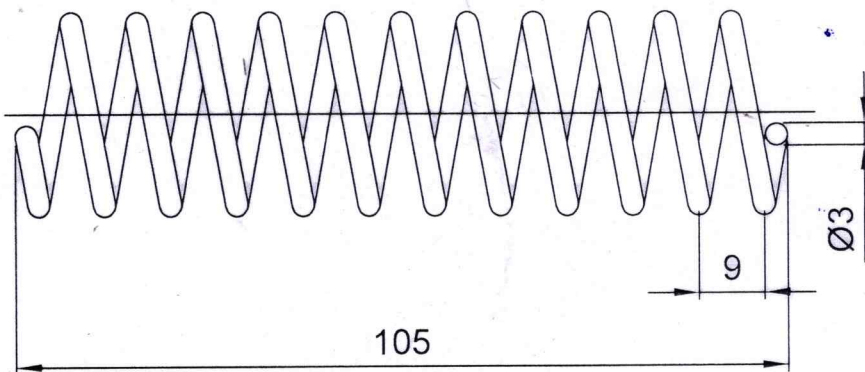
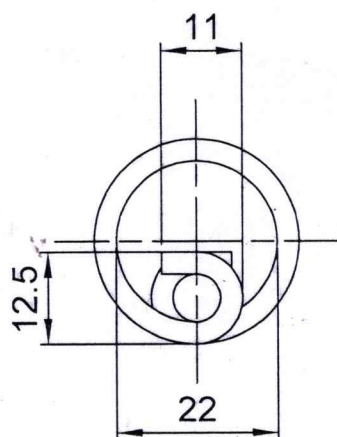


DRG. No. 6 342 889

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR Sr. GM G.C.Fy.
LINEAR DIMENSIONS						
0-6	±0.1				2020	NAME DATE
6-30	±0.2				DRN.	DEEPAK 02/01
30-120	±0.3				CKD.	
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSIONS		INDEX	AMENDMENTS	SIGN	DATE	APPROVED
0-10°	±1°					M. S. [Signature]
10-50°	±30'					
50-100°	±20'					
>100°	±10'					
<p>~ UNMACHINED</p> <p>▽ ROUGH</p> <p>▽▽ SMOOTH</p> <p>▽▽▽ FINISH</p>				<p>SPRING</p>		
				<p>MATERIAL</p> <p>IS:6528-1995, Design X07Cr18Ni9, Softened</p>		
				<p>SCALE: -- REF.DRG.NO.</p>		
				<p>ASSY/SUB ASSY NO. 1136347</p>		
				<p>DRG. No. 6 342 889</p>		
				<p>SHEET NO. OF SHEETS</p>		
GUN CARRIAGE FACTORY, JABALPUR						

1

2

3

4

DRG. No. 6 342 890

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED

R10 (2x)

55

122

3

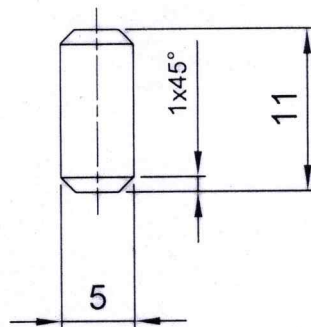
16

MATERIAL LENGTH: 228

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR Sr. GM G.C.Fy.
LINEAR DIMENSIONS						2020 NAME DATE
0-6	±0.1					DRN. DEEPAK 02/01
6-30	±0.2					CKD.
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSIONS						INDEX AMENDMENTS SIGN DATE APPROVED
0-10°	±1°					
10-50°	±30'					
50-100°	±20'					
>100°	±10'					
~ UNMACHINED	<h1>PLATE</h1>					MATERIAL
▽ ROUGH						IS:6911-1992, Design X04Cr19Ni9, Annealed
▽▽ SMOOTH						SCALE REF.DRG.NO.
▽▽▽ FINISH						ASSY/SUB ASSY NO. 1136347
	GUN CARRIAGE FACTORY, JABALPUR					DRG. No. 6 342 890
						SHEET NO. OF SHEETS

