



QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6009718								
Nomenclature	LEVER, COCKING, OOW50BMG REQD FOR BOLT ASSEMBLY BREECH (5428322)								
Material	ALLOY STEEL BARS, HOT WROUGHT, ASTM A322, GRADES 4340 ALLOY STEEL BARS, COLD FINISHED , ASTM A331, GRADES 4340 ALT: ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 4340. ALLOY STEEL, PLATES, ASTM A829, GRADES 4340 ALLOY STEEL, SHEET, STRIP, PLATE AMS 6359 (GRADE 4340) ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6454 (GRADE 4340)								
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
Lever, Cocking (Raw material)	General appearance	Critical	Visual	100%	ALLOY STEEL BARS, HOT WROUGHT, ASTM A322, GRADES 4340 ALLOY STEEL BARS, COLD FINISHED , ASTM A331, GRADES 4340 ALT:	ALLOY STEEL, SHEET AND STRIP, ASTM A506, GRADES 4340.	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			ALLOY STEEL, PLATES, ASTM A829, GRADES 4340 ALLOY STEEL, SHEET, STRIP, PLATE AMS 6359 (GRADE 4340)	Test report from NABL lab	
	Mechanical properties	Critical	Mechanical Lab analysis	100%	ALLOY STEEL, SHEET, STRIP, PLATE, AMS 6454 (GRADE 4340)	Test report from NABL lab	R		
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%	As per Drawing 6009718	HEAT AT 815°C - 843°C. OIL QUENCH. DOUBLE TEMPER AT 215°C FOR TWO HOURS PLUS ONE HOUR TO HARDNESS SPECIFIED RH C 52-59.	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 6009718	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 6009718		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 6009718		Firm Inspection report	W	

(*) 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.
 (ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.
 (iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.


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


 G. DEVENDIRANE, I.O.F.S.
 ASST. WORKS MANAGER
 GOVT. OF INDIA, MIN. OF DEFENCE
 ORDNANCE FACTORY
 TIRUCHIRAPPALLI