QUALITY ASSURANCE PLAN (SRCG IM PHASE)	Issue No : 01 Rev No:
	Date of Issue 21/05/ 2021

Drg . No.	064331A-00	
Nommenclature	GEAR SECTOR	OFT/QAP/SRCG/064331A
Material	ALLOY STEEL PLATE SAE 4130 AS PER SAE-AMS 6345 OR SAE 4340 AS PER AMS 6359 (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
Gear Sector (Raw material)	General appearance	Critical	Visual	100%	SAE 4130 as per SAE-AMS 6345 OR SAE 4340 as per AMS 6359	As per SAE 4130 as per SAE-AMS 6345 OR SAE 4340 as per AMS 6359	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, Threading.	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. 064331A-00	As per Approved Drg No. 064331A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Magnetic particle inspection, Identificaton of cracks or discontinuties	Mechanical properties	Critical	Mechanical Lab analysis	100%	Approved Drg No. 019789A-00	In accordance with ASTM E 1444-05	Test report from NABL lab	R	
Phosphate Coating	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 064331A-00	As per Type M, Class 2, 0.005-0.010mm Thick as per MIL-DTL-16232	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	Zero Acceptance Number (# ZAN)	Approved Drg No. 064331A-00	As per Approved Drg No. 064331A-00	Firm Inspection report	W	

* **Note** 1. Clause 16 indicated in Drawing to be followed
          2. Process audit on Magnetic particle inspection, Phosphating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)