

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	064414A-00								OFT/QAP/SRCG/064414A
Nomenclature	WASHER SPHERICAL								
Material	CRES BAR TYPE 17-4PH PER AMS-5643 .								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by QAE(N), Chennai or by Nominated Agency (Review/Witness)	Remarks
WasherSpherical (Raw material)	General appearance	Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS -5643	CRES BAR TYPE 17-4PH PER AMS -5643	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Milling Drilling.	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064414A-00	As per Approved Drg No. 064414A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation treatment	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064414A-00	PER AMS-QQ-P-35 TYPE II	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Baking	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064414A-00	BAKE PART AFTER PLATING WITHIN 4 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	W	
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064414A-00	As per Approved Drg No.064414A-00	Firm Inspection report	W	
* Note Process audit on passivation treatment, Backing and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									