

QAP FOR 12 BORE PAG (METALLIC COMPONENT)		QAP/PAG/SK 8972-1C/1	
		DATE : 17-12-2018	
1	NOMENCLATURE	1 C MAGAZINE TUBE LOCKING HOLDER	
2	DRG NO. / D.S. CAT. No.	RFI SK 8972-G	
3	MATERIAL SPECIFICATION	BS 3146 Pt. 1 1974 OLA 5 GRADE A	
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING	
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING	
6	DOCUMENT VERIFICATION	A) SUPPLY ORDER	E) MECHANICAL TEST CERTIFICATE
		B) MIS	F) CRACK DETECTION CERTIFICATE
		C) BATCH NO.	H) PRE-INSPECTION REPORT
		D) CHEMICAL TEST CERTIFICATE	I) BATCH SIZE
7	VISUAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS: 2500 (Pt. 1): 2000	A) COMPONENT SHOULD BE FREE FROM RUST, PITS, CRACKS, SHARP EDGES & BURRS. B) MARKINGS - AS PER DRAWING.	
8	DIMENSION CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS: 2500 (Pt. 1): 2000  UN TOLERATED DIMENSIONS TO BE AS PER IS: 11166-1993 CLASS-I OF INVESTMENT CASTING	Sl. No.	AUDIT POINTS/DIMENSIONS
		1	16.0
		2	20.7
		3	R 10
		4	30±0.1
		5	Ø25.2
		6	R 14.5
		7	13.0
		8	1.5
		9	17.5
		10	R 2.5
		11	
		12	
		13	
		14	
		15	
9	HEAT TREATMENT	250-300 VP	
10	CASE DEPTH		
11	PROTECTIVE FINISH		
12	OTHER TESTS	AS MENTIONED IN DRAWING	

**NOTE:**

1. PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
2. TEST REPORTS IS TO BE ISSUED FROM NABL APPROVED LAB./DGQA LAB./DGQA APPROVED LAB./ORDNANCE FACTORIES LAB.
3. RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
4. ENSURE MARKING OF MANUFACTURER'S CODE ON THE STORE SUITABLY & ENTRY OF LOT NO. & YEAR OF MANUFACTURING IN PRE INSPECTION REPORT.
5. TEST PIECES (CAST ALONG WITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECN. ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

REP OF ODC

REP OF QC

02-01-2019

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verified  
23/3/19