

QAP FOR 12 BORE PAG (METALLIC COMPONENT)

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DATE: 18-02-2019

1. NOMENCLATURE	MAGAZINE COVER PIPE		
2. DRG. NO/D.S. CAT No.	PAG-0009		
3. MATERIAL SPECIFICATION	BS-970-1956, En-9 IN T CONDITION		
4. CHEMICAL COMPOSITION	AS PER SPECIFICATION		
5. PHYSICAL PROPERTIES	AS PER SPECIFICATION		
6. DOCUMENT VERIFICATION	A) SUPPLY ORDER B) MIS C) BATCH No. D) CHEMICAL TEST CERTIFICATE E) MECHANICAL TEST CERTIFICATE F) CRACK DETECTION CERTIFICATE G) PRE-INSPECTION REPORT H) BATCH SIZE		
7. VISUAL CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(Pt.1):2000	A) COMPONENT SHOULD BE FREE FROM RUST, PITS, CRACKS, SHARP EDGES AND BURRS. B) MARKINGS AS PER DRAWING		
8. DIMENSION CHECKING SAMPLE SIZE AS PER GENERAL INSPECTION LEVEL-1 & AQL-4.0 IS:2500(Pt.1):2000	S.No.	AUDIT POINTS/DIMENSIONS	GAUGE No./METHOD
	1	M-28.5X1.6h	GE METHOD/GAUGE
	2	φ28.9±0.1	RFG-23905-G
	3	LENGTH 19.5	GE METHOD/GAUGE
	4	LENGTH 197.5	GE METHOD/GAUGE
	5	11	GE METHOD/GAUGE
	6	φ26.8±0.035±0.022	RFG-23906-G
	7	φ25.0±0.02	RFG-23907-G/ RFG-23908-
	8		
	9		
	10		
	11		
	12		
	13		
	14		
	15		
	16		
9. HEAT TREATMENT	HARDNESS 200-250 VPN		
10. CASE DEPTH	NA		
11. PROTECTIVE FINISH	PHOSPHATED TO SPECN: JSS-0465-01 1988 CLASS II OIL FINISH.		
12. OTHER TESTS	AS PER DRAWING/SPECIFICATION		

NOTE:

1. PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
2. TEST REPORT IS TO BE ISSUED FROM NABL APPROVED LAB./DGQA LAB./DGQA APPROVED LAB./ORDNANCE FACTORIES LAB.
3. RECORD OF TEST REPORT WITH REFERENCE TO MIS/S.O. No. ARE TO BE MAINTAINED.
4. ENSURE MARKING OF MANUFACTURER'S CODE ON THE STORE SUITABLY & ENTRY OF LOT No. & YEAR OF MANUFACTURING IN INSPECTION REPORT.
5. TEST PIECES (CAST ALONG WITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECN. ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

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REP OF ODC

HOS/ODC

JWM DO/QC(IM)

verified
JWM