<table>
<tr><td colspan="2" rowspan="2">QUALITY ASSURANCE PLAN
(M2HB GUN IM PHASE)</td><td>Issue No : 01
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QUALITY ASSURANCE PLAN **(M2HB GUN IM PHASE)**		Issue No : 01 Rev No: 00
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Drg . No.	5013530	**QAP No:** **OFT/QAP/M2HB/5013530**
Nommenclature	SCREW, LOCK, BREECH BEARING,OOW50BMG. : REQD. FOR HB ASSEMBLY (7265636)	
Material	STEEL, ASTM A322 OR A331:8620	

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
Screw, Lock, Breech Bearing (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A322 OR A331:8620		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 5013530	CARBURIZE AT 1575°F - 1600°F FOR 5 TO 7 MINUTES. CASE DEPTH 0.005 TO 0.010 OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED (RH FILEHARD)	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 5013530	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5013530		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5013530		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 Arumugam
Technical Officer (Mech)
Inspector of Naval Armament

OFT ...NDIRANE, I.O.FS
ASST WORKS MANAGER
GOVT OF INDIA, MIN. OF DEFENCE
ORDNANCE FACTORY
TIRUCHIRAPPALLI, TAMIL NADU

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