

## ROD ASSEMBLY DRIVING SPRING (5564305)

<u>SL.NO</u>	<u>PART NO.</u>	<u>ASSY/COMPONENT</u>	<u>NOMENCLATURE</u>	<u>PAGE</u>
1	5152900	COMPONENT	COLLAR, DRIVING SPRING ROD	171
2	5152898	COMPONENT	PIN, SHOULDER, HEADLESS	172
3	7313289	ROD ASSEMBLY, GUIDE & COMPONENTS	ROD ASSEMBLY, GUIDE	173
4	7313288		ROD, GUIDE	174
5	5152899		PIN, SHOULDER, HEADLESS	175
6	7312243		SPRING ASSEMBLY	176
7	6147509	SPRING ASSEMBLY & COMPONENTS	SPRING, HELICAL COMPRESSION	177
8	6147510		SPRING, HELICAL COMPRESSION	178

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5564305								QAP No: OFT/QAP/M2HB/5564305
Nomenclature	ROD ASSEMBLY DRIVING SPRING , OOW50BMG. REQD FOR HB ASSEMBLY (7265636)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Rod Assembly Driving Spring (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		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 5564305 & Components		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%	As per Drawing 5564305 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5564305 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5564305 & Components		Firm Inspection report	W	

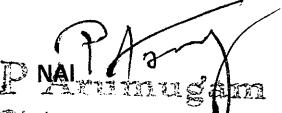
\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

NAI  
**P. Arumugam**  
Civilian Technical Officer (Mech)  
for Principal Inspector Of Naval Armament  
Tiruchirappalli.

OFT  
**G. DEVENDIRANE, I.O.E.S.**  
ASST WORKS MANAGER  
GOVT. OF INDIA, MIN. OF DEFENCE  
ORDNANCE FACTORY  
TIRUCHIRAPPALLI-TAMILNADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5152900								QAP No: OFT/QAP/M2HB/5152900
Nomenclature	COLLOR, DRIVING SPRING ROD , OOW50BMG : REQD FOR ROD ASSEMBLY DRIVING SPRING ( 5564305)								
Material	STEEL, ASTM A576: 1095 AUSTENITIC GRAIN SIZE 5-8 OR STEEL, ASTM A686: CLASS W1-8 THRU 10, GRADE 'C'.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Collor, Driving Spring Rod (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A576: 1095 AUSTENITIC GRAIN SIZE 5-8 OR STEEL, ASTM A686: CLASS W1-8 THRU 10, GRADE 'C'.		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%	HEAT AT 787°C TO 816°C. OIL QUENCH. TEMPER FOR ONE HOUR MINIMUM TO HARDNESS SPECIFIED. (RH 15N 84-88)		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 5152900	Dimensions Specified in the inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5152900		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5152900		Firm Inspection report	W	


\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.


  
**P. Arumugam**  
 Chief Technical Officer (Mech)  
 Inspector Of Naval Armament  
 Chennai.

  
**G. DEVENDRAN, I.U.C.S.**  
 ASST WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI-TAMILNADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5152898								QAP No: OFT/QAP/M2HB/5152898
Nomenclature	PIN, SHOULDER, HEADLESS , OOW50BMG : REQD FOR ROD ASSEMBLY DRIVING SPRING ( 5564305)								
Material	STEEL; ASTM A576: 1095 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Pin, Shoulder, Headless (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A576: 1095 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.		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%	HEAT AT 787°C TO 816°C. OIL QUENCH. TEMPER FOR ONE HOUR MINIMUM TO HARDNESS SPECIFIED. (RH 15N 75-79)		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 5152898	Dimensions Specified in the inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5152898		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5152898		Firm Inspection report	W	

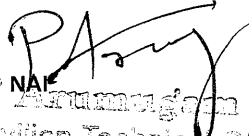
\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.


  
P. Arumugam  
Civilian Technical Officer (Mech)  
or Principal Inspector Of Naval Armament  
Tiruchirappalli.

  
OFT  
G. DEVENDHANE, I.O.S.  
ASST WORKS MANAGER  
GOVT. OF INDIA, MIN. OF DEFENCE  
ORDNANCE FACTORY  
TIRUCHIRAPPALLI-TAMILNADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313289								QAP No: OFT/QAP/M2HB/7313289
Nomenclature	ROD ASSEMBLY GUIDE , OOW50BMG. REQD FOR ROD ASSEMBLY DRIVING SPRING (5564305)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Rod Assembly Guide (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		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 7313289 & Components		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%	As per Drawing 7313289 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7313289 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7313289 & Components		Firm Inspection report	W	

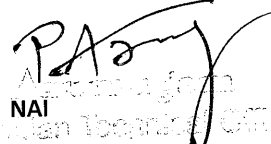
\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.


