QUALITY ASSURANCE PLAN (SRCG IM PHASE)	Issue No : 01 Rev No:
	Date of Issue 05 /06 / 2021

Drg . No.	074266A-00	OFT/QAP/SRCG/074266A
Nommenclature	STOPPER	
Material	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150	

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
Stopper (Raw material)	General appearance	Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS -5643 PURCHASED IN CONDITION H1150	CRES BAR TYPE 17-4PH PER AMS -5643 PURCHASED IN CONDITION H1150	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. 074266A-00	As per Approved Drg No. 074266A-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. 074266A-00	PER AMS-2700 METHOD 1 TYPE 8	Firm Inspection report	W	
Baking	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 074266A-00	BAKE PART AFTER PLATING WITIN 3 HOURS PER AMS-2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 C.	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 074266A-00	As per Approved Drg No.074266A-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)