DRG. No. 6 342 891

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



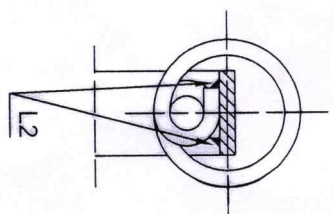
P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR Sr. GM G.C.Fy.
LINEAR DIMENSIONS						
0-6	±0.1				2020	NAME DATE
6-30	±0.2				DRN.	DEEPAK 02/01
30-120	±0.3				CKD.	
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSIONS		INDEX	AMENDMENTS	SIGN	DATE	APPROVED
0-10°	±1'					01/12/21
10-50°	±30'					
50-100°	±20'					
>100°	±10'					
~ UNMACHINED	▽ ROUGH	<h1>PIN</h1>			MATERIAL	
▽▽ SMOOTH					IS:6911-1992, Design X07Cr18Ni9, Annealed	
▽▽▽ FINISH					SCALE	REF.DRG.NO.
					2:1	
		GUN CARRIAGE FACTORY, JABALPUR				
					ASSY/SUB ASSY NO. 1136347	
					SHEET NO. OF SHEETS	

1

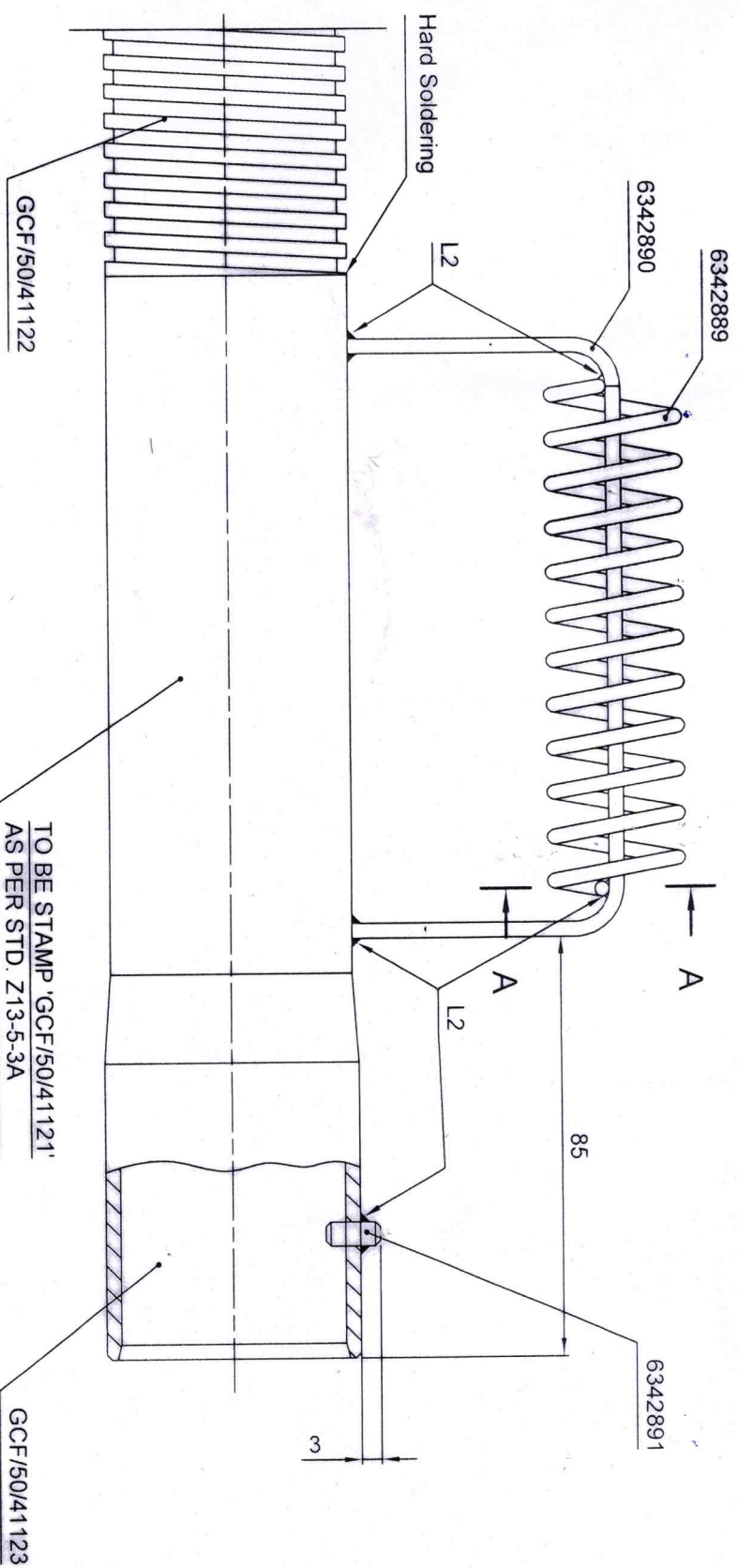
2

3

4



A-A



ART NUMBER	NOMENCLATURE	QTY.
GCF/50/41122	FAN HOSE	1
GCF/50/41123	PIPE	1
6342889	SPRING	1
6342890	PLATE	1
6342891	PIN	1

WELDING SPEC.	CLASS	METHOD	CLASS OF ELECTRODE
A 3034	C	TIG	W20-6

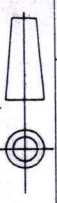
REV	AMENDMENTS	SIGN	DATE	CHECKED	APPROVED	SCALE	NTS	EXHAUST HOSE COVER ASSY DRWG FOR CUMMINS ENGINE (CCES ITEM)