  
P. N. Arumugam  
Civilian Technical Officer (Mech)  
Principal Inspector (M) Key / ...  
Tiruchirappalli.

OFT   
G. DEVENDRAKANE, I.O.E.S.  
ASST WORKS MANAGER  
GOVT. OF INDIA, MIN. OF DEFENCE  
ORDNANCE FACTORY  
TIRUCHIRAPPALLI - TAMILNADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7313288								QAP No: OFT/QAP/M2HB/7313288
Nomenclature	ROD, GUIDE, OOW50BMG. : REQD FOR ROD ASSEMBLY GUIDE ( 7313289)								
Material	ALLOY STEEL BARS, HOT WROUGHT ASTM A322, GRADES 4140,4142,4340, ALLOY STEEL BARS, COLD FINISHED, ASTM A331, GRADES 4140, 4142, 4340, STEEL BARS, CARBON, HOT WROUGHT, ASTM A576, GRADE 1095.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI or their authorised Rep. (Review/Witness) (*)	Remarks
Rod, Guide (Raw material)	General appearance	Critical	Visual	100%	ALLOY STEEL BARS, HOT WROUGHT ASTM A322, GRADES 4140,4142,4340, ALLOY STEEL BARS, COLD FINISHED, ASTM A331, GRADES 4140, 4142, 4340, STEEL BARS, CARBON, HOT WROUGHT, ASTM A576, GRADE 1095.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%	As per Drawing 7313288	HARDEN BOTH ENDS FOR DISTANCE INDICATED. OIL QUENCH AND TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED RH 15N 84.5-87.5	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	Critical	Visual and Dimensional Checks	100%	As per Drawing 7313288		Test report from NABL lab	R	
In process -As per Drawing 7313288	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 7313288		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 7313288		Firm Inspection report	W	


(\* Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) & (iii) the following is applicable.  
(ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.  
(iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.


  
**NAI**  
 In-charge Officer (Modt)  
 Principal Inspector of Arms & Ammunition  
 Tiruchirappalli.

  
**ASST WORKS MANAGER**  
**GOVT. OF INDIA, MIN. OF DEFENCE**  
**ORDNANCE FACTORY**  
**TIRUCHIRAPPALLI-TAMILNADU**

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	5152899								QAP No: OFT/QAP/M2HB/5152899
Nomenclature	PIN, SHOULDER, HEADLESS , OOW50BMG : REQD FOR ROD ASSEMBLY GUIDE ( 7313289)								
Material	STEEL, ASTM A576: 1095 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness) (*)	Remarks
Pin, Shoulder, Headless (Raw material)	General appearance	Non Critical	Visual	100%	STEEL, ASTM A576: 1095 OR STEEL, ASTM A686: CLASS W1-8 THRU 9, GRADE 'C'.		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%		HARDEN AND TEMPER TO HARDNESS SPECIFIED (RH 15N 76.5-80). LOCALLY TEMPER LENGTH B TO ROCKWELL 15N 72 MAX.	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 5152899	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 5152899		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 5152899		Firm Inspection report	W	


\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

  
**P. Arumugam**  
 Civilian Technical Officer (Mech)  
 Principal Inspector Of Naval Armament  
 Tirappalli.

  
**G. DEVENDIRANE, I.O.F.S.**  
 ASST WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI, TAMILNADU

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)									Issue No : 01 Rev No: 00
									Date of Issue / / 2021
Drg . No.	7312243								QAP No: OFT/QAP/M2HB/7312243
Nomenclature	SPRING ASSEMBLY DRIVING , OOW50BMG. REQD FOR ROD ASSEMBLY DRIVING SPRING (5564305)								
Material	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Spring Assembly Driving (Raw material)	General appearance	Non Critical	Visual	100%	AS PER MATERIAL SPECIFICATION IN THE ASSEMBLY PARTLIST.		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 7312243 & Components		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%	As per Drawing 7312243 & Components		Test report from NABL lab	R	
In process	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	100%	As per Drawing 7312243 & Components		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	100%	As per Drawing 7312243 & Components		Firm Inspection report	W	

\*Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause 3(c) sub clause (i) NAI, Trichy may do Surveillance audit of the reports, if applicable.  
(ii) In case of hard ware items, NAI, Trichy will review the reports, if required.

