

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7266134								QAP No: OFT/QAP/M2HB/7266134
Nomenclature	SPRING, LOCKING, BARREL, OOW50BMG REQD.FOR HB ASSEMBLY (7265636)								
Material	STEEL, ASTM A108; 1085, 1095 OR ASTM A322 OR A331: 6150. ALT.MATL: STEEL, ASTM A686: TYPE W1-8 THRU 10, GRADE 'C'.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Spring, Locking, Barrel (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A108; 1085, 1095 OR ASTM A322 OR A331: 6150. ALT.MATL: STEEL, ASTM A686: TYPE W1-8 THRU 10, GRADE 'C'.		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 7266134	FOR 1085 OR 1095 STEEL HEAT AT 787°C TO 816°C. OIL QUENCH, TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH A 73-76) FOR 6150 STEEL HEAT AT 843°C TO 871°C. OIL QUENCH, TEMPER ONE HOUR MINIMUM TO HARDNESS RH A 73-76)	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		R	
In process -As per Drawing 7266134	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7266134		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7266134		Firm Inspection report	W	

(* Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for out sourced components. JRI will be done by NAI & OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.

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

G. Bevendirane
G. BEVENDIRANE, I.O.F.S.
 ASST. WORKS MANAGER
 GOVT. OF INDIA, MIN. OF DEFENCE
 ORDNANCE FACTORY
 TIRUCHIRAPPALLI, TAMIL NADU