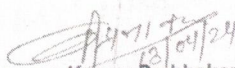



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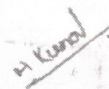
**QUALITY ASSURANCE PLAN**  
**SELF ADHESIVE TAPE**  
**FOR**  
**OF 155 mm BMCS M91LZ & M92HZ**

PREPARED BY

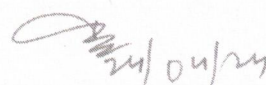
  
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**1.0 GENERAL**

- 1.1 QAP has been prepared by Standard Cell, OFN on the authority of the CGM, OFN, a unit of MIL, under Ministry of Defence, Govt. of India.
- 1.2 The information contained herein is privileged and should be used by Authorized Personnel only.
- 1.3 The purpose of the QAP is to ensure the quality of SAT and its raw materials, satisfy contractual agreements and meet quality standards.
- 1.4 This QAP is applicable and specific to manufacturing of SAT.
- 1.5 The CGM, OFN or his authorized representative must have free access to the Suppliers/Manufacturers work premises, his processing facilities, assembly lines, Testing fields at all times during the auditing/ PDI as well as run of the contract. The supplier/manufacturer shall also make arrangements with outside agencies wherever becomes imperative to execute the Special Quality Management Tools / Tests with information to The CGM, OFN for effective and meaningful auditing as per IS/ ISO 19011: 2018 standard.

**1.6 DEFINITIONS FOR TERMS AND ACRONYMS**

Ammn.	-	Ammunition
ANSI	-	American National Standards Institute
AQL	-	Acceptable Quality Level
BMCS	-	Bi Modular Charge System
CFEES	-	Centre for Fire, Explosive & Environment Safety
CGM	-	Chief General Manager
CQA(ME)	-	Controllerate of Quality Assurance (Military Explosives)
DCL	-	Defect Classification List
HZ	-	High Zone
IS	-	Indian Standard
ISO	-	International Organization for Standardization
LZ	-	Lower Zone
MIL	-	Munitions India Limited
mm	-	Millimeter
NABL	-	National Accreditation Board for Testing and Calibration laboratories.
OFN	-	Ordnance Factory Nalanda
PDI	-	Pre Dispatch Inspection
QA	-	Quality Assurance
QC	-	Quality Control
QAP	-	Quality Assurance Plan
Spec.	-	Specification
RMC	-	Raw Material Clearance
SAT	-	Self Adhesive Tape
Sl. No.	-	Serial Number
STEC	-	Storage and Transportation of Explosive Committee
w.r.t	-	with respect to



## 2.0 BRIEF DESCRIPTION OF THE PRODUCT

SAT is used to stick BWRL and Tin Foil (In case of BMCS M91 only Tin Foil) with inner surface of CCC main body.

## 3.0 SAFETY/ SECURITY ASPECT

SAT is used in the 155mm BMCS as a non Explosive component. Hence no special safety Regulation prescribed in STEC Pamphlet No. 2 is applicable to it.

## 4.0 TECHNICAL SPECIFICATION

SAT shall be manufactured in accordance with the relevant drawings and relevant process schedule and shall meet all the technical requirements of the spec.

## 5.0 MARKING / IDENTIFICATION OF DETAILS

SAT are to be marked / identified as per the relevant drg./spec. Any changes required shall be subject to approval of the CGM/OFN and shall not be changed without approval.

However the supplier / manufacturer shall mention lot no. in every consignment at their end w.r.t Lot Size as mentioned below at Para.9.

## 6.0 QUALITY

### 6.1 ORGANISATION

The supplier / manufacturer shall have an appropriate organizational chart for the QC program describing the tasks in terms of QC activities, the roles and responsibilities of QC personnel performing the QC tasks to ensure that the concepts & standards applied are implemented and all testing & evaluation are done in accordance with approved plans, drg., Standards, and procedures.

### 6.2 FACILITIES

6.2.1 The supplier / manufacturer shall establish and maintain appropriate facilities for manufacturing of SAT. The Shops used for manufacturing of SAT shall be provided with all the necessary equipment/instruments, skilled personnel and appropriate environmental conditions with means of regulating temperature and relative humidity. The shops shall have a program for scheduled maintenance of all the equipment/test equipment/instruments. The shop shall maintain records of environmental conditions where required.

