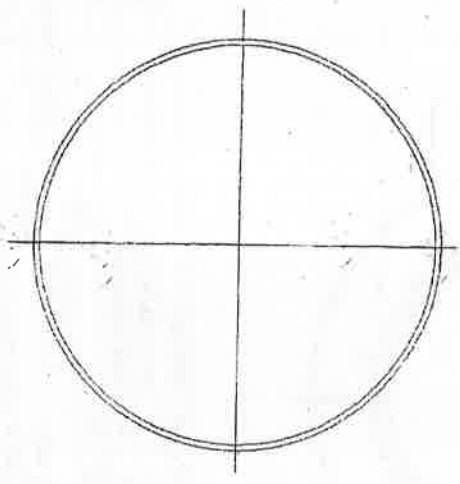
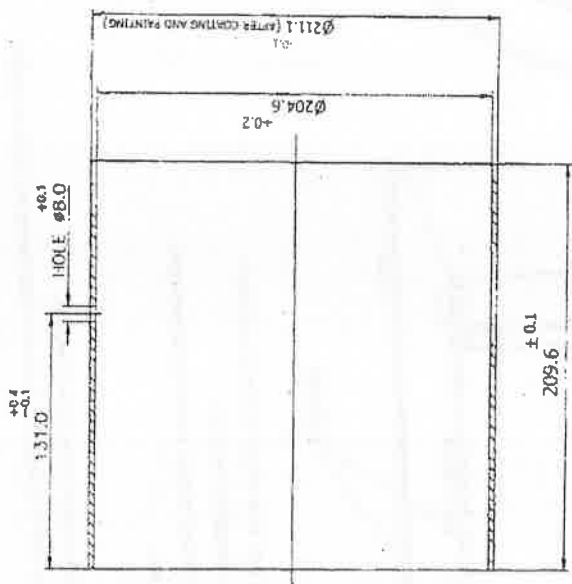


2
 1. INSPECTION OF ONLY FOLLOWING FEATURES ON COMPONENT :-
 (a) INNER DIA OF CYLINDER
 (b) HOLE
 2. REMAINING FEATURES AFTER FINAL TAIL UNIT ASSEMBLY.



NOTE :-
 1. INSPECTION OF ONLY FOLLOWING FEATURES ON COMPONENT :-
 (a) INNER DIA OF CYLINDER
 (b) HOLE
 2. REMAINING FEATURES AFTER FINAL TAIL UNIT ASSEMBLY.

क्र. सं. (Sl. No.)	विवरण (Description)	मात्रा (Quantity)	संग्रह स्थान (Store Location)	संग्रह तिथि (Date)
1	आंतरिक व्यास (Inner Diameter)	1
2	छाद (Hole)	1

SCHEDULE OF COMPONENTS

क्र. सं. (Sl. No.) विवरण (Description) मात्रा (Quantity) संग्रह स्थान (Store Location) संग्रह तिथि (Date)

1 आंतरिक व्यास (Inner Diameter) 1 ...

2 छाद (Hole) 1 ...

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OUTER CYLINDER MOD 1

NASK 1134/1/8/2(P)

डी. जे. नौसेना आयात निरीक्षण महाविद्यालय
 Die Gen of Naval Armament Inspection
 HQ/ Mod (NAVY), New Delhi

