

QUALITY ASSURANCE PLAN		QAP No: ARDE/QAP(PROV)JVPC/ SPRING RECOIL ASSEMBLY/ 06		
Issue No. 1	Date: 30/11/2010	Revision No. 3	Date: 29/08/2017	Page No. 1 of 2
Component / Assembly		ROD FRONT SPRING RECOIL		

- 1 Drawing no. : 0204 03 02 00 06 003 00DD
- 2 Method of Manufacture : Machining
- 3 Receiving inspection :
- 3.1 Raw material : Steel to IS: 5517-1993, 55C8 (En-9)
- 3.2 Tests / Checks and Acceptance Criteria for Raw Material:

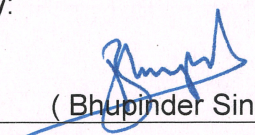
Sl. No	Test / Check	Parameter	Acceptance Value
1	Chemical Analysis	Chemical Composition	As per spec.

- 4 In-Process Inspection : Nil
- 5 Stage Inspection : Nil
- 6 Final Inspection :
- 6.1 Visual Examination : Sample Size -100%
- 6.1.1 Features for Visual Examination and Acceptance Criteria:

Sl. No	Details of features	Sample Size	Acceptance Criteria
1	Sharp edges, burrs	100%	Not allowed
2	All features like Chamfers , Radius ,Undercut etc	100%	To be present

- 6.2 Dimensional Inspection :
- 6.2.1 Critical Dimensions : Sample Size – 100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	Ø4.95-0.05	C-3	Ring / Snap gauge
2.	Ø4.1-0.05 'A'	B-3	Plug gauge
3.	1.15-0.05	B-4	Position gauge

Prepared By:  TO 'C' (N B Wadekar)	Recommended By:  Sc 'E' (Bhupinder Singh)
--	---

QUALITY ASSURANCE PLAN		QAP No: ARDE/QAP(PROV)JVPC/ SPRING RECOIL ASSEMBLY/ 06		
Issue No. 1	Date: 30/11/2010	Revision No. 3	Date: 29/08/2017	Page No. 2 of 2
Component / Assembly		ROD FRONT SPRING RECOIL		

6.2.2 Geometrical Features : Sample Size – 100%

Sl. No	Dimension / Feature			Drawing Zone	Inspection Method
1.		0.02	'A'	C-3	Concentricity gauge

6.2.3 Major Dimensions : Sample Size – 100%

Sl. No	Dimension / Feature		Drawing Zone	Inspection Method
1.	M4		B-1	Thread gauge
2.	68.0		B-2	Snap gauge

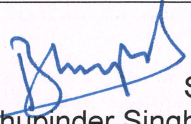
6.2.4 Minor Dimensions : Nil

6.2.5 Tests on Finished Items :

6.3.1 Details of Tests / Checks on Finished Items and Acceptance Criteria:

Sl. No	Test / Check	Sample Size	Acceptance Values
1.	Hardness	10 %	350-400 HV
2.	Protective Finish	5%	Phosphated to Specification IS: 3618 -1966, Class 'B'.

7 Details of tests and other information: Nil

Prepared By:  TO 'C' (N B Wadekar)	Recommended By:  Sc 'E' (Bhupinder Singh)
--	---