GUN CARRIAGE FACTORY,
JABALPUR

NAME: A. Khare
DATE: 14.02.23
ASSY. No.: 1135600D
WEIGHT (KG) REF. ONLY

GENERAL TOLERANCE ACCORDING TO IS 2102-1993

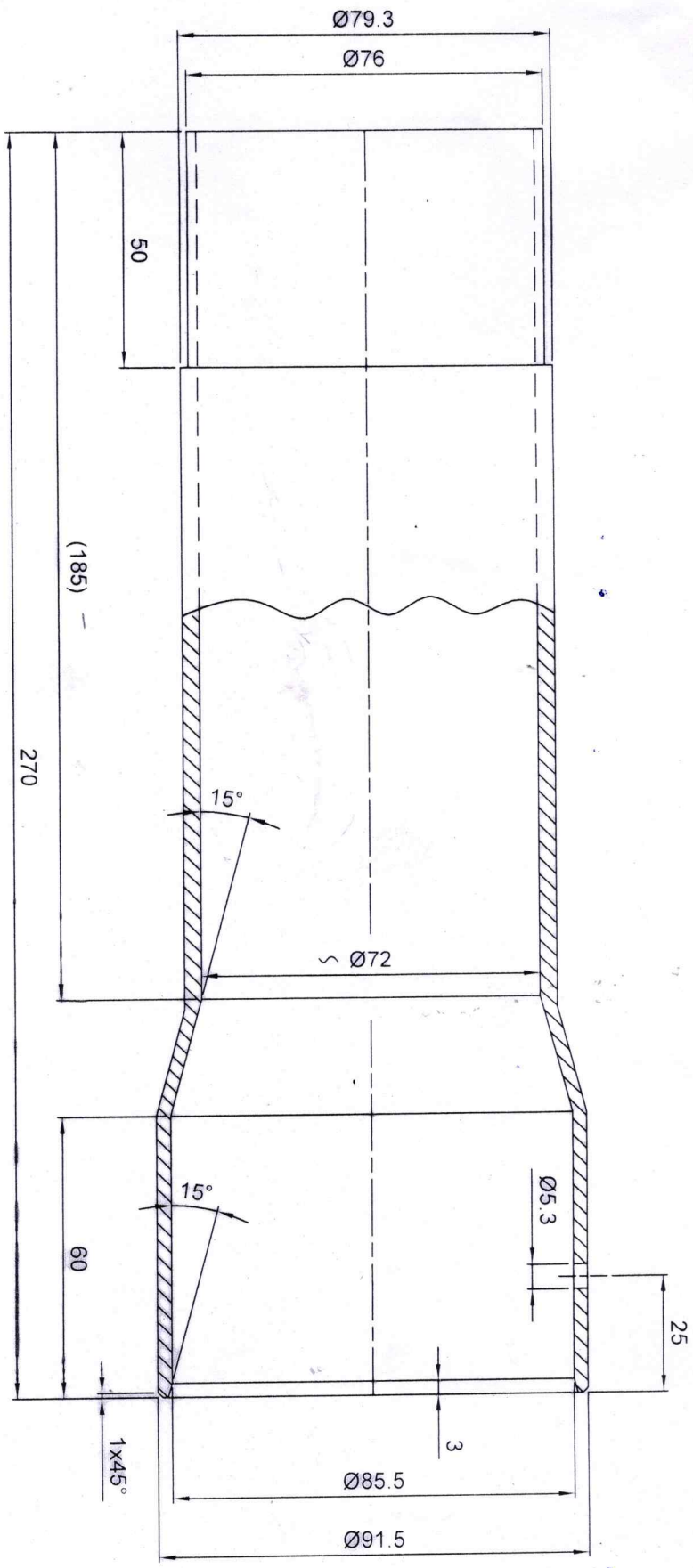


DRG. No. GCF/50/41121
SHEET


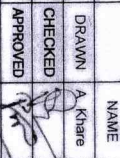
1 2 3 4 5 6 7 8

A B C D E F

A3



**GUN CARRIAGE FACTORY,
JABALPUR**

		NAME	DATE	ASSY. No.	WEIGHT (KG)
		A. Khare	08.02.23	1135600D	REF. ONLY
REV	AMENDMENTS	CHECKED	APPROVED	REF. DRG. No.	
				5168539D	
SURFACE TREATMENT		SCALE		MATERIAL	
		NTS		IS:6911-1992, Design X04C17N12M02, Annealed Cond	

GENERAL TOLERANCE ACCORDING TO IS 2702-1993



DRG. No. GCF/50/41123

SHEET

PIPE

A3



**155MM/45CAL ELECTRONICALLY UPGRADED GUN
SYSTEM
“DHANUSH”**

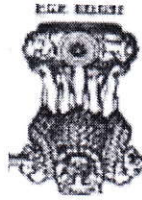
**QUALITY ASSURANCE PLAN/ACCEPTANCE TEST
PROCEDURE
OF
EXHAUST HOSE (1135600)**

**GOVERNMENT OF INDIA, MINISTRY OF DEFENCE
ORDNANCE FACTORY BOARD
