

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:	
									Date of Issue 21 /05/ 2021	
Drng . No.	062815A-00									OFT/QAP/SRCG/062815A
Nomenclature	SHAFT SPLINE, ELEVATION									
Material	STEEL ALLOY BAR SAE 4130 AS PER SAE-AMS-S-6758 OR SAE 4340 AS PER SAE-AMS-S-5000. (Equivalent Steel permitted after ELBIT approval)									
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	
Shaft Spline, Elevation (Raw material)	General appearance	Critical	Visual	100%	SAE 4130 as per SAE-AMS-S-6758 OR SAE 4340 as per SAE-AMS-S-5000	As per SAE 4130 as per SAE-AMS-S-6758 OR SAE 4340 as per SAE-AMS-S-5000	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Critical	Chemical Lab analysis	As per Batch			Test report from NABL lab	R		
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
In process - Gear cutting,Gear grinding, Turning, Milling,Drilling, Reaming,Threading.	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. 062815A-00	As per Approved Drg No. 062815A-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. 062815A-00	15±5 micron thick as per VS-1-3-1-165 (or equivalent).	Firm Inspection report	W		
Phosphate Coating	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 062815A-00	As per Approved Drg No. 062815A-00	Firm Inspection report	W		
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 062815A-00	As per Approved Drg No. 062815A-00	Firm Inspection report	W		
<p>* Note 1. Clause 7.2 indicated in Drawing to be followed 2. Process audit on Dry Film Lubrication,Phosphating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										