

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313069								QAP No: OFT/QAP/M2HB/7313069
Nomenclature	PAWL, COVER DETENT ,OOW50BMG. REQD FOR HB ASSEMBLY (7265636)								
Material	WROUGHT STEEL, ASTM A108, 1018, 1117, 1118. PRECISION CASTING: STEEL, MIL-S-22141, IC 8620. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 2 GRADE C OF MIL-STD-2175.								
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
Pawl, Cover Detent (Raw material)	General appearance	Non Critical	Visual	100%	WROUGHT STEEL, ASTM A108, 1018, 1117, 1118. PRECISION CASTING: STEEL, MIL-S-22141, IC 8620. TENSILE TEST SHALL NOT APPLY. INSPECTION SHALL BE IN ACCORDANCE WITH CLASS 2 GRADE C OF MIL-STD-2175.		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 7313069	CARBURIZE AT APPROXIMATELY 857°C TO 0.127 TO 0.254 CASE DEPTH. OIL QUENCH. TEMPER ON HOUR MINIMUM AT HEAT TO HARDNESS SPECIFIED (FILE HARD).	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	Finish: 5.3.1.2 (or) 5.3.2.2	Test report from NABL lab	R	
In process -As per Drawing 7313069	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313069		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313069		Firm Inspection report	W	

(\* ) 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.

*PA...*  
 NAI  
 Chief Technical Officer (QA/QC)  
 or Principal Proposer Of ...  
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OFT  
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