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GUN CARRIAGE FACTORY



JABALPUR

INDUCTION HARDENING OF
SECTOR (675-54-190)

QUALITY ASSURANCE PLAN

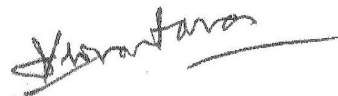
PREFACE

THE GENERAL PROCEDURE GOVERNING QUALITY ASSURANCE ACTIVITIES OF SECTOR TO DRAWING NO 675-54-190 OF BMP II GUN MOUNT HAVE BEEN LAID DOWN IN THIS QUALITY ASSURANCE PLAN.

THE QUALITY ASSURANCE ACTIVITIES MUST BE CONDUCTED STRICTLY IN ACCORDANCE WITH THE DRAWINGS AND SPECIFICATIONS MENTIONED IN THE QUALITY ASSURANCE PLAN.

DATE: 26/04/2019

PLACE : JABALPUR



(SANJAY SHRIVASTAVA)
JOINT GENERAL MANAGER/QC
GUN CARRIAGE FACTORY, JABALPUR

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QAP NO. : SECTOR /01

QUALITY ASSURANCE PLAN
OF
INDUCTION HARDENING OF SECTOR OF BMP-II GUN
MOUNT
(675-54-190)

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QUALITY ASSURANCE PLAN

NOMENCLATURE OF STORE: INDUCTION HARDENING OF SECTOR OF BMP-II
GUN MOUNT

DRAWING NUMBER: 675-54-190

INSPECTION FOR FIRST TIME SUPPLIER

For proving the establishment of the hardening process, the firm, in presence of GCF representative, shall inspect & test the first Sector after induction hardening in the following manner:

- The firm shall carry out destructive testing of the first induction hardened Sector and shall arrange for cutting/sectioning of Sector along the depth of induction hardening.
- The firm shall then carry out necessary testing to check the case depth (Depth up to which the induction hardening effect has propagated) and ensure the same to the desired range as per Drawing.
- The firm shall arrange for hardness testing at the surface where induction hardening has been done and also check the hardness within the case depth on sectioned piece, along the full circumference of the Sector. The firm shall make sufficient test pieces to cover the full circumference of Sector. The measured hardness of the test piece should lie in the range HB 388 – HB 477.
- The firm shall prepare necessary test report mentioning the above parameters and shall submit the joint test report to GCF for acceptance.
- After successful establishment of the Induction Hardening Process, the other Sectors shall be accepted based on hardness testing at the surface where induction hardening has been done for each Sector and ensuring that the same should lie in the range HB 388 – HB 477.
- The firm shall prepare necessary test report for hardness testing and shall submit the same to GCF along with the job.

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QUALITY ASSURANCE PLAN

NOMENCLATURE OF STORE: INDUCTION HARDENING OF SECTOR OF BMP-II
GUN MOUNT

DRAWING NUMBER: 675-54-190

INSPECTION FOR REGULAR SUPPLIER

For regular supplier, whereby the Induction Hardening process has already been proven by destructive testing, the firm, shall inspect & test the Sector after induction hardening in the following manner:

- The firm shall arrange for hardness testing at the surface where induction hardening has been done for each Sector and ensure the same should lie in the range HB 388 – HB 477.
- The firm shall prepare necessary test report for hardness testing and shall submit the same to GCF along with the job.

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