Inspection Report

Description of the item		ASSEMBLY FIN MOD 1	Inspection Activity Catagorisation: Critical
Drawing No.		NASK 1134/1/8(P)	Inspection by: NAI
Special Notes:			
Ser	Note		Observations
1	Strip Mod 1 is to be welded with inner cylinder and then to be welded with outer cylinder as shown in drawing.		
2	OD of outer cylinder & ID of inner cylinder to be finished after Assy of outer cylinder, inner cylinder & strip to minimise the ovality in Assy fin.		
3	Ovality on negative side: 0.3mm. Max passing of Assembly fin through chamber gauge mandatory.		
4	Inspection of following features after Assy:- (a) OD of outer cylinder. (b) ID of inner cylinder. (c) Ovality		
5	Ensure tight fitment of Strip between inner & outer cylinders prior to welding.		
6	Parallel and perpendicular position of assembly fin after welding to be checked with gauge		
7	Zinc and yellow chromate coating (25 micron) on Assembly fin to spec. IS 1573.		
8	External & internal surfaces marked xxx in the drawing and Strip to be painted with PU paint colour dove grey (three coats i.e. Chemzinc 1000 as first coat, Chemprime 3001 as second coat & Chemthane 3300 as third coat) (ISC no. 694 to IS:5) except threaded surfaces.		
9	Ovality, outer dia & total length to be checked on 100% stores.		
10	Manufacturer's logo and serial no. to be engraved at white stage and stenciled with black colour paint to Spec IS 138 in 10mm letter size leaving 15mm space from rear side of the inner surface of outer cylinder.		
11	General tolerance spec. IS 2102 unless specified.		

S. KASTURI, J.M.

[Signature]

Inspection Report

Description of the item		OUTER CYLINDER MOD 1					Remarks
Drawing No.		NASK 1134/1/8/2(P)					
Ser	Description of parameter	Nominal dimension as per drawing in mm	Gauge used	Tolerance (As per drg/ spec.)	Nature of Parameter	Observed dimension in mm	Deviation in mm
1	Outer diameter	211.1 (Post Plating & Painting)	Snap gauge	-0.1	Major		
2	Inner diameter	204.6	Plug 'Go' & 'No Go' gauge	+0.2			
3	Dia.of hole on circumference	8		+0.1			
4	Hole centre distance from end	131		+0.4 / -0.1			
5	Overall length	209.6		±0.1			
Special Notes:							
Ser	Note	Observations					
1	Material: Steel to spec BS 970(Pt 3)-91 Gde 817 M40.						
2	Hardened & tempered 'X' Condition.						
3	General tolerance spec IS 2102 (Medium class) unless specified. Inspection of only following features on component:-						
4	(a) Inner dia.of cylinder (b) Dimensions of Hole & Distance (c) Remaining features ie. Total length & Outer Dia to be finished after final Fin Assy to minimise ovality in Fin Assy.						
5	Finish as per assembly drawing.						

K. KASTORI, Juny

(A. Karasamy)
Civilian Technical Officer (Mech)

Inspection Report

Description of the item		INNER CYLINDER						
Drawing No.		NASK 1134/1/8/1(P)						
Ser	Description of parameter	Nominal dimension as per drawing in mm	Gauge used	Tolerance (As per drg/ spec.)	Nature of Parameter	Observed dimension in mm	Deviation in mm	Remarks
1	Outer diameter	154		-0.2				
2	Inner diameter	149	Plug 'Go' & 'No Go' gauge	±0.1				
3	Internal thread	140 x 12 B.S. BUTTRESS THREAD TPI CLOSE CLASS						
4	Length of internal thread	12		+0.4				
5	Inner step diameter (other end)	149		+0.1	Major			
6	Length of inner step dia.149	23		±0.1				
7	Tapped hole on circumference (1 no.)	M 6 x 1	Screw plug 'Go' & 'No Go' gauge					
8	Centre distance of tapped hole from end	133		+0.4 / -0.1				
9	Overall length	162		±0.1				
10	Chamfer Angle	70°						
Special Notes:								
Ser	Note			Observations				
1	Material: Steel to spec BS 970(Pt 3)-91 GDE -817 M40 (EN24).							
2	Hardened & tempered 'X' Condition.							
3	Metric thread to conform to spec IS:4218.							
4	Buttress thread to conform to spec BS:1657							
5	General tolerance spec IS 2102 (Medium class) unless specified.							
6	Inspection of only following features on component							
	(a) Outer dia. of cylinder							
	(b) Dimensions of Hole & Distance.							
	(c) Remaining features i.e. Inner dia to be finished after final fin Assy to minimise ovality in fin Assy.							
7	Finish as per assembly drawing							