GUN CARRIAGE FACTORY
JABALPUR (M.P) 482011**

QAP NO-GCF/QC/100/QAP/155MM/45CAL/DHANUSH/EXHAUST HOSE
[1135600]/NOV/2019/01

इस दस्तावेज में दी गई सूचना कहीं और छापना अथवा प्रकाश या अप्रकाश रूप में प्रसारण या किसी ऐसे व्यक्ति को कहीं बताना है जो भारत सरकार को किसी पद पर न हो।
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QUALITY ASSURANCE PLAN/ACCEPTANCE TEST PROCEDURE OF EXHAUST HOSE (1135600) FOR 155 mm / 45 CAL DHANUSH



उक्त हैण्डबुक को होल से किसी प्रयोगकर्ता को यह अधिकार नहीं मिलना कि वह कंपोनेंट्स की मरम्मत करे या उसे बदल ले का काम करे। उक्त परीक्षणों द्वारा मरम्मत कार्य पर किसी बल विपरीत "के अंतर्गत" के अंतर्गत किए जाए जो साफ़ एम डेकार या उस जैसे अन्य पर्यकालिकताएं।
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Prepared and published by



Gun Carriage Factory
Ordnance Factory Board
Government of India, Ministry of Defence,
Jabalpur (MP) 482011



