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Sling Assy INSAS Rifle

APPENDIX 'A' TO SPECIFICATION NO. ARDE/SPCN/534(PROVN)

QUALITY ASSURANCE PROVISIONS

VISUAL, DIMENSIONAL AND TEST DEFECTS

ACCEPTANCE QUALITY LEVELS

1. DEFECTS - DEFINITION

1.1 Defect - A defect is non conformance of the unit of product to specified requirements.

1.2 Critical Defect - A critical defect is a defect that judgement and experience indicate is likely to result hazardous or unsafe conditions for individuals using, maintaining or depending upon the product, or a defect that judgement and experience indicate is likely to prevent performance of the technical functions of a major item such as a ship, aircraft, tank, missile or a space vehicle.

1.3 Major Defect - A Major defect is a defect, other than critical that is likely to result in failure or to reduce materially the usability of the unit of the product for its intended purpose.

1.4 Minor Defect - A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose or is a departure from established standards having little bearing on the effective use or operation of the unit.

2. EXAMINATION

2.1 Examination shall be performed as indicated below :-

2.1.1 Critical Defects - One hundred percent examinations shall be performed for critical defects. All sling assy components containing such defects shall be rejected. Similarly a batch or a lot shall be rejected, if it fails in a test classified as critical.

2.1.2 Major and Minor Defects - Examination for major and minor defects shall be performed on a class basis in accordance with classification of rejects applicable sampling plans and acceptance criteria of specification DEF 131A, General Inspection II .

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APPENDIX 'B' TO ARDE/SPCN/554(PROV)

LIST OF DIMENSIONAL CHECK

Sr No.	Component and Drg No.	Zone	Dimension	Remarks
1	HOUSING SLING ARDE SK 3303/1	C-8	7.0 +.1	
		CD-8	0.6	
		D-7	dia 5.0	
2	HOOK ARDE SK 3303/3	D-6	3.5	
3	LOCK HOOK ARDE SK 3303/5	D-8	Dia.2.95	+.05
		E-5/6	2.0	
		C-6	9.0	
		E-6	4.0	
4	LOCK BELT ARDE SK 3303/4	D-2	dia 5.8	
		E-4	2.0	
		E-3	1.2	
		E-4/3	40 deg	
		E-2	25 deg	
5	LINK ARDE SK 3303/11	BC-4	5.0	
6	PIN AXIS LOCK HOOK ARDE SK 3303/6	C-2	dia 2.95	+.05

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3 CLASSIFICATION OF DEFECTS AND ACCEPTABLE QUALITY LEVELS

3.1 The classification of defects and the acceptable quality levels for defects shall be as follows. The AQL listed for each defect shall be applied to the individual defect and not to a group defects.

Component	Defect	AQL percent	Inspection method
NYLON WEBBING (IQV)	Major		
	Dimensions	0.25	Measurement
	Minor		
	i) Fitment with Replica Gauge	0.25	Gauge
	ii) Spring Test	0.25	Practical
	iii) Lock Opening test	0.25	Practical
	iv) Stitching test	0.25	Practical
	v) Hot plate test	0.25	Practical
	vi) Visual observation for colour	0.25	Visual
	vii) weaving defect and stains	0.25	Visual
METALLIC COMPONENTS (IQV)	Major		
	i) Dimensions	0.25	Measurements
	Minor		
	i) Cramp test for spring	0.25	Practical
	ii) Phosphating	0.25	Visual
	iii) Visual observation for cracks, blow holes etc.	0.25	Visual

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APPENDIX 'C' TO ARDE/SPCN/534(PROV)

METHOD AND FIXTURE FOR HOT PLATE TEST(REF.PARA 11.1.7)

1. This test is to be carried out to test Heat Resistance of Nylon Webbing.

1.1 The general arrangement for the test is shown in Fig.below.

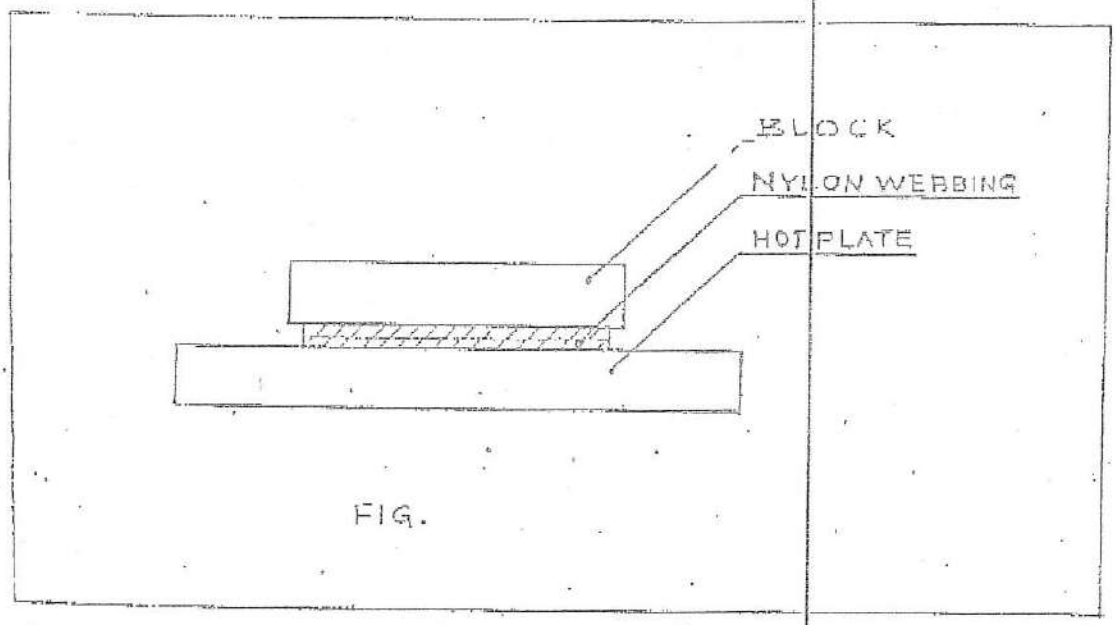

FIG.

1.2 Proceedure

1.2.1 Heat the hot plate to 250 deg c.

1.2.2 Put 50mm length Nylon webbing sample on a hot plate so as the entire surface is in contact with hot plate. A load of 250 g. block having dimensions 50 X 30 X 20 mm should be kept on the webbing sample.

1.2.3 Keep the sample for 20 sec and remove the sample for visual observation.

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