NAI  
  
**P. Arumugam**  
 Civilian Technical Officer (Mech)  
 for Principal Inspector Of Naval Armament  
 Tiruchirappalli.

OFT  
  
**G. DEVENOKONE, I.O.S.**  
 ASST. WORKS MANAGER  
 GOVT. OF INDIA, MIN. OF DEFENCE  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI



QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	6147509							GAP No: OFT/QAP/M2HB/6147509	
Nomenclature	SPRING, HELICAL COMPRESSION, OOW50BMG : REQD FOR SPRING ASSEMBLY DRIVING ( 7312243)								
Material	STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228 / A228M								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI or their authorised Rep. (Review/Witness) (*)	Remarks
Spring, Helical Compression. (Raw material)	General appearance	Critical	Visual	100%	STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228 / A228M		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%	STRESS RELIEVE AT 224°C ± 5°C . FOR 30 Min 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	Critical	Visual and Dimensional Checks	100%	MIL-STD-171	Finish 5.3.3.1 WITH DRY FILM LUBRICANT MIL-PRF-46010 PER FINISH 30.7 OF MIL-STD-171	Test report from NABL lab	R	
In process -As per Drawing 6147509	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 6147509		Firm Inspection report	R	
Load Test	Mechanical properties	Critical	Mechanical Lab analysis	100%	LOAD TEST SHALL BE CARRIED OUT AS PER DRAWING 6147509		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 6147509		Firm Inspection report	W	
<p>(*) Note : As per the MoU No: OFT / SRCG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) &amp; (iii) the following is applicable.</p> <p>(ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.</p> <p>(iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.</p>									

*P. Narayana*  
**P. Narayana**  
 Civilian Technical Officer (Mech)  
 for Principal Inspector Of Naval Armament  
 Tiruchireppalli.

OFT *G*  
**G. DEVENDIRANE, I.O.F.S.**  
**ASST. WORKS MANAGER**  
**GOVT. OF INDIA, MIN. OF DEFENCE**  
**ORDNANCE FACTORY**  
**TIRUPPALLI**

QUALITY ASSURANCE PLAN (M2HB GUN IM PHASE)								Issue No : 01 Rev No: 00	
								Date of Issue / / 2021	
Drg . No.	6147510							QAP No: OFT/QAP/M2HB/6147510	
Nomenclature	SPRING, HELICAL COMPRESSION, OOW50BMG : REQD FOR SPRING ASSEMBLY DRIVING ( 7312243)								
Material	STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228 / A228M								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by NAI or their authorised Rep. (Review/Witness) (*)	Remarks
Spring, Helical Compression. (Raw material)	General appearance	Critical	Visual	100%	STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228 / A228M		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
Heat Treatment	Mechanical properties	Critical	Mechanical Lab analysis	100%	STRESS RELIEVE AT 224°C ± 5°C . FOR 30 Min 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	Critical	Visual and Dimensional Checks	100%	MIL-STD-171	Finish 5.3.1.2 WITH MIL-PRF-3150 SUPPLEMENTARY OIL.	Test report from NABL lab	R	
In process -As per Drawing 6147510	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	100%	As per Drawing 6147510		Firm Inspection report	R	
Load Test	Mechanical properties	Critical	Mechanical Lab analysis	100%	LOAD TEST SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED SOLID FIVE(5) TIMES.		Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	100%	As per Drawing 6147510		Firm Inspection report	W	
<p><b>(*) Note :</b> As per the MoU No: OFT / SRGG / M2HBGun / MoU /01 Dt: 20.09.2021, Clause no. 3(a), Sub clause (ii) &amp; (iii) the following is applicable.</p> <p>(ii) For springs manufactured In-house (OFT) - Dimension inspection, Load Testing on sampling basis.</p> <p>(iii) For springs procured from vendors - from raw material to finished product QA by NAI, Trichy.</p>									

NAI  
 P. Anand  
 Civilian Technical Officer (QA/QC)  
 Jr Principal In-charge of Quality Assurance  
 Trichy

OFT  
 G. DEVENDIRANE, I.O.E.S.  
 ASST WORKS MANAGER  
 CIVIL OF INDIA, MIN. OF DEFENCE  
 Ordnance Factory  
 TRICHY