

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
		Rev No :
		Date of Issue 08/02/2024
C-1101 (CATCH) ✓		OFT/MI/30 mm/C1101. ✓
Rev.No	Amendment	Date

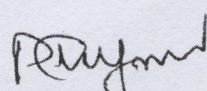
MATERIAL SPECIFICATION : Steel 30XPA OST-3-98-80. ✓
 MATERIAL FOR INDIA : BS: 970 PT1 1983 Gde 817 M40 IN 'Z' CONDITION ✓
 CONDITION OF SUPPLY : FULL FINISHED WITH FIRM'S MATERIAL. ✓
 END USE : 30 mm CANNON. ✓

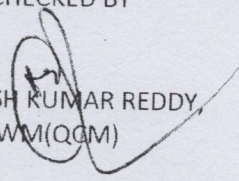
INSPECTION CHECK TO BE CARRIED OUT

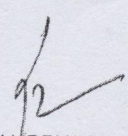
Table 'A'

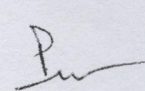
SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The Component shall be smooth and as free as possible from defects, such as grooves, seams, tears, rust, scale, scratches, pits, die-marks and any other harmful defects.	100%
2.	Dimension	100% Dimension check as per drawing.	
3.	Chemical Composition (%)	<p>STEEL 30XPA OST 3-98-80 :- (As per Standard GOST 5160-70) C = 0.28-0.33 ✓ Ni = 0.25-0.50 ✓ Si = 0.17-0.37 ✓ S = 0.025(Max) ✓ Mn = 0.50-0.80 ✓ P = 0.025(Max) ✓ Cr = 1.00-1.30 ✓ Cu = 0.20 (Max) ✓ B = 0.001-0.0045 ✓</p> <p>BS:970 Pt1 1983 Gde 817 M40 in 'Z' Condition C = 0.36-0.44 ✓ Mn = 0.45-0.70 ✓ Cr = 1.00 -1.40 ✓ Mo = 0.20-0.35 ✓ Ni = 1.30- 1.70 ✓ P = 0.025(Max) ✓ Si = 0.1-0.35 ✓ S = 0.025(Max) ✓</p> <p>(Permissible variations in value as per specification standard)</p>	One Sample Per Heat

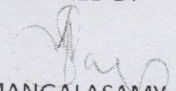
4.	Mechanical Properties	STEEL 30XPA OST-3-98-80 Tensile Strength 160 Kgf/mm ² (Min) ✓ Yield Strength 130 Kgf/mm ² (Min) ✓ Elongation 9% (Min) ✓ Reduction of area 40% (Min) ✓ Impact 5 Kgf/cm ² (Min) ✓	One sample Per Heat.
		BS:970 Pt1 1983 Gde 817 M40 IN 'Z' CONDITION Tensile Strength 1550 N/mm ² (Min) ✓ 0.2% Proof Stress 1235 N/mm ² (Min) ✓ % Elongation 5% (Min) ✓ Izod Impact 8 ft.lb (Min) ✓	
5.	Hardness	43.5- 51.5 HRC (As per drawing) ✓	
6.	Protective Finish	Accelerated electroless phosphating with chromate treatment/ Impregnation with adhesive Bφ-4, TOCT 12172-74, Nigrosine Grade A, GOST 9307-78, One coat OR Phosphating (Accelerated) Gde I to JSS:0465-01-1994 with coating of Dunlop adhesive S758, One layer Nigrosine to JSS:1036.	100%
7.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	Each
8.	Marking	Each Packing shall be legibly marked with manufacturer's identity , Qty, Heat No, OFT Supply order No etc.,	Consignment


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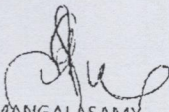

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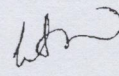
Note:

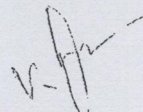
1. The Raw material/component/forging/casting to be tested by the firm on selection of the sample by the firm itself for chemical composition and mechanical properties in NABL accredited approved Lab as per Table 'A'.
2. The Firm has to check for the dimensions, visual defects, packing and marking as per Table 'A'. After completion of tests as per Note-1 as above, the Firm has to submit the following documents to OFT.
 - I. The Raw material certificate from the original manufacturer, Heat number, and quantity purchased and number of bars is to be mentioned in the inspection letter to OFT.
 - II. The Chemical and Mechanical test certificates from NABL accredited approved lab as per Table 'A'.
 - III. **Raw material sample minimum of 300mm should be supplied for cross verification along with the first supply of stores.**
 - IV. Dimensional reports including visual as per Table 'A'.
 - V. Guarantee / Warrantee certificate of supplier against the supply.
3. All the above Documents mentioned at Note No.2 above are to be forwarded to GM/OFT along with supply.
4. OFT shall verify all the documents as above and accord clearance to the firm for dispatch of the material to OFT if all documents are in order.
5. OFT/Trichy shall verify all the parameters as per Table 'A' and after satisfactory results, the material will be accepted /cleared accordingly.
6. Material has to be replaced 100% by the firm in case of non-conformity to specification as per Table-A, during inspection at OFT, Trichy.

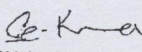
VERIFICATION OF INSPECTION DOCUMENTS

SL_NO	INSPECTION DOCUMENTS
1	The Raw material original Manufacturer's certificate, Details of Heat Number, Quantity purchased and number of Bars etc.,
2	The Chemical and Mechanical test certificates from NABL accredited approved Lab.
3	Dimension report including visual.
4	Packing slip details.

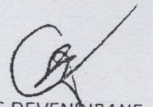

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