

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: 10/04/2014	Page No. 1 of 2
Component / Assembly		PIN AUTO SEAR		

- 1 Drawing no. : 0204 03 02 02 18 017 00DB
- 2 Method of Manufacture : Machining
- 3 Receiving inspection :
- 3.1 Raw material : Steel to IS:9432-1988 Gd 13Ni13Cr3 (En 36-B)
- 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.

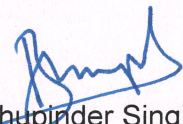
- 4 In-Process Inspection : Nil
- 5 Stage Inspection : Nil
- 6 Final Inspection :
- 6.1 Visual Examination : Sample Size -100%
- 6.1.1 Features for Visual Examination and Acceptance Criteria:

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 :
- 6.2.1 Critical Dimensions : Sample Size – 100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	Ø3.95-0.05	B-3,4	Snap gauge
2.	Ø6.98-0.05	C-3,4	-----//-----

- 6.2.2 Geometrical Features : Nil

Prepared By:  TO 'C' (N B Wadekar)	Recommended By:  Sc 'E' (Bhupinder Singh)
--	---

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: 10/04/2014	Page No. 2 of 2
Component / Assembly		PIN AUTO SEAR		

6.2.3 Major Dimensions : Sample Size – 100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	6.4	B-2	Vernier Caliper
2.	43.0	C-2,3	-----//-----
3.	Ø4.98-0.1	B-4	Snap gauge
4.	4.0-0.05	B-1,2	-----//-----
5.	38.5+0.1	C-2,3	Vernier Caliper
6.	2.1	B-2	-----//-----
7.	1.0	B,C-2	-----//-----

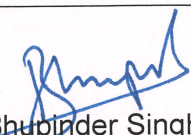
6.2.4 Minor Dimensions : Nil

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 %	500-550 HV
2.	Case Depth	10%	0.13-0.26 mm
2.	Protective Finish	5%	Phosphated to Specification IS: 3618 -1966, Class 'B'.

7 Details of tests and other information: Nil

Prepared By:  TO 'C' (N B Wadekar)	Recommended By:  Sc 'E' (Bhupinder Singh)
--	---