Inspection report	W	
<p><b>*Note :</b> As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable. (ii) In case of hard ware items, NAI, Trichy will review the reports, if required.</p>									

  
 NAI Trichy  
 Civilian Technical Officer (Mech)  
 for Principal Inspector Of Naval Armament  
 Tiruchirappalli.

OFT  
  
**G. DEVENDHIRANE, I.O.F.S.**  
**ASST WORKS MANAGER**  
**INDIA. MIN. OF DEFENCE**  
**ARMAMENTS FACTORY**  
 TRICHY

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drng . No.	7313081								QAP No: OFT/QAP/M2HB/7313081
Nomenclature	PAWL, BELT HOLDING, LEFT HAND, OOW50BMG : REQD FOR PAWL ASSEMBLY BELT HOLDING ( 7313083)								
Material	WROUGHT MATERIAL: STEEL, ASTM A322 OR A331; 4140, 8645. PRECISION CASTING: STEEL, MIL-S-22141; IC4140, IC8640. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS2, GRADE B OF MIL-STD-2175.								
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
Pawl, Belt Holding, Left Hand (Raw material)	General appearance	Non Critical	Visual	100%	WROUGHT MATERIAL: STEEL, ASTM A322 OR A331; 4140, 8645. PRECISION CASTING: STEEL, MIL-S-22141; IC4140, IC8640. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS2, GRADE B OF MIL-STD-2175.		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%	HEAT AT 829°C TO 843°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH C46-52)		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 7313081	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313081		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313081		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.

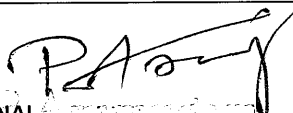
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NAI


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OFT  
S. VEENDIRANE, I.O.F.S.  
ASST WORKS MANAGER  
GOVT. OF INDIA, MIN. OF DEFENCE  
ORDNANCE FACTORY  
CHIRAPPALLI, TAMILNADU


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313082								QAP No: OFT/QAP/M2HB/7313082
Nomenclature	PAWL, BELT HOLDING, RIGHT HAND, OOW50BMG REQD FOR PAWL ASSEMBLY BELT HOLDING (7313083)								
Material	WROUGHT MATERIAL: STEEL, ASTM A322 OR A331; 4140, 8645. PRECISION CASTING: STEEL, MIL-S-22141; IC4140, IC8640. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS2, GRADE B OF MIL-STD-2175.								
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
Pawl, Belt Holding, Right Hand (Raw material)	General appearance	Non Critical	Visual	100%	WROUGHT MATERIAL: STEEL, ASTM A322 OR A331; 4140, 8645. PRECISION CASTING: STEEL, MIL-S-22141; IC4140, IC8640. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS2, GRADE B OF MIL-STD-2175.		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%		HEAT AT 829°C TO 843°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH C46-52)	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 7313082	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313082		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313082		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  
 Division Technical Officer (QA)  
 Ordnance Factory, Tiruchirappalli

  
 OFT  
 ASSISTANT WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	7160627							GAP No: OFT/QAP/M2HB/7160627	
Nomenclature	SLEEVE, BELT HOLDING PAWL, OOW50BMG : REQD FOR PAWL ASSEMBLY BELT HOLDING (7313083)								
Material	STEEL, CARBON; ASTM A108: SAE 1117, 1118.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Sleeve, Belt Holding Pawl (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, CARBON; ASTM A108: SAE 1117, 1118.		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	
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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
In process -As per Drawing 7160627	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7160627		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7160627		Firm Inspection report	W	
<p><b>*Note</b> : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable. (ii) In case of hard ware items, NAI, Trichy will review the reports, if required.</p>									

NAI  
  
 NAI, Trichy  
 10/10/2021

OFT  
  
**G. DEVENDHIRANE, I.O.F.S.**  
**ASST WORKS MANAGER**  
**GOVT. OF INDIA, MIN. OF DEFENCE**  
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**TIRUCHIRAPPALLI TAMIL NADU**