


QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	6009732							QAP No: OFT/QAP/M2HB/6009732	
Nomenclature	EJECTOR, SMALL ARMS CARTRIDGE ,OOW50BMG. REQD FOR EXTRACTOR ASSEMBLY SMALL ARMS CARTRIDGE (6008959)								
Material	STEEL, ASTM A576 OR ASTM A108: 1075 TO 1084; ASTM A322 OR ASTM A331: 4140. INVESTMENT CASTING: STEEL, MIL-S-22141; IC 6150. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A 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 or their authorised Rep. (Review/Witness) (*)	Remarks
Ejector, Small Arms Cartridge (Raw material)	General appearance	Critical	Visual	100%	STEEL, ASTM A576 OR ASTM A108: 1075 TO 1084; ASTM A322 OR ASTM A331: 4140. INVESTMENT CASTING: STEEL, MIL-S-22141; IC 6150. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A OF MIL-STD-2175.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%		<p>WROUGHT MATERIAL: HEAT AT 774°C - 802°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED RH A 73.5 - 77. CASTING: HEAT AT 816°C - 843°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED RH A 73.5 - 77.</p>	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	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 6009732	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 6009732		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 6009732		Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) & (iii) the following is applicable.</p> <p>(ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.</p> <p>(iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.</p>									


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 OFT

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