6.2.2 The supplier/manufacturer shall have/ arrange laboratory facilities for testing of SAT. The laboratory shall be furnished with all the relevant test equipment/instruments and shall have a Program for scheduled maintenance of the test/measuring equipment/instruments. The laboratory shall have a program for calibration of its test/measuring instruments/equipment.



**6.3 INTERMEDIATE**

The Supplier/Manufacturer shall carry out inspection of all intermediates to ensure that they conform to the relevant spec. / drg. / standard. Only those intermediates meeting the spec. / standard / drg. shall be used for further processing.

**6.4 PROCESS**

The supplier/manufacturer shall ensure that only approved processes are adopted in the manufacturing of SAT. The supplier/ manufacturer shall monitor and control the processes throughout the manufacturing process and shall maintain records of all critical process parameters. These records are made available to the CGM/OFN, as and when required.

**6.5 ACCEPTANCE / PERFORMANCE TESTS**

The supplier/ manufacturer shall evaluate the lots of the finished SAT and assure himself that the lots shall satisfy the requirements laid down in the relevant Drg./ Spec. The number of samples to be drawn and the method of sampling shall be in accordance with the relevant standard/Spec. Records of evaluations done on the lots shall be maintained and made available to the CGM, OFN as and when required.

**7.0 PROCESS AUDIT**

7.1 The CGM, OFN or his authorized Representative may conduct process audit in accordance with IS/ISO 19011:2018. The supplier/ manufacturer shall offer his premises to the CGM, OFN, free of cost, all reasonable / related facilities (including test equipment / gauges) for satisfying himself during process audit, that the stores are being manufactured in accordance with the governing specifications / Environment.

7.2 The CGM, OFN shall forward the audit report to the Supplier/manufacturer for necessary corrective action. The process audit report shall indicate either conformity or non-conformity with audit criteria and whether the process is effective /efficient and identify opportunities for improvement. The overall objective of the audit is continual improvement. The Supplier / manufacturer shall identify corrective action and implement the same. A follow up audit may be planned and conducted by the CGM, OFN to assess the effectiveness of the corrective actions

**8.0 QUALITY AUDIT****8.1 AUDIT METHODOLOGY AND PRINCIPLES**

The CGM, OFN shall carry out Quality Audit in accordance with IS/ISO 19011:2018.

**8.2 SAMPLING PLAN**

8.2.1 The CGM, OFN or his authorized Representative shall inspect/ audit the bulk lot as per approved Sampling Plan ANSI/ASQ Z1.4-2003 (R 2018), Single sampling plan, Normal inspection, and General Inspection level-II or as per requirement of the CGM, OFN during PDI or receipt inspection at OFN. These samples should be thoroughly representative of the bulk.

*N. Paul*

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### 8.3 PRE DISPATCH INSPECTION

8.3.1 Upon completion of the manufacturing of the bulk lot, the supplier/ manufacturer shall offer the bulk lot of SAT to the CGM, OFN, free of cost, all reasonable / related facilities (including test equipment / gauges) for PDI along with following documents.

- a. Pre inspection and in-process inspection reports of SAT as per relevant drawing and specification.
- b. Raw material consumption and balance statement as per Annexure-'C' on supplier's / manufacturer's letter head.
- c. Safety certificate and guarantee/warranty certificates for every consignment as per Annexure-'B' on supplier's / manufacturer's letter head.
- d. Any other quality related documents at the discretion of the CGM, OFN or his authorized Representative, as per general industry practice.

8.3.2 The CGM, OFN or his authorised representative shall audit the quality documents and draw samples from the bulk lot as per sampling plan, evaluate physical parameters as per approved drawing and Spec. and classify the samples as defective/non defective as per DCL based on physical inspection.

8.3.3 The CGM, OFN or his authorised representative shall draw samples, wherever required, for testing of physical and chemical parameters as per spec. at Ordnance Factory/ DGQA/ Govt./DRDO/NABL accredited Lab.

