



QUALITY ASSURANCE PLAN



Document ID	QAP-00886
Subject	SGL PACKING BOX TO DRG.NO. GCF/20A/SK-898
Revision	A
Release Date	30-Apr-2024 11:41
Effective From	

Prepared By	Checked By	Approved By
903241	992727	992034

GUN CARRIAGE FACTORY
A GOVT. OF INDIA ENTERPRISE
MINISTRY OF DEFENCE
(A UNIT OF ADVANCED WEAPONS AND EQUIPMENT INDIA LTD)

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A Summary of Changes section appears at the end of this specification

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QAP

This quality plan is a general guide to meet the quality requirements of product. It consists of applicable procedures (describing production processes, inspection & testing instructions), applicable workmanship standards, the measurement tolerances acceptable, the description of material standards and so forth. It also mentions the list of documents, test certificates that will be submitted by firm to GCF along with finished component.

1. Nomenclature & Drawing No.: SGL PACKING BOX & [GCF/20A/SK-898](#)

2. Dimension & Tolerance:

As per relevant [IS:2102-1993](#) standard etc. mention in drawing of item/component. In case of assembly or subassembly drawings the type of fit should be follow as per relevant drawings. Angular or linear attachment or fitting at any location should be as per drawings.

2. Method of manufacture & Inspection schedule:

S. NO.	Sequence of operation/ process/functional check/Inspection	REMARK (SAMPLE PLAN OR ANY OTHER APPLICABLE INSTRUCTIONS)
1	FIT ASSEMBLE ALL DETAIL AS PER DRG.	ASSY SHOULD CONFIRM ACCEPTANCE TEST
2	ACCEPTANCE TEST	

3.0 Inspection: Following methodology is to be followed for inspection.

3.1 Mode of Inspection & Sample Size/Selection:

(a) At Firm Premises: Inspection by the manufacturer for 100% quantities of lot size.

(b) At receipt End: Inspection by MID/QC (GCF Rep.) at receipt at GCF. Sample selection as per existing IS standard [2500 part-II, 1965](#).

(c) Acceptance as per performance Test/ Fitment Trial/ Practical Trial/ Any other functional requirement.

4. Submission of Documents:

Following documents should be submitted along with finished product:

- (1) Acceptance test report after functional trial.
- (2) NABL/Govt. approved Lab certificate required for material.
- (3) It is mandatory for supplier to fill and submit Annexure 'A' format along with documents mentioned in Annexure with each lot of material supplied to GCF

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SUMMARY OF CHANGES

SL No	Document	Rev	Change
1	SGL PACKING BOX TO DRG.NO.GCF/20A/SK-898	A	Initial Release

GCF Released

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ANNEXURE A

Firm's Name						Format No:	GCF-MTO-QAP-DI						
						Version No	1						
PO No	ITEM DESCRIPTION	DRG NO		PO QTY	EARLIER ACCETED QTY	OFFERED QTY	TOTAL NO OF PAGES IN REPORT					PAGE	1 of N
9999	ABC	XYZ		A	B	C	N						
SI No	ASSY / COMPONENT DESCRIPTION	DRG NO	TYPE OF ITEM	DRG MTL SPEC	SPEC OF USED MATERIAL	CHEMICAL TEST REPORT (Page No)	MECHANICAL TEST REPORT (Page No)	DIMENSIONAL REPORT (Page No)	SURFACE TREATMENT CERTIFICATE (Page No)	UT/RG/ MPI TEST REPORT (Page No)	FUNCTIONAL TEST	CoC	DETAIL OF ANY OTHER TEST (Page No)
1	SGL PACKING BOX	GCF/20A/SK-898	MTO			NO	NO	YES	NO	NO	YES	YES	

