

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	5564279							QAP No: OFT/QAP/M2HB/5564279	
Nomenclature	CAM, EXTRACTOR, COVER ,OOW50BMG. : REQD. FOR COVER SUB ASSEMBLY ( 5504081)								
Material	WROUGHT STEEL, ASTM A108: 1018-1022, ASTM A322,A331; 4118,8615 OR 8620. FOR CASTING: STEEL, MIL-S-22141, IC 8620. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 4 OF SAE AMS 2175.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI or their authorised Rep. (Review/Witness) (*)	Remarks
Cam, Extractor, Cover (Raw material)	General appearance	Critical	Visual	100%	WROUGHT STEEL, ASTM A108: 1018-1022, ASTM A322,A331; 4118,8615 OR 8620. FOR CASTING: STEEL, MIL-S-22141, IC 8620. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 4 OF SAE AMS 2175.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%		CARBURIZE FOR 3 TO 5 MINUTES AT 802°C - 816°C. OIL QUENCH. TEMPER ALL OVER AT 149°C FOR 1 HOUR MINIMUM TO FILE HARDNESS.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Critical	Visual and Dimensional Checks	100%		AFTER ASSEMBLY	Test report from NABL lab	R	
In process -As per Drawing 5564279	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%		As per Drawing 5564279	Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%		As per Drawing 5564279	Firm Inspection report	W	

(\* ) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) & (iii) the following is applicable.

- (ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.
- (iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.

NAI

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OFT

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