

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	6008982-PA							GAP No: OFT/QAP/M2HB/6008982-PA	
Nomenclature	PEEL AWAY SHIM, TRUNNION BLOCK, OOW50BMG : REQD. FOR HB ASSEMBLY (7265636)								
Material	LAMINATED SHIM STOCK, 1008 CARBON STEEL, 0.002 THICK FOIL, 0.094 TOTAL THICKNESS. FEDERAL SPECIFICATIONS: FEB SPEC. QQ-S-698. RECOMMENDED SUPPLIER: MCMaster CARR, P/N 9720K47 OR 9720K19.								
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
Peel Away Shim, Trunnion Block. (Raw material)	General appearance	Non Critical	Visual	100%	LAMINATED SHIM STOCK, 1008 CARBON STEEL, 0.002 THICK FOIL, 0.094 TOTAL THICKNESS. FEDERAL SPECIFICATIONS: FEB SPEC. QQ-S-698. RECOMMENDED SUPPLIER: MCMaster CARR, P/N 9720K47 OR 9720K19.		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	
In process -As per Drawing 6008982-PA	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%		As per Drawing 6008982-PA	Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%		As per Drawing 6008982-PA	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

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