

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 10 /06/ 2021
Drg . No.	066237A-00								OFT/QAP/SRCG/066756B-00
Nomenclature	HEAD COCKING 1								
Material	As per Assembly Part List.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Head Cocking 1 (Raw material)	General appearance	Non Critical	Visual	100%	Material Specification as per Assembly Part list		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 - Turning, Milling,Drilling, Reaming, Threading etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 066756B-00	As per Approved Drg No. 066756B-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
A dry film lubrication in a fluoropolymer organic resin Class-2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066756B-00, 066615A-00, 066623A-00, 071070A-00.	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W	
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 023367A-01, 023372A-00, 023366A-01.	BLACK-T PER VS-1-3-1-165, CLASS 2 TYPE 1 12-15 MICRON THICK. BAKE PART AFTER PLATING WITHIN 3 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	W	
Cataforetic finish	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066619A-00	Per MIL-DTL-0053084A (MR)	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066756B-00, 066615A-00,		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066756B-00	As per Approved Drg No. 066756B-00	Firm Inspection report	W	

* **Note:** 1. Clause indicated in the drawing to be followed
2. Process audit on Dry film lubrication, Finish, Phosphate coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

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Drg . No.	066756B-00								OFT/QAP/SRCG/066756B-00
Nomenclature	SUPPORT HEAD COCKING : REQD.FOR HEAD COCKING 1 (066237A-00)								
Material	ALLOY STEEL PLATE SAE 4130 NORMALIZED PERSAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Support Head Cocking (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL PLATE SAE 4130 NORMALIZED PERSAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.		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 - As per approved Drg.No.066756B-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 066756B-00	As per Approved Drg No. 066756B-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Heat treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 066756B-00	HEAT TREATMENT TO 35 +-3 HRC PER AMS 2759/1.	Firm Inspection report	W	
A dry film lubrication in a fluoropolymer organic resin Class-2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066756B-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066756B-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066756B-00	As per Approved Drg No. 066756B-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication, and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	023367A-01								OFT/QAP/SRCG/023367A-01
Nomenclature	HOOK : REQD.FOR HEAD COCKING 1 (066237A-00)								
Material	ALLOY SAE 4340 PER AMS 6359.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Hook (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY SAE 4340 PER AMS 6359.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).		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 - As per approved Drg.No.023367A-01	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 023367A-01	As per Approved Drg No. 023367A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Heat treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 023367A-01	HEAT TREATMENT TO 35+-4 HRC PER MIL-H-6875 CLASS A.	Firm Inspection report	W	
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023367A-01	BLACK-T PER VS-1-3-1-165, CLASS 2 TYPE 1 BAKE PART AFTER PLATING WITHIN 3 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 023367A-01		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023367A-01	As per Approved Drg No. 023367A-01	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on finish and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	066615A-00									OFT/QAP/SRCG/066615A-00
Nomenclature	BOLT M8 : REQD.FOR HEAD COCKING 1 (066237A-00)									
Material	ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZEDPER SAE-AMS-S-5000.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
BOLT M8 (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZEDPER SAE-AMS-S-5000.		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 - As per approved Drg.No.066615A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 066615A-00	As per Approved Drg No. 066615A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 066615A-00	HEAT TREATMENT TO 35 +-3 HRC PER AMS 2759/1.	Firm Inspection report	W		
A dry film lubrication in a fluoropolymer organic resin Class-2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066615A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W		
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066615A-00		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066615A-00	As per Approved Drg No. 066615A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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									Rev No:	
									Date of Issue 10 /06 / 2021	
Drg . No.	023372A-00									OFT/QAP/SRCG/023372A-00
Nomenclature	BOLT M4 : REQD.FOR HEAD COCKING 1 (066237A-00)									
Material	STEEL ALLOY SAE 4340 PER SAE-AMS-S-5000.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
BOLT M4 (Raw material)	General appearance	Non Critical	Visual	100%	STEEL ALLOY SAE 4340 PER SAE-AMS-S-5000.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).		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 - As per approved Drg.No.023372A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 023372A-00	As per Approved Drg No. 023372A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Heat treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 023372A-00	HEAT TREATMENT TO 35+ -4 HRC PER MIL-H-6875 CLASS A.	Firm Inspection report	W		
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023372A-00	BLACK-T PER VS-1-3-1-165, CLASS 2 TYPE 1 12-15 MICRON THICK. BAKE PART AFTER PLATING WITHIN 3 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	W		
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 023372A-00		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023372A-00	As per Approved Drg No. 023372A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	023366A-01									OFT/QAP/SRCG/023366A-01
Nomenclature	PUSHER : REQD.FOR HEAD COCKING 1 (066237A-00)									
Material	ALLOY STEEL PLATE SAE 4130 PER SAE-AMS 6345.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL)									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
PUSHER (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL PLATE SAE 4130 PER SAE-AMS 6345.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL)		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 - As per approved Drg.No.023366A-01	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 023366A-01	As per Approved Drg No. 023366A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Heat treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 023366A-01	HEAT TREATMENT TO 35+-4 HRC PER MIL-H-6875 CLASS A.	Firm Inspection report	W		
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023366A-01	BLACK-T PER VS-1-3-1-165, CLASS 2 TYPE 1 12-15 MICRON THICK. BAKE PART AFTER PLATING WITHIN 3 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	W		
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 023366A-01		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 023366A-01	As per Approved Drg No. 023366A-01	Firm Inspection report	W		

* **Note:** 1. Clause indicated in the drawing to be followed
2. Process audit on finish and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

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Drg . No.	066623A-00								OFT/QAP/SRCG/066623A-00
Nomenclature	PLUNGER : REQD.FOR HEAD COCKING 1 (066237A-00)								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Plunger (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.		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 - As per approved Drg.No.066623A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 066623A-00	As per Approved Drg No. 066623A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Heat treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 066623A-00	HEAT TREATMENT TO 35 +-3 HRC PER AMS 2759/1.	Firm Inspection report	W	
A dry film lubrication in a fluoropolymer organic resin Class-2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066623A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 066623A-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066623A-00	As per Approved Drg No. 066623A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
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Drg . No.	071070A-00									OFT/QAP/SRCG/071070A-00
Nomenclature	INSERT : REQD.FOR HEAD COCKING 1 (066237A-00)									
Material	ALLOY STEEL PLATE SAE 4130 NORMALIZED PERSAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
Insert (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL PLATE SAE 4130 NORMALIZED PERSAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.		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 - As per approved Drg.No.071070A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 071070A-00	As per Approved Drg No. 071070A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 071070A-00	HEAT TREATMENT TO 35 +-3 HRC PER AMS 2759/1.	Firm Inspection report	W		
A dry film lubrication in a fluoropolymer organic resin Class-2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 071070A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W		
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Part Drg. No. 071070A-00		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 071070A-00	As per Approved Drg No. 071070A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										