Under the Authority of
Secretary, Ministry of Defence, Govt. of India

QAP NO-GCF/QC/100/QAP/155MM/45CAL/DHANUSH/EXHAUST HOSE
(1135600)/NOV/2019/01

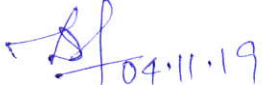
**155MM/45CAL ELECTRONICALLY UPGRADED GUN
SYSTEM
“DHANUSH”**

**QUALITY ASSURANCE PLAN/ACCEPTANCE TEST
PROCEDURE
OF
EXHAUST HOSE (1135600)**


REVIEWED BY

**(NILESH SOLANKY)
WM/QC**



PREPARED BY


**(DANISH ANSARI)
JWM/QC**

APPROVED BY


**(SANJAY SHRIVASTAVA)
JT.GM/QC**

RESTRICTED

	QUALITY ASSURANCE PLAN/ACCEPTANCE TEST PROCEDURE OF EXHAUST HOSE (1135600)/DHANUSH	
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1. MATERIAL DETAILS:

S.N.	Material
a)	Chemical composition and mechanical properties are according to the given standard. And its Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports for all items/components from which the same are manufactured/formed/integrated is to be attached herewith.

2. DIMENSIONS:

Dimensions	Instrument to be used for measurement of dimension	Observed dimensions	Remark
All dimensions must compliance with drawing and should be in the tolerance limits. Note: i. General tolerance according to IS standard.	General engineering instrument		

3. PRACTICAL TRIAL WITH DHANUSH GUN SYSTEM (OR WITH ITS SUB-ASSY) AFTER THE SAID ITEM/COMPONENTS/SUB-ASSEMBLY RECEIVED AT GCF.

S.N	Remark to be filled by concerned section	Signature by concerned head of section


4. LIST OF DOCUMENTS TO BE SUBMITTED BY FIRM ALONG WITH SUB ASSY/COMPONENT/ ITEM:

- a) Dimensional acceptance check sheet – 100%.
- b) Chemical composition and mechanical properties NABL accredited/Gov. approved lab reports for all items/components from which the same are manufactured/formed/integrated.

REVIEWED BY

**(NILESH SOLANKI)
WM/QC**

(PREPARED BY)


**(DANISH ANSARI)
JWM/QC**

RESTRICTED

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QUALITY ASSURANCE PLAN/ACCEPTANCE TEST PROCEDURE OF
EXHAUST HOSE (1135600)/DHANUSH



- c) Heat treatment NABL Accredited/Gov. approved report with specified hardness as mentioned in standard along with graph, representing HT cycle, if any.
- d) NABL / government approved NDT certificated report to be attached herewith, if the same test is mentioned.
- e) Surface treatment report, if any.
- f) Surface Coating conformation certificates for all sub-assy, if any.
- g) Fabrication report along with SR report, if any.
- h) Copies of invoice /Purchases order of all raw materials/Standard items pertaining to said item/components/sub-assy are to be attached herewith this QAP/ATP by the firm in hard copy.

5. IMPORTANT NOTES:

- a) Handling according to standard V6-1, if the same mentioned in the drawing.
- b) Use rust preventative (W11-217-1) after integration, location specified in drawing; if any.
- c) If any query arise pertaining to dimensions, standards (viz. mechanical properties, chemical composition, Heat treatment etc) or any other aspects which are mentioned in QAP/ATP but are mismatching with actual drawings/standards , then in this case the firm should intimate GCF with detail explanation and the commencement of bulk production only be make after receiving of proper clarification from GCF,Jabalpur.
- d) This Quality plan/Acceptance, after proper vetting by standard cell, should be issued to vendor along with supply order. Vetting by standard cell is to be done for checking whether any modification or amendment of material/drawing has been introduced in drawing within of action of procurement.
- e) Test piece of adequate size of any sub-assy may asked by the GCF for verification of its Chemical and mechanical properties.
- f) ***Final authority of acceptance is based on the Practical trial report.***
- g) All necessary mark/punch/patter should be compliance with drawing, if any.


6. LIST OF DOCUMENTS PROVIDED BY GCF TO FIRM ALONG WITH THIS QAP/ATP, ISENUMERATED BELOW:

- a) A copy of all relevant drawings under article no. 1135600

REVIEWED BY

(NILESH SOLANKI)
WM/QC

(PREPARED BY)


(DANISH ANSARI)
JWM/QC

RESTRICTED