

QUALITY ASSURANCE PLAN		GAP No: ARDE/QAP(PROV)/JVPC/ PISTOL GRIP AND LOWER BODY ASSEMBLY / 02	
Issue No. 1	Date: 30/11/2010	Revision No. 2	Date: 10/12/2015
Component / Assembly		BUTTON CATCH MAGAZINE	

1 Drawing no. : 0204 03 02 02 19 002 00DD

2 Method of Manufacture : Machining

3 Receiving inspection :

3.1 Raw material : Steel to IS: 5517-1993, Gd-40C8 (En-8)

3.2 Tests / Checks and Acceptance Criteria for Raw Material:

Sl. No	Test / Check	Parameter	Acceptance Value
1	Chemical Analysis	Chemical Composition	As per spec.

4 In-Process Inspection : Nil

5 Stage Inspection : Nil

6 Final Inspection :

6.1 Visual Examination : Sample Size -100%

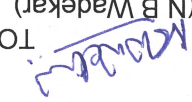
6.1.1 Features for Visual Examination and Acceptance Criteria:

Sl. No	Details of features	Sample Size	Acceptance Criteria
1	Sharp edges, burrs	100%	Not allowed
2	All features like Chamfers , Radius , Undercut etc	100%	To be present

6.2 Dimensional Inspection:

6.2.1 Critical Dimensions :

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	4.0+0.1	A-3	Position Gauge
2.	2.0-0.1	B-3	Vernier Calliper
3.	2.0-.1	B-2	Vernier Calliper

Prepared By:  (N B Wadekar)	Recommended By:  (RS Rao)
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6.2.2 Geometrical Features : Nil

6.2.3 Major Dimensions : Sample Size -100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	11.0-0.1	C,D-3	Vernier Caliper
2.	Ø8.0-0.1	C,D-1	Micrometer

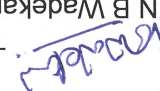
6.2.4 Minor Dimensions : Nil

6.3 Tests on Finished Items :

6.3.1 Details of Tests / Checks on Finished Items and Acceptance Criteria:

Sl. No	Test / Check	Sample Size	Acceptance Values
1.	Hardness	10 %	250-300
2.	Protective Finish	5%	Phosphated to Specification IS:3618 -1966, Class 'B'.

7 Details of tests and other information: Nil

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