

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	064706A-00									OFT/QAP/SRCG/064706A-00
Nomenclature	BODY EXTERNAL WELDED									
Material	As per Assembly Part List.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
Body External Welded (Raw material)	General appearance	Non Critical	Visual	100%	As per Assembly Part List.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
In process - Turning, Milling,Drilling, Reaming, Threading, etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064706A-00	As per Approved Drg No. 064706A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
A dry film lubrication in a fluoropolymer organic resin Class-2, color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064706A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W		
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064706A-00	WELDING PER AWS D1.1 GTAW OR GMAW USING ELECTRODE ER80SD-2 PER AWS A5.28 OR ELECTRODE ER70S-2 PER AWS A5.18. VISUAL INSPECTION.	Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064706A-00	As per Approved Drg No. 064706A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication, Welding and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	064708A-00								
Nomenclature	POINTER : FOR BODY EXTERNAL WELDED (064706A-00)								
Material	ALLOY STEEL PLATE SAE 4130 NORMALIZED PER SAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
POINTER (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL PLATE SAE 4130 NORMALIZED PER SAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - As per approved drg.no. 064707A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064708A-00	As per Approved Drg No. 064708A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064708A-00	As per Approved Drg No. 064708A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	064707A-00								
Nomenclature	BODY EXTERNAL : FOR BODY EXTERNAL WELDED (064706A-00)								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Body External (Raw material)	General appearance	Non Critical	Visual	100%	MATERIAL: ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - As per approved drg.no. 064707A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064707A-00	As per Approved Drg No. 064707A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064707A-00	As per Approved Drg No. 064707A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									