SIGNATURE OF AUTHORIZED QUALITY PEPRSON OF FIRM

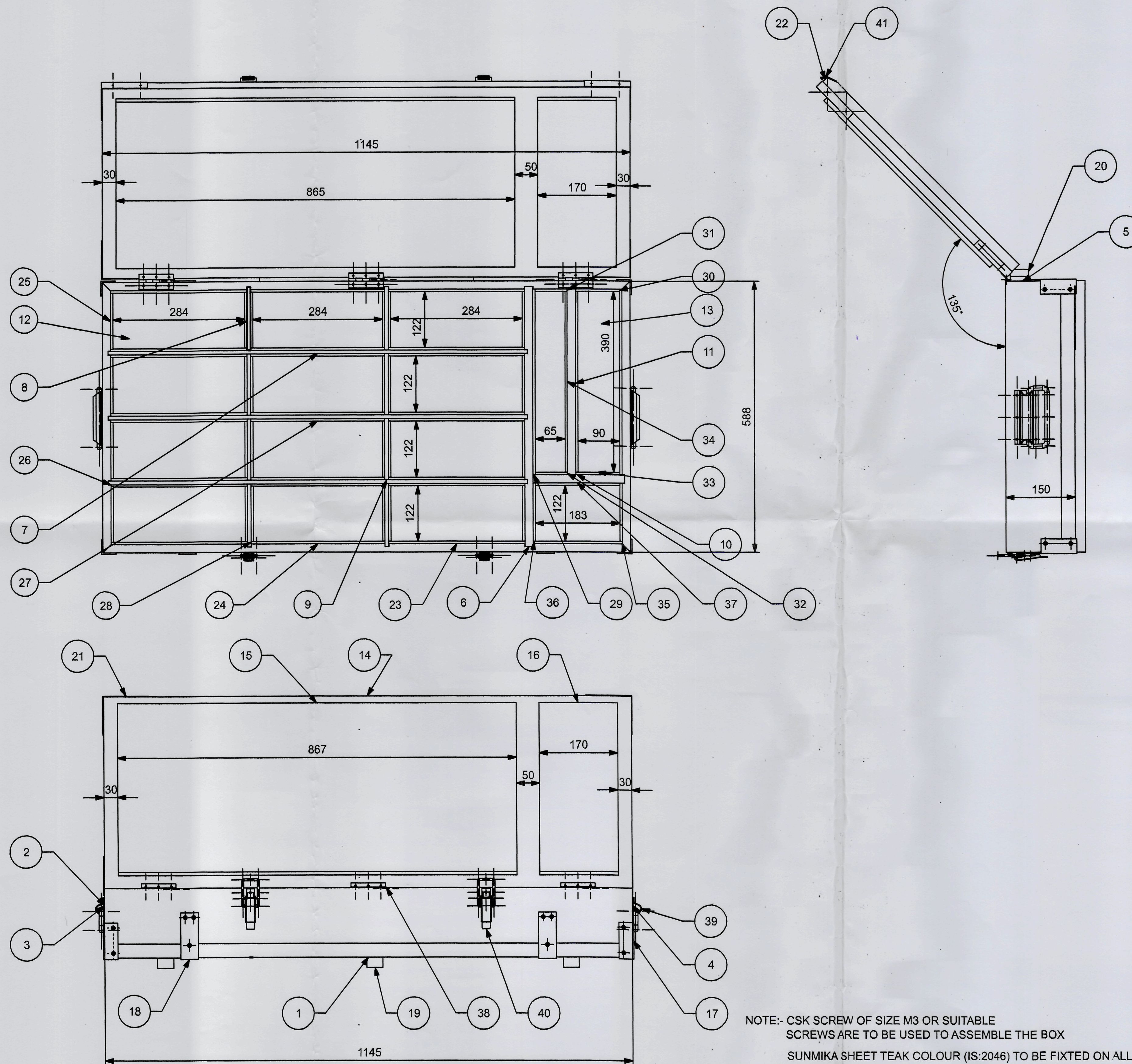
NOTE:

- 1 ALL PAGES TO BE NUMBERED AND INDEX SHALL BE GIVEN PAGE NO 1
- 2 Column No B C D & E Shall be filled by Buyer
- 3 Column F shall be filled by supplier based on material used for manufacturing and shall comply with material mentioned in column E
- 4 Firm shall fill Column G H I J K L with page no "From - To" where ever YES is mentioned

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NOTE:- CSK SCREW OF SIZE M3 OR SUITABLE
SCREWS ARE TO BE USED TO ASSEMBLE THE BOX