8.3.4 Upon successful completion of PDI and satisfactory laboratory test results of SAT, the bulk lot shall be recommended for Dispatch Clearance. Lots not meeting the criteria for acceptance requirement during PDI or unsatisfactory laboratory test results the lot shall be **REJECTED**.

8.3.5 The CGM, OFN in his discretion may exempt the PDI and allow consignment to dispatch without PDI. In that case the lot will be accepted/ rejected based on receipt inspection of the bulk lot at OFN.

### 8.4 RECEIPT INSPECTION

8.4.1 Upon receipt of the bulk lot at OFN, QC team of OFN shall audit the quality documents and draw samples from the bulk lot as per sampling plan, evaluate physical parameters as per approved Drg. and Spec. and classify the samples as defective/non defective as per DCL based on physical inspection. The supplier/ manufacturer shall submit following documents along with consignment-

- a. Pre inspection and in-process inspection reports of SAT as per relevant Drg. and Spec.
- b. Raw material consumption and balance statement as per Annexure-'C' on supplier's/manufacturer's letter head.
- c. Safety certificate and guarantee/warranty certificates for every consignment as per Annexure-'B' on supplier's / manufacturer's letter head.
- d. Any other quality related documents at the discretion of the CGM, OFN or his authorized Representative, as per general industry practice.

*Nail*

*Nail*



- 8.4.2** Additional samples may also be drawn from the bulk lot by OFN QC team for testing of physical as well as chemical parameters at Ordnance Factory/ DGQA/ Govt./DRDO/NABL accredited Lab. Sample shall also be sent to user section for user trial.
- 8.4.3** In case where PDI is done, the scope of receipt inspection will be in the purview of the CGM, OFN..
- 8.4.4** Upon successful completion of receipt inspection, auditing of quality documents provided by the supplier / manufacturer, satisfactory laboratory test results and user trial report, the bulk lot shall be sentenced as **ACCEPTED**. Lots not meeting the criteria for acceptance requirement or unsatisfactory laboratory test results or adverse user trial report, the lot shall be sentenced as **REJECTED**.

**9.0 ATTRIBUTE INSPECTION PLAN INDEXED BY AQL- ANSI/ASQ Z1.4-2003**

Normal inspection- Single Sampling Plan- General Inspection level II

	155mm BMCS M91LZ	155mm BMCS M92HZ
Lot Size	5600 nos. or multiple of 5600 nos.	10800 nos. or multiple of 10800 nos.
Sample Size	As per Sampling Plan no. ANSI/ASQ Z1.4-2003 (R 2018)	

DCL	AQL%		Accept	Reject
	BMCS M91	BMCS M92	As per Sampling Plan no. ANSI/ASQ Z1.4-2003 (R 2018)	
Critical	0.065	0.04		
Major	0.65	0.65		
Minor	1.50	1.50		

**9.1 LIST OF DEFECT:**

Sl.	Inspection Parameter	Specified Limit	Nature of defect	DCL
01	Physical Dimension	As per Drg.	Dimension beyond specified limit.	Major
02	External Defect on SAT	---	Tear, cut, pin hole	Minor

**10.0 PROCEDURE FOR DISPOSAL OF NON-CONFORMING AMMUNITION MATERIALS**

SAT not meeting the standard/specifications during bulk receipt inspection at OFN shall be sentenced as **'REJECTED'** and intimated to the supplier/ manufacturer for collection from OFN Store. Further action will be taken as per procedure laid down in Supply Order.

**11.0 LIST OF DRAWINGS**

Sl.	Assembly/ Component	Nomenclature	OFN Drawing No.
1.	----	Self Adhesive Tape	BMCS-M91-M92-SAT-01



## 12.0 SPECIFICATIONS OF SELF ADHESIVE TAPE:

Specification No.OFN/SPEC/BMCS/M91/M92/SAT/00

Sl. No.	Description	Unit	SPEC. LIMIT	Test Method
1.0	Tensile Strength	N	Max 30	SABS KA3093
2.0	Elongation at Break,	%	Minimum 80	
3.0	Strength of Adhesion- After 72 hrs,	N	Minimum 10	
4.0	Shrinkage	mm	Max 2	
5.0	Release per 15 mm	N	Min 0.25 Max 0.50	
6.0	Physical dimensions	As per Drawing No. BMCS-M91-M92-SAT-01		

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**Annexure-A**

**Raw Materials offered for sampling and Inspection:**  
**Product Name:**

Sl. No.	Nomenclature of Item/ Store	Drg. No./ Part No.	Raw Material Name	Specification No.	Offered Qty

Authorized signatory

**Annexure-B****Guarantee/ Warranty Certificate**

We hereby declare that the product..... quantity .....supplied by our company M/s..... vide Challan No..... Dated..... as per S. O. No.....Dated..... are meeting all requirements laid down in the relevant specification.

