

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313068								QAP No: OFT/QAP/M2HB/7313068
Nomenclature	SPRING, HELICAL COMPRESSION, OOW50BMG .REQD FOR HB ASSEMBLY (7265636)								
Material	WIRE, MUSIC, STEEL, ASTM A228.								
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
Spring, Helical Compression (Raw material)	General appearance	Non Critical	Visual	100%	WIRE, MUSIC, STEEL, ASTM A228.		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	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	100%	As per Drawing 7313068	STRESS RELIEVE AT 224°C ± 5°C FOR 30 MINUTES AFTER COILING.	Test report from NABL lab	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Protective Finish	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-STD-171 WITH MIL-L-3150	Finish 3.3.1 , SUPPLEMENTARY OIL TREATMENT.	Test report from NABL lab	R	
In process -As per Drawing 7313068	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313068		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313068		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 out sourced components. JRI will be done by NAI & 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>									

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