

QA PLAN FOR COVER LRCR & MRCR (FRP GLASS RED)
TO DRG NASK 939/22 (PROV)

1. On receipt of supply order, vendor/ firm shall contact the inspecting agency/ officer to discuss technical requirement of inspection, production schedule and confirm adequacy of paper particulars.
2. QCP (Quality Control Plan), PP (Process Plan) shall be formulated/ discussed by the firm/ vendor with the inspection agency prior to commencement of production.
3. **Item Specn:** Cover LRCR & MRCR to Drg. NASK 939/22 (Prov) (FRP GLASS RED COLOUR)
Item code: 9077100048
4. All correspondence related to sampling of raw material/inspection/ acceptance of the subject store are to be addressed to inspecting officer.
5. The Physical and chemical composition of the raw material involved must be tested as per the specification quoted in the drawing NASK 939/22 (Prov).
6. The firm, before commencement of production Cover LRCR & MRCR and while making an inspection call must get the raw material checked, both for physical and chemical properties from NABL accredited/Govt. approved Labs and copies of the same are to be forwarded to the inspecting officer along with inspection call letter.
7. The raw material receipt document and test certificates received from the supplier for the involved material for manufacture of Cover LRCR & MRCR to Drg. NASK 939/22 (Prov) must also be put up to the inspecting officer along with the call letter.
8. In case items are being procured or sub-contracted, the supply order of the same are required to be routed through the nominated inspection agency for vetting of technical parameters/requirements thereof.
9. Test sample from the raw material to be used in the manufacture of Cover LRCR & MRCR to drg NASK 939/22 (Prov) is to be drawn by the inspecting officer or his representative. The samples are to be sealed separately by the inspecting officer, and sent for testing (physical and chemical testing) to NABL labs under their covering letter, so that the test result is sent directly to the Inspecting officer and not to the firm. The remaining bulk quantity of raw materials is to be sealed by the inspecting officer.
10. The firm is to start production of **Advance samples (05 Numbers)** of the subject store only after getting clearance from the inspecting officer

regarding satisfactory testing of all the raw material. The raw materials are to be taken up for manufacture only after removal of seals on clearance given by the inspecting officer.

11. The Firm after manufacture of the subject store, should conduct pre-inspection checks by the Firm's QC for all the dimensions, and render a detailed report to the inspecting officer, before making an inspection call.

12. The Gauges /measuring instruments are to be provided/arranged by the firm. The instruments provided should be calibrated and must be within calibration due date. A certificate in this regard is to be provided to the inspecting officer or his representative.

13. The Advance samples of manufactured Store are to be checked for following:-

(a) **Visual Inspection.** The store should be visually examined 100%. The Store should be made of FRP Glass (Red colour).

(b) **Dimensional Inspection.** Dimensional inspection to be carried out for all the components as per the relevant drawing dimensions (as per Section A, AA & BB).

(c) **Tests to be performed.**

(i) There should be no water leakage between the Disc 'A' and the body of the cover muzzle.

(ii) The Disc 'A' should shear off with a force of 3 to 5 Kgf.

14. On satisfactory inspection of advance samples. The samples to be forwarded to GCF, Jabalpur for Fitment test. Upon receipt of satisfactory fitment report, the firm shall be permitted to commence Bulk Production.

15. The subject store is to be fabricated with due care in accordance with the drawing, the workmanship is to be of the best quality and sharp edges are to be removed. It should be ensured that there is no crack and breakage. After production of Bulk the firm is to pre-inspect the complete bulk and make available the pre-inspection report to the inspection agency while making inspection call for the bulk.

16. The bulk quantity of the store will be inspected/checked for the following parameters (by the inspector):-

(a) **Visual Inspection.** The store should be visually examined 100%. The Store should be made of FRP Glass (Red colour). The store should be free from cracks and breakage. No sharp edges. The Slot dia and slot width should be maintained as per the drawing.

(b) **Dimensional Inspection.** Dimensional inspection to be carried out for all the components as per the relevant drawing dimensions (as per Section A, AA & BB).

(c) **Tests to be performed.**

(i) There should be no water leakage between the Disc 'A' and the body of the cover muzzle.

(ii) The Disc 'A' should shear off with a force of 3 to 5 Kgf.

(d) Any other tests warranted by Inspecting Officer.

17. Any additional technical requirement projected by the inspection agency to ascertain quality of the product shall be arranged by the firm/vendor.

18. **Note :** Store should be submitted to Inspecting Officer for inspection within the delivery period.

CHECKED
J. Ahari
10/01/23
for Chief Inspector of Naval Armament
JABALPUR