

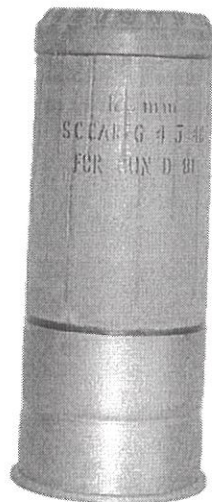
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ACCEPTANCE TEST PROCEDURE(ATP)

FOR

125 mm SCCC (FILLED) (IMPORT)



125 mm

RECORD OF AMENDMENTS.

Issue	Date	Changed By	Change Description

Jc. Rev

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K. Raji

ACCEPTANCE TEST PROCEDURE FOR 125 mm SCCC

1. Introduction.

- (a) SCCC for 125 mm is used with 125 mm ammunition. It is designed to provide extended range, quick, accurate and heavy fire power at every type of terrain.
- (b) Governing documents:
 - (i) Drg No 3-026892 detail 'Cd'
 - (ii) Specification No 848726
 - (iii) CQA(A) Proof Schedule No. CQA(A)/PS/GA/192(h)

2. Sequence of Conduct of Pre Dispatch Inspection: -

- (a) Document Verification. (As per Para 3 below)
- (b) Acceptance Inspection of Packing. (As per Para 4 below)
- (c) Acceptance Inspection of Store. (As per Para 5 below)
- (d) Dynamic proof (All the necessary proof stock and required arrangements related to firing shall be in the scope of Supplier in case dynamic proof is carried out at firm premises).

3. Document Verification. Acceptance documents i.e. Quality Conformance Certificate of end product to be provided along with shop test reports and inspection / Proof reports of the components as applicable.

The following documents and details of inspection / tests conducted by firm to be submitted:

- (a) Quality Conformance Certificate (QCC) of Lot of Semi combustible cartg. Case.
- (b) Acceptance documents of Propellants 12/7 BA and 15/1 TPBA with ACM.
- (c) Acceptance documents and Proof Result of Metallic Base, Primer GUV-7.
- (d) Test Report of TNT, CCC, PC sheet (thickness 0.29mm and 0.52mm), Lead wire, Igniter (Gun powder) Top and bottom and FRC(BTX-20)
- (e) Air Leak Test Report (Before Primer Assy & after primer assy).
- (f) Test Report of Pull off Test of CCC Body & Metallic Base, Resistance of Primer GUV-7 and Mass of Propellant (ACM).
- (g) Acceptance details of Nitromastic special, Glue BØ4, Epoxy Resin, Polyethylene Polyamine, Varnish AC 583, Container 3RK33 and outer package (wooden box).
- (h) Concession / Deviation granted, if any.
- (i) Other documents, Shop test reports and inspection / Proof reports of the components as asked by O.F. Chanda.

Firm shall send required necessary acceptance documents by e-mail after completion of production of lot. After satisfactory verification of documents and obtaining other necessary permissions, O F Chanda will depute PDI team to Supplier premises to carryout PDI.



4. **Acceptance Inspection of Packing at Firm Premises during Pre Dispatch Inspection**

(a) Entire lot to be submitted in packed condition in full qty.

(b) **Details of Packing.**

Item Name	Packing Details
Wooden Box (Drg no. 3-026892 4*40 TYM)	Each box contains 04nos. of Container 3RK33
Container 3RK33 (Drg. No. 3-026892 4* 40 CX)	Each Container contains 01 No 125mm SCCC (Filled)

(c) **Marking / Stenciling** : As per the governing Drg No. CQA(A)/AMN/2800./ Recommended by OEM

(d) **Sampling Plan and AQL** : Single Sampling Plan, General Inspection Level-I for Normal Inspection as per IS 2500 Part - I. AQL 0% for critical, 1.0% for Major and 4.0% for Minor defect.

(e) **Pilot Lot / First Lot** : In case of break in production for more than 01 year, the pilot lot to be manufactured, tested and proved in accordance with governing Proof Schedule No. CQA(A)/PS/GA/192(h). If the firm is producing the SCCC regularly without a break in production of 1 year or more, no pilot lot is required, only a self-certification by the firm is necessary.

(f) **Lot Size** : Firm shall intimate the Lot qty. Lot size shall be from 1000nos. to 15000nos.

(g) **Sample Size and Acceptance Criteria**: Shall be as per IS 2500

(h) **Defect Classification List** :

SI No.	Feature	Defect Classification
<u>Visual Examination.</u>		
(i)	Missing of Container 3RK33 in wooden box	Critical
(ii)	Missing SCCC in Container	Critical
(iii)	Snug fitting of SCCC inside Container	Major
(iv)	Broken / Cracked / Corroded Container	Major
(v)	Incorrect stenciling on Container	Major
(vi)	Stenciling not legible	Minor

SI No.	Feature	Defect Classification
(vii)	Absence of locking and sealing of Container	Minor
(viii)	Peel-off / Chipping of paint.	Minor

5. **Acceptance Inspection of 125mm SCCC (Filled) at Firm Premises during PDI**

- (a) **Sampling Plan and AQL** : Single Sampling Plan, General
Inspection Level-I for Normal Inspection as per IS 2500 Part - I. AQL 0% for critical, 1.0% for Major and 4.0% for Minor defect
- (b) **Lot Size**: Firm shall intimate the Lot qty.
- (c) **Defect Classification List** :

SI No.	Feature	Defect Classification
<u>Visual Examination.</u>		
(i)	Cracked / Broken CCC body, Cover & Ram-Cover.	Major
(ii)	Protrusion of Primer.	Major
(iii)	Crack / corroded / black spots on Metallic Base.	Major
(iv)	Mixing of Primer/Metallic Base lots*	Major
(v)	Incorrect Stenciling on SCCC.	Major
(vi)	Width of folds on CCC Body exceeding 7mm.	Major
(vii)	Stenciling on SCCC not legible.	Minor
<u>Gauging Inspection.</u>		
(i)	Total height of SCCC (H : 408 mm & L : 406mm)	Major
(ii)	Outer profile / Chamber Gauging	Major
(iii)	Intrusion of Primer from face to base(0.1 mm to 0.5 mm)	Major
<u>Tests.</u>		
(i)	Air Leak Test after Primer Assy. Specified Vacuum Pressure 13300Pa for 30 Sec and Pressure variation should not be more than 10% during test. As per drawing no. 3-026892 detail "cd" and specification no. OST-B 84-1958-81	Major

*No mixing of different lots of Primer GUV-7 and Metallic Base allowed in single filled SCCC lot.