SUNMIKA SHEET TEAK COLOUR (IS:2046) TO BE FIXTED ON ALL OUTER FACES
BEFORE MOUNTING OF ALL METAL PARTS & LIFTING HANDLES

FLEXIBLE POLYURETHENE FOAM TO IS:7888

ALL METAL DETAILS TO BE BLACK PAINTED

WOOD SUPPORT TO IND/ME/883

PLYWOOD TO SPEC IS:707

41	HOOK	2	2X25X40	
40	FRONT CLOSER LOCK ASSY	2	STANDARD	
39	LIFTING HANDLE ASSY	2	STANDARD	
38	HINGE ASSY	3	STANDARD	
37	INSIDE WALL FOAM 183X100	1	5x100x183	BLACK COLOUR
36	INSIDE WALL FOAM 127X110	2	5x110x127	BLACK COLOUR
35	INSIDE WALL FOAM 193X110	1	5x110x193	BLACK COLOUR
34	INSIDE WALL FOAM 390X100	2	5x100x390	BLACK COLOUR
33	INSIDE WALL FOAM 100X95	1	5x95x100	BLACK COLOUR
32	INSIDE WALL FOAM 100X70	1	5x70x100	BLACK COLOUR
31	INSIDE WALL FOAM 110X70	1	5x70x110	BLACK COLOUR
30	INSIDE WALL FOAM 110X95	1	5x85x110	BLACK COLOUR
29	INSIDE WALL FOAM 400X110	2	5x110x400	BLACK COLOUR
28	INSIDE WALL FOAM 122X100	16	5x100x122	BLACK COLOUR
27	INSIDE WALL FOAM 292X100	6	5x100x292	BLACK COLOUR
26	INSIDE WALL FOAM 296X100	12	5x100x296	BLACK COLOUR
25	INSIDE WALL FOAM 122 L	8	5x110x122	BLACK COLOUR
24	INSIDE WALL FOAM 292 L	2	5x110x292	BLACK COLOUR
23	INSIDE WALL FOAM 296 L	4	5x110x296	BLACK COLOUR
22	WOODEN RIP ON TOP PLY	2	22x35x588	
21	TOP PLY EDGE SUPPORT	4	MS channel 1.5x100x100 18H	
20	WOODEN BACK STOPPER	1	25x40x465	
19	WOODEN RIB	3	22x35x586	
18	SUPPORT	4	MS channel 3x100x100 38L	
17	EDGE SUPPORT	4	3x32x32 78L	
16	FOAM FOUR	1	10x170x514	WHITE COLOUR
15	FOAM THREE	1	10x514x865	WHITE COLOUR
14	TOP PLY	1	18x586x1145	
13	FOAM TWO	1	10x193x550	WHITE COLOUR
12	FOAM ONE	1	10x550x900	WHITE COLOUR
11	INSIDE PLY SIX	1	18x100x400	
10	INSIDE PLY FIVE	1	18x100x199	
9	INSIDE PLY FOUR	4	8x100x132	
8	INSIDE PLY THREE	4	8x100x137	
7	INSIDE PLY TWO	3	8x110x912	
6	INSIDE PLY ONE	1	18x120x562	
5	BACK SIDE PLY	1	18x150x1145	
4	RIGHT SIDE PLY	1	18x150x588	
3	FRONT SIDE PLY	1	18x150x1145	
2	LEFT SIDE PLY	1	18x150x588	
1	BASE PLY	1	30x586x1145	
PC NO	PART NAME	QTY	SIZE	Remarks

GUN CARRIAGE FACTORY, JABALPUR				
2024	NAME	DATE	ASSY. No.	WEIGHT (KG)
DRAWN	Raj	07/02	REF. DRG. No.	REF. ONLY
CHECKED	7/03		MATERIAL	AS STATED ABOVE
REV	AMENDMENTS	SIGN	DATE	APPROVED
SURFACE TREATMENT		SCALE	NTS	DRG OF SGL PACKING BOX
GENERAL TOLERANCE ACCORDING TO IS 2102-1993		DRG. No. GCF/20A/SK-898		SHEET 1 OF 1