



QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	13018132								QAP No: OFT/QAP/M2HB/13018132
Nomenclature	SCREW, OOW50BMG : REQD. FOR WITH SAFETY, SPADE GRIP ASSEMBLY ( 6535477-S)								
Material	STEEL, ASTM A322 OR A331; 4140, 4340								
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
Screw material) (Raw	General appearance	Non Critical	Visual	100%	STEEL, ASTM A322 OR A331; 4140, 4340		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 13018132	HEAT AT 838°C TO 860°C OIL QUENCH. TEMPER 1 HOUR MINIMUM TO RHC 34-38. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT HARDNESS REQUIREMENT IS MANDATORY AND TIME AT TEMPERING TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.	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	Test report from NABL lab	R	
In process -As per Drawing 13018132	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 13018132		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 13018132		Firm Inspection report	W	

\*Note : 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.

  
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**OFT**  
 GOVERNMENT OF INDIA  
 ASTROPHYSICAL OBSERVATORY  
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