

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 05/06 / 2021
Drg . No.	Y25684A-00								OFT/QAP/SRCG/Y25684A
Nomenclature	COVER FRONT PEDESTAL								
Material	ALUMINUM ALLOY SHEET 5083-H321 PER AMS-QQ-A-250/6 3 MM THICK (FOR REF. ONLY).								
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 Front Pedestal (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY SHEET 5083-H321 PER AMS-QQ-A-250/6 3 MM THICK (FOR REF. ONLY).	ALUMINUM ALLOY SHEET 5083-H321 PER AMS-QQ-A-250/6 3 MM THICK (FOR REF. ONLY).	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, Reamin, Welding	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25684A-00	As per Approved Drg No. Y25684A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	100%	Approved Drg No. Y25684A-00	WELDING PER AWS D1.2 GTAW OR GMAW CLASS B USING ELECTRODE ER5356 PER AWS A5.10 OR EQUIVALENT.	Firm Inspection report	W	
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-A-8625	Type-II, 15to 25 Micron Thick Class-1	Firm Inspection report	R	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	100%	Primer, Intermediate , Top Coat and Seal Welded area shall be carried out as per specification standard in the drawing.		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25684A-00	As per Approved Drg No. Y25684A-00	Firm Inspection report	W	
* Note: 1. Process audit on Anodic Coating,welding, paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									