We hereby undertake to replace whole and/ or part consignment as the case may be in the event of it is not meeting the requirements/ standards laid down in the supply order. This Guarantee/ Warranty Certificate is valid till .....months from date of receipt at O. F. Nalanda.

Quality Control Manager

Managing Director/General Manager  
or his authorized Signatory.

Supplier's Stamp

**Annexure-C****Raw Material Consumption Report**

S.O. No:..... Date:.....

Supplied Qty.....

Product Name:.....

Sl. No.	Raw Material	Accepted Qty	Ref. Document of QC, OFN	Last Consignment balance Qty. (Total)	Present Consignment Consumed Qty.	Present Consignment (balance) Qty
A	B	C	D	E	F	G

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**Self-Adhesive Tape for 155 mm BMCS M91 LZ and M92 HZ**

- 1.0 This Monitoring Instruction (MI) shall be applicable invariably as Addendum of Quality Assurance Plan (QAP) no. OFN/QAP/BMCS/M91/M92/SAT/00, Rev.00, dated 13.04.2024. MI shall be strictly followed/complied by all the interested parties.
- 2.0 Supplier/ manufacturers on receipt of Supply Order (SO) should invariably check the correctness of the SO in respect of item description, drawing no., specification, delivery period, place of inspection, inspection authority and quality clauses.
- 4.0 **Source Development Open Tender Enquiry (SDOTE) Cases:**
- 4.1 **Advance Sample Qty.: 50 nos.**
- Advance samples shall be manufactured and submitted to OFN along with pre-inspection report , Laboratory test reports etc. for inspection (Physical, chemical inspection as well as user/ fitment trial).
  - The inspection and acceptance of advance samples shall be done as per provisions of QAP, mentioned in para 1.0 above.
  - After satisfactory inspection report (Physical, chemical inspection as well as user/ fitment trial), supplier/manufacturer shall be accorded clearance to manufacture a Pilot Lot and offer the same for the inspection.
  - In case of rejection of advance samples, supplier/ manufacturer may submit subsequent advance samples free of cost for the inspection. Advance samples shall be in exclusion to the Supply Order Qty.
- 4.2 **Pilot Lot: Lot Size: 10800 nos.**
- 4.2.1 Upon getting clearance from OFN to manufacture a Pilot Lot, the supplier/ manufacturer shall manufacture and offer a pilot Lot for inspection along with following documents/reports :
- Pre inspection and in-process inspection reports of Self-Adhesive tape as per relevant Drawing and Spec.
  - Raw material consumption and balance statement as per Annexure-'C' of QAP, mentioned in para 1.0 above on supplier's/manufacturer's letter head.
  - Safety certificate and guarantee/warranty certificates for every consignment as per Annexure-'B' of QAP, mentioned in para 1.0 above on supplier's / manufacturer's letter head.
- 4.2.2 Inspection and acceptance/rejection thereof, of Pilot Lot shall be done as per provision of QAP mentioned in para 1.0 above.
- 4.3 **Bulk Production Clearance (BPC):**
- After acceptance of the pilot lot, BPC will be accorded to the supplier/manufacturer. For subsequent supplies, QAP, mentioned in para 1.0 above shall be the guiding document.
- 5.0 **Open Tender Enquiry (OTE) / Limited Tender Enquiry (LTE) / Option Clause (OC) Cases:**
- Inspection and acceptance/rejection thereof, shall be done as per provision of QAP mentioned in para 1.0 above.



*H Kunal*  
(हिमराज कुणाल)  
समुह अधिकारी / क्यू  
कृते मुख्य महाप्रबंधक