

QAP FOR SEMI – FINISHED / IC / FORGING, BLANK OF 12 PAG COMPONENTS

NOMENCLATURE :- STEEL RD SIZE DIA 35 ± 0.5 mm LENGTH 525 ± 1.5 mm. FOR PAG BARRREL INTEGRAN (PB)

DRAWING NO. :- RFI SK 10419-G

MATERIAL SPECIFICATION :- MATERIAL SPECIFICATION: STEEL ROD 35 MM (± 0.5 MM) DIA. TO SPECIFICATION BS: 970, PT-I; 1983 GD 708M40. ALT. MATL. EN-19A, V.D. IN HR PEELED & ANNEALED CONDITION (230 HV MAX). MAINTAINED S & P % COMBINED = 0.022 % MAX. (%S=0.01 MAX & P= 0.015 MAX.) WITH NMIR TEST AS PER IS: 4163-2004 AND INCLUSION CONTENT SHOULD NOT EXCEED FOR A=2 FOR THIN & 0.5 FOR THICK, FOR B = 2 FOR THIN & NIL FOR THICK, FOR C= 2 FOR THIN & NIL FOR THICK, FOR D= 2 FOR THIN AND 0.5 FOR THICK, FOR DS NIL. MACRO ETCH TEST AS PER ASTM-381-84 ACCEPTED STD. C1, R1, S1 FOR PLATE-1 AND NIL FOR PLATE-2, GRAIN SIZE 5 TO 8 ASTM. ALLUMINIUM CONTENTS SHOULD NOT EXCEED TO 0.033% MAX, MATL. SHOULD BE FREE FROM CRACKS, FLAKES, POROSITIES, PITTING, DENDRITIES, ROLLED IN SCALE & SEG REGATION TO LENGTH SIZE 525 MM (± 1.5 MM) FOR BARREL BLANK FOR PAG(PB) AS PER DRG.NO.RFI SK-10419-G, APPD. DT 18.01.2019.

EQUIVALENT SPECN:

1) IS: 9510-06, 1994/2006, CODE-B TABLE-I. 2) IS: 5517-1993, STEEL DESIG 42Cr4 Mo2.

MATERIAL VERIFICATION :-

- i) Verification of Ord. Fy. I / Note & Test Certificate at MIS stage. Drawal of samples from input material as per Specification for Metallurgical testing.
- ii) If GM, Ord. Fy. Is the inspecting officer, -
 - a) Verification of test certificate, I / Note and relevant documents.
 - b) If required, material sample drawn from run of production may be sent to CQA(Met) for metallurgical verification.
- iii) Whether specified material for the component issued to the pipe line of the production.

SURVEILLANCE POINTS :-

SL. NO.	DIMENSION	GAUGE NO.
01	DIA 35 ± 0.5 mm	G.E METHOD / GAUGE
02	LENGTH 525 ± 1.5 mm	G.E METHOD / GAUGE
03	STRAIGHTNESS 0.5 mm	G.E METHOD / GAUGE
04	ROUNDNESS 0.5 mm	G.E METHOD / GAUGE

NOTE :-

- i) All dimensions are in mm.
- ii) Physical properties & other test as per requirement of relevant material specification.
- iii) All test report should be from NABL approved LAB / DGQA approved LAB/ Ordnance Fys. LAB.
- iv) Record of test report with reference to MIS. No. is to be maintained.
- v) ~~Cleanliness tests for Raw Material of the component will be as per col (d) of CQA(SA) Note Sheet No. 1.~~

OTHER INSPECTION PARAMETERS & TESTS :- AS PER SPECIFICATION

PROTECTIVE FINISH :- AS PER SPECIFICATION

HEAT TREATMENT :- 230 HV MAX

REP. OF ODC

HOS/ODC

REP. OF QC (IM)

verified
MU
29/2/19