

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06 / 2021
Drg . No.	074811A-00								OFT/QAP/SRCG/074811A
Nomenclature	KEY								
Material	CRES PLATE 17-4PH PER AMS-5604 PURCHASED IN CONDITION H1150.								
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
Key material) (Raw	General appearance	Non Critical	Visual	100%	CRES PLATE 17-4PH PER AMS-5604 PURCHASED IN CONDITION H1150.	CRES PLATE 17-4PH PER AMS-5604 PURCHASED IN CONDITION H1150.	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 - Milling,Drilling, Reaming.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 074811A-00	As per Approved Drg No. 074811A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	Method 1, Type 8	Firm Inspection report	W	
Baking	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 074811A-00	Bake part after plating within 3 hours as per AMS/2759/9 Table 1 for 3 hours Minimum at 191°C.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 074811A-00	As per Approved Drg No. 074811A-00	Firm Inspection report	W	
* Note 1. Process audit on Passivation Treatment, Baking and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									