

QUALITY ASSURANCE PLAN
RIFLE 5.56 mm. INSAS.
(INVESTMENT CASTING COMPONENTS)

1	NOMENCLATURE	RETAINER SPRING RECOIL (I.C.)
2	DRG. NO./D.S.CAT.NO.	RFI.SK.: - 4663 ^{*2} 8064 - S
3	MATERIAL SPECIFICATION	B.S:3146 PT.I:1974, CLASS 12 GRADE C.
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING.
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING.
6	THE FOLLOWING DOCUMENTS ARE TO BE VERIFIED/SUBMITTED.	
	a) SUPPLY ORDER.	f) CRACK DETECTION CERTIFICATE.
	b) MIS.	g) RADIOGRAPHIC TEST CERTIFICATE.
	c) BATCH NO./HEAT NO.	h) DECARBURISATION TEST CERTIFICATE.
	d) CHEMICAL TEST CERTIFICATE.	i) PRE INSPECTION REPORT.
	e) MECHANICAL TEST CERTIFICATE.	j) BATCH SIZE.
7	VISUAL :- SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL S-4 AQI-1 IS:2500 (PT.I):2000.	
	CASTING SHOULD BE FREE FROM CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES, SHARP EDGES, BURRS ETC.	
8	DIMENSIONAL CHECKING, SAMPLE SIZE AS PER SPECIAL INSPECTION LEVEL S-4 OF IS:2500 (PT.I):2000.	

SL. NO.	AUDIT POINTS	DRG. ZONE	GAUGE NO./METHOD	CLASS OF DEFECT (DCL)	ACCEPTANCE (AQL AS PER IS:2500)
1	42.5	E-6	G.E	MAJOR	4.0
2	±0.1 2.6	E-7	-DO-	-DO-	-DO-
3	±0.1 22.0	D-7	-DO-	-DO-	-DO-
4	-0.1 3.5	C-4	-DO-	-DO-	-DO-
5	-0.2 11.40	D-8	-DO-	-DO-	-DO-
6	7.0 (=/=)	C-8	-DO-	-DO-	-DO-
7	10.5	D-7	-DO-	-DO-	-DO-
8	12.0	C-8	-DO-	MINOR	6.5
9	14.2	C-8	-DO-	-DO-	-DO-