QAP FOR 12 BORE PAG (METALLIC COMPONENT)

QAP/PAG/SK 3972 IC/1
DATE : 17-12-2018

1	NOMENCLATURE	I C MAGAZINE TUBE LOCKING HOLDER	
2	DRG.NO./D.S.CAT No.	RFI SK 8972-G	
3	MATERIAL SPECIFICATION	BS: 3146 Pt.I 1974 CLA 5 GRADE A	
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING	
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING	
6	DOCUMENT VERIFICATION	A) SUPPLY ORDER	E) MECHANICAL TEST CERTIFICATE
		B) MIS	F) CRACK DETECTION CERTIFICATE
		C) BATCH NO.	H) PRE-INSPECTION REPORT
		D) CHEMICAL TEST CERTIFICATE	I) BATCH SIZE
7	VISUAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(Pt.1):2000	A) COMPONENT SHOULD BE FREE FROM RUST, PITS, CRACKS, SHARP EDGES & BURRS. B) MARKINGS:-AS PER DRAWING.	

8 DIMENSION CHECKING
SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(Pt.1):2000

UN TOLERATED DIMENSIONS TO BE AS PER IS: 11166-1993 CLASS-I OF INVESTMENT CASTING

Sl.No.	AUDIT POINTS/DIMENSIONS	GAUGE No./METHOD
1	16.0	GE METHOD /GAUGE
2	20.7	GE METHOD /GAUGE
3	R 10	GE METHOD /GAUGE
4	30±0.1	GE METHOD /GAUGE
5	ø25.2	GE METHOD /GAUGE
6	R 14.5	GE METHOD /GAUGE
7	13.0	GE METHOD /GAUGE
8	1.5	GE METHOD /GAUGE
9	17.5	GE METHOD /GAUGE
10	R 2.5	GE METHOD /GAUGE
11		
12		
13		
14		
15		

HOS/MPM
CERTIFIED COPY OF
DRG/LAYOUT/GAUGE SCHEDULE
AT THIS DATE 11-02-2020
STANDARD CELL
REPORT

9	HEAT TREATMENT	250-300 VPN
10	CASE DEPTH	
11	PROTECTIVE FINISH	
12	OTHER TESTS	AS MENTIONED IN DRAWING

NOTE:

1. PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
2. TEST REPORTS IS TO BE ISSUED FROM NABL APPROVED LAB./DGQA LAB./DGQA APPROVED LAB./ORDNANCE FACTORIES LAB.
3. RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
4. ENSURE ~~MARKING OF MANUFACTURER'S CODE ON THE STORE SUITABLY &~~ ENTRY OF LOT NO. & YEAR OF MANUFACTURING IN PRE INSPECTION REPORT.
5. TEST PIECES (CAST ALONG WITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECN. ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

REP OF ODC

REP OF QC