

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05/06 / 2021
Drg . No.	Y18725A-00								OFT/QAP/SRCG/Y18725A
Nomenclature	COVER, MOTOR								
Material	CRES 316 PER ASTM-A-240								
Component Nomenclature/ operations	Charateristics	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
Cover, Motor (Raw material)	General appearance	Non Critical	Visual	100%	CRES 316 PER ASTM-A-240	CRES 316 PER ASTM-A-240	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.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18725A-00	As per Approved Drg No. Y18725A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment	Dimensions Specified in the Inspection report of the	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	AMS-2700	Method 1, Type-7			
Dry Film Lubrication in a FluoroPolymer Organic Resin Class 2 colour Matt Black Type 1	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18725A-00	5-13 Micron Thick per VS-1-3-1-165 (or equivalent)	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18725A-00	As per Approved Drg No. Y18725A-00	Firm Inspection report	W	
<p>* Note 1. Clause 7.3 indicated in the drawing to be followed. 2. Process audit on Passivation Treatment, Dry Film Lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									