

QUALITY ASSURANCE PLAN				QAP No: ARDE/QAP(PROV)/JVPC/ PISTOL GRIP AND LOWER BODY ASSEMBLY / 02	
Issue No. 1	Date: 30/11/2010	Revision No. 1	Date: 07/03/2014	Page No. 1 of 2	
Component / Assembly			PIN LEVER CATCH MAGAZINE		

1 Drawing no. : 0204 03 02 02 18 020 00DA

2 Method of Manufacture : Machining

3 Receiving inspection :

3.1 Raw material : Steel to IS: 5517-1993, Gd 55C8 (En-9)

3.2 Tests / Checks and Acceptance Criteria for Raw Material:

Sl. No	Test / Check	Parameter	Acceptance Value
1	Chemical Analysis	Chemical Composition	As per spec.

4 In-Process Inspection : Nil

5 Stage Inspection : Nil

6 Final Inspection :

6.1 Visual Examination : Sample Size -100%

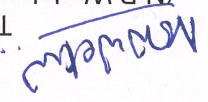
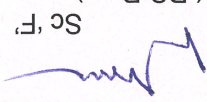
6.1.1 Features for Visual Examination and Acceptance Criteria:

Sl. No	Details of features	Sample Size	Acceptance Criteria
1	Sharp edges, burrs	100%	Not allowed
2	All features like Chamfers , Radius , Undercut etc	100%	To be present

6.2 Dimensional Inspection :

6.3 Critical Dimensions : Nil

6.3.1 Geometrical Features : Nil

Prepared By:  (N B Wadekar)	Recommended By:  (RS Rao)
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6.3.2 Major Dimensions : Sample Size – 100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	11.5	C-3	Vernier Caliper
2.	3.0	C-2	-----//-----
3.	Ø2.5-0.05	D-3	Snap gauge
4.	9.5-0.1	C-3	Vernier caliper
5.	Ø2.0-0.1	D-3	Snap gauge

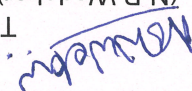
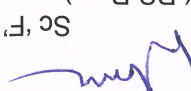
6.3.3 Minor Dimensions : Nil

6.3 Tests on Finished Items :

6.3.1 Details of Tests / Checks on Finished Items and Acceptance Criteria:

Sl. No	Test / Check	Sample Size	Acceptance Values
1	Hardness	10%	300 350 H.V.
2.	Protective Finish	5%	Phosphated to Specification IS:3618 -1966, Class 'B'.

7 Details of tests and other information: Nil

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