6. **Dynamic Proof**

As per mutual agreement between the OFCH and Firm

(a) Dynamic proof to be carried out as per Proof Schedule no. CQA(A)/PS/GA/192(h) at CPE Itarsi (Country : India).

Or

(b) Dynamic proof to be carried out at Firm premises before dispatch of SCCC as per Proof Schedule no. CQA(A)/PS/GA/192(h).

Firm Shall make following arrangements at the time of firing at their own cost.

- i) Conditioning as per referred proof schedule.
- ii) Firing to be carried out with 125mm TK Gun D81 mounted on Tank.
- iii) CCD Camera 02 nos. Duck cloth of appropriate size and video camera shall be arranged as per relevant clause of the proof schedule.
- iv) 2 set of Video recording of each round at Breech End and Muzzle End to be provided in appropriate electronic format.
- v) Complete Video recording of activities at the Proof Range of Dynamic Proof firing to be provided.

7. **Receipt Inspection after receiving of the consignment at OFCH**

(A) **Acceptance Inspection of Packing.**

(a) Entire lot to be submitted in packed condition in full qty.

(b) **Details of Packing.**

Item Name	Packing Details
Wooden Box (Drg no. 3-026892 4*40 TYM)	Each box contains 04nos. of Container 3RK33
Container 3RK33 (Drg. No. 3-026892 4* 40 CX)	Each Container contains 01 No 125mm SCCC (Filled)

(c) **Marking / Stenciling** : As per the governing Drg No. CQA(A)/AMN/2800 or Recommended by OEM

(d) **Sampling Plan and AQL** : Single Sampling Plan, General Inspection Level-II for Normal Inspection as per IS 2500 Part - II. AQL 0% for critical, 1.0% for Major and 4.0% for Minor defect.

(e) **Sample Size and Acceptance Criteria**: Shall be as per IS 2500

(f) **Defect Classification List :**

SI No.	Feature	Defect Classification
<u>Visual Examination.</u>		
(i)	Missing of Container 3RK33 in wooden box	Critical
(ii)	Missing SCCC in Container	Critical
(iii)	Snug fitting of SCCC inside Container	Major
(iv)	Broken / Cracked / Corroded Container	Major
(v)	Incorrect stenciling on Container	Major
(vi)	Stenciling not legible	Minor
(vii)	Absence of locking and sealing of Container	Minor
(viii)	Peel-off / Chipping of paint.	Minor

Point No. (i) and (ii) – if a container or SCCC is missing during JRI, the consignment shall not be rejected at once immediately, but in case of this situation, the complete consignment will be checked and the firm shall be liable for the payment of the missing quantity within stipulated time as mutually agreed and the consignment will be sentenced accepted only after completion of payment formalities by the firm for the missing quantity, subject to condition, there are no other deviations. In case the firm denies or fails to complete the payment formalities within stipulated time as mutually agreed, the consignment will be rejected.

(B) **Acceptance Inspection of 125mm SCCC (Filled)**

- (a) **Sampling Plan and AQL** : Single Sampling Plan, General
Inspection Level-II for Normal Inspection as per IS 2500 Part - I. AQL 0% for critical, 1.0% for Major and 4.0% for Minor defect
- (b) **Lot Size**: Firm shall intimate the Lot qty.. Lot size shall be from 1000 nos. to 15000 nos.
- (c) **Defect Classification List:**

SI No.	Feature	Defect Classification
<u>Visual Examination.</u>		
(i)	Cracked / Broken CCC body, Cover & Ram-Cover.	Major
(ii)	Protrusion of Primer.	Major
(iii)	Crack / corroded / black spots on Metallic Base.	Major

SI No.	Feature	Defect Classification
(iv)	Mixing of Primer/Metallic Base lots*	Major
(v)	Incorrect Stenciling on SCCC.	Major
(vi)	Width of folds on CCC Body exceeding 7mm.	Major
(vii)	Stenciling on SCCC not legible.	Minor
(viii)	Dismantling of one Cartg. Case from entire lot, for verification of presence of requisite components as per applicable specification and drawings.	Critical
<u>Gauging Inspection.</u>		
(i)	Total height of SCCC (H : 408 mm & L : 406mm)	Major
(ii)	Outer profile / Chamber Gauging	Major
(iii)	Intrusion of Primer from face to base (0.1 mm to 0.5 mm)	Major
<u>Tests.</u>		
(i)	Air Leak Test after Primer Assy. Specified Vacuum Pressure 13300Pa for 30 Sec and Pressure variation should not be more than 10% during test.	Major

*No mixing of different lots of Primer GUV-7 and Metallic Base allowed in single filled SCCC lot.



OIC/Unit-V



OIC/QC (Mat)



OIC/QCP & QC(T&G)



OIC/QAP



DO/Unit-V



DO/QC (Mat)



DO/QCP & QC(T&G)



DO/QAP

DGM/AKV



AGM/RKC



GM/AS