

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 21/05/ 2021
Drg . No.	065289A-00								OFT/QAP/SRCG/065289A
Nomenclature	AXIS 1								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALISED AS PER SAE-AMS-S-6758 OR SAE 4340 NORMALISED AS PER SAE-AMS-S-5000.								
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
Axis 1 (Raw material)	General appearance	Critical	Visual	100%	Alloy Steel Bar Rnd SAE 4130 Normalised as per SAE-AMS-S-6758 OR SAE 4340 Normalised as per SAE-AMS-S-5000.	As per Alloy Steel Bar Rnd SAE 4130 Normalised as per SAE-AMS-S-6758	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	As per Batch		OR SAE 4340 Normalised as per SAE-AMS-S-5000.	Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%		Test report from NABL lab	R		
In process - Facing, Turning, Drilling,	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. 065289A-00	As per Approved Drg No. 065289A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Dry Film Lubrication in a FluoroPolymer Organic Resin Class 2 colour Matte Black Type 1	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065289A-00	5-13 micron thick as per VS-1-3-1-165 (or equivalent).	Firm Inspection report	W	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065289A-00	As per Approved Drg No. 065289A-00	Firm Inspection report	W	
* Note Process audit on Dry Film Lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									