

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	6008920								QAP No: OFT/QAP/M2HB/6008920
Nomenclature	BEARING, BREECH ,OOW50BMG. : REQD. FOR HB ASSEMBLY (7265636)								
Material	CASTING, IRON, MALLEABLE, PEARLITIC, ASTM A220, GRADE 45006 OR CONTINUOUSLY CAST GRAY IRON BAR ASTM A48, CLASS 40 (DURA-BAR G2) ALT: IRON, DUCTILE CASTINGS, ASTM A536, GRADE 80-55-06 OR ASTM A536, GRADE 65-45-12.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI / GM/OFT (Review/Witness) (*)	Remarks
Bearing, Breech (Raw material)	General appearance	Non Critical	Visual	100%	CASTING, IRON, MALLEABLE, PEARLITIC, ASTM A220, GRADE 45006 OR CONTINUOUSLY CAST GRAY IRON BAR ASTM A48, CLASS 40 (DURA-BAR G2) ALT: IRON, DUCTILE CASTINGS, ASTM A536, GRADE 80-55-06 OR ASTM A536, GRADE 65-45-12.		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	
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171	Finish: 5.3.1.2 (or) 5.3.2.2	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
In process -As per Drawing 6008920	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 6008920		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 6008920		Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause No. 3(b), Sub clause (i) is applicable for In-House manufacturing and inspection by GM/OFT. Sub clause (ii) is applicable for <u>out sourced</u> components. JRI will be done by NAI &amp; OFT on sampling basis. For springs: (i) Trade : Raw material to finished product QA by NAI. (ii) In house : Dimension inspection and Load test on sampling basis by NAI.</p>									

NAI

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OFT

*[Signature]*  
OFT  
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