K. HASTORI, JAWA

[Handwritten Signature]

Inspection Report

Description of the item		STRIP MOD 1						
Drawing No.		MASK 1134/1/8/3 (P)						
Ser	Description of parameter	Nominal dimension as per drawing in mm	Gauge used	Tolerance (As per drg/ spec.)	Nature of Parameter	Observed dimension in mm	Deviation in mm	Remarks
1	Overall length	208		±0.1	Major			
2	Overall width	26		+0.2				
3	Length (taper cut at other end)	50		-0.1				
4	Flat width (other end)	6		±0.5				
5	Flat thickness	3		-0.1				
Special Notes:								
Ser	Note			Observations				
1	Material: Steel to spec BS 970(PT 3)-91 Gde- 817 M40 (EN 24).							
2	General Tolerance spec IS 2102 (Medium class) unless specified.							
3	Ensure tight fitment between outer and inner cylinders prior to welding.							
4	Finish as per assembly drawing.							

K. Bastola, Jw

A. Ramasamy

A Ramasamy)

Civilian Technical Officer (Mech)

HEPF, TRICHY

The HIGH ENERGY PROJECTILE FACTORY (HEPF) is an Indian Defence establishment under Munitions India Limited, A Government of India Enterprise, Ministry of Defence, for production of anti tank kinetic energy projectiles of various calibers and the factory is located about 25 kilometres from the main city of Tiruchirappalli.

SCOPE OF WORK

PR No: 2300166

MACHINING OF RGB60 TAILFIN ASSEMBLY FROM STEEL TUBES AND STRIP AS PER DRG No: NASK 1134/1/8 (P) AND QUALITY ASSURANCE PROCEDURE (QAP)


1. Raw material, steel tubes (OUTER CYLINDER: OD 219 mm, ID 199.8 and length 215 mm, INNER CYLINDER OD 159mm ID 132.8 and Length 170mm, STRIP -4 Nos/JOB) BS 970(Pt3)-91Gde 817 M40 (EN24), Hardened and Tempered to X condition and weight 22 KGs approximately will be supplied by HEPF.
2. The firm has to carry out only machining work of Tail fin assembly including welding.
3. The firm need not return the scrap generated during machining, however, the firm should submit their offer lowest by taking the cost of steel scrap of 16.5 kgs (approx) generated in machining into account.
4. The firm has to take utmost care to avoid material rejection due to dimensional deviation during machining and welding.
5. In case of rejection exceeds 2%, the existing cost of raw material will be recovered from the firm. The firm shall also return the rejected components to HEPF.
6. The firm should submit Bank guarantee for the cost of raw material for minimum 50 Nos, and collect the material from HEPF store within 10 days of placement of supply order. Firm should make their own arrangement (including loading/ unloading) for collection of raw material from HEPF stores and deliver the finished / accepted components to HEPF stores.
7. Firm should submit pilot sample along with dimension report within 15 days of receipt of raw material for prior approval.
8. The pilot sample submitted by the firm shall be inspected by HEPF Quality Control Section / inspection authority before bulk production.
9. After obtaining approval of pilot sample, the firm should maintain the delivery schedule of minimum 50 Nos for every week from the date of receipt of the raw material.

QUALITY ACCEPTANCE CRITERIA:

10. The components shall be inspected by Quality Control Section /HEPF or Naval Armament of Inspectorate (NAI) as per drawing and Quality Assurance Procedure (Inspection Report). If it is confirming to both drawing and Quality Assurance Procedure (Inspection Report) the same will be accepted.

- Note:**
1. Prospective bidders are free to visit HEPF before bidding, for understanding the operation.
 2. In case of technical clarification the bidders may contact : 0431-2584-645 & 662, 0431-2584600 Extn: 271.


GO/MS


DO/MS


OIC/MS