

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5013526								QAP No: OFT/QAP/M2HB/5013526
Nomenclature	NUT, BOLT LATCH ROD, OOW50BMG : REQD FOR HB ASSY (7265636)								
Material	STEEL, ASTM A108: 1045, 1050, 10L50, 1137 THRU 1151 OR 11L37 THRU 11L51.								
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
Nut, Bolt Latch Rod (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A108: 1045, 1050, 10L50, 1137 THRU 1151 OR 11L37 THRU 11L51.		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 5013526	HEAT AT 816°C TO 860°C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED RH A70-74	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 5013526	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5013526		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5013526		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.

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

OFT
G. VEENODRANE, I.O.F.S.
ASST. MD/AS MANAGER
COM. OF INDIA, MIN. OF DEFENCE
ORDNANCE FACTORY
TIRUCHIRAPPALLI - 620002