		QUALITY ASSU (SRCG IM			Issue No : 01 Rev No: Date of Issue					
Drg . No.	066237A-00								10 /06/ 2021	
Nomenclature	HEAD COCKING 1								OFT/QAP/SRCG/066756B-00	
Material										
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	
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R		
Head Cocking 1 (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	Material Specification as per Assembly Part list		Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	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 P	Part Drg. No. 066756B-00 066615A-00,	Firm Inspection report	W		
inal 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		

	QUALITY ASSURANCE PLAN (SRCG IM PHASE)											
Drg . No.	rg . No. 066756B-00											
Nomenclature	OFT/QAP/SRCG/066756B-00											
Motorial	ALLOY STEEL PLAT 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			
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Support Head Cocking (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency				
	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				
Heat tretment	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	Firm will be undertaking			
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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted			
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per P	art 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				

2. Process audit on Dry film lubrication, and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)

	QUALITY ASSURANCE PLAN (SRCG IM PHASE) rg . No. 023367A-01											
Drg . No.												
Nomenclature	HOOK : REQD.FOR	HEAD C	OCKING 1 (066237A-0	00)					OFT/QAP/SRCG/023367A-01			
Material	ALLOY SAE 4340 P	ER AMS 6	6359.(EQUIVALENT S	TEEL IS PERMI	ITED AFTER EL	BIT APPROVAL).			<u> </u> !			
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			
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R				
Hook (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis			PER AMS 6359.(EQUIVALENT STEEL FER ELBIT APPROVAL).	Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	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			As per Approved Drg No. 023367A-01	Firm Inspection report	W				
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis			HEAT TREATMENT TO 35+-4 HRC PER MIL-H-6875 CLASS A.	Firm Inspection report	w	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted			
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks		Approved Drg No. 023367A-01	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%		Part Dra No. 022267A 01	Firm Inspection report	W				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks			As per Approved Drg No. 023367A-01	Firm Inspection report	W				

2. Process audit on finish and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)

			Issue No : 01 Rev No: Date of Issue 10/ 06 / 2021						
Drg . No.	066615A-00								
Nomenclature	BOLT M8 : REQD.F	OR HEAD	D COCKING 1 (066237	/A-00)					OFT/QAP/SRCG/066615A-00
Material	ALLOY STEEL BAR	RND SAF	= 4130 NORMALIZED	PER SAE-AMS-	S-6758 OR SAE 4	4340 NORMALIZEDPER SAE-AN	MS-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
	General appearance	Non Critical	Visual	100%	Fi ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZEDPER SAE- AMS-S-5000.		Firm Inspection report	R	
BOLT M8 (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis				Test report - from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	1
In process - As per approved	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%		As per Approved Drg No. 066615A-00	Firm Inspection report	W	
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	••••••	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%	No. 066615A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	w	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Pa	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%	••••••	As per Approved Drg No. 066615A-00	Firm Inspection report	w	]

2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)

			Issue No : 01 Rev No: Date of Issue 10 /06 / 2021							
Drg . No.	023372A-00									
Nomenclature	BOLT M4 : REQD.F	OR HEAD	D COCKING 1 (066237)	/A-00)					OFT/QAP/SRCG/023372A-00	
Material	STEEL ALLOY SAE	4340 PEF	₹ SAE-AMS-S-5000.(E	QUIVALENT ST	EEL IS PERMITT	TED 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)	r Remarks	
	General appearance	Non Critical	Visual	100%	Fi STEEL ALLOY SAE 4340 PER SAE-AMS-S- 5000.(EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).		Firm Inspection report	R		
BOLT M4 (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement		••••••	As per Approved Drg No. 023372A-00	Firm Inspection report	w		
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis		11 5	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		Approved Drg No. 023372A-00	BAKE PART AFTER PLATING WITHIN 3 HOURS PER ASTM B 850 CLASS ER12	Firm Inspection report	w	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Pa	Part Drg. No. 023372A-00	Firm Inspection report	w		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks			As per Approved Drg No. 023372A-00	Firm Inspection report	W		

	QUALITY ASSURANCE PLAN (SRCG IM PHASE) g . No. 023366A-01											
Drg . No.	023366A-01											
Nomenclature	PUSHER : REQD.FC	OR HEAD	OCOCKING 1 (066237)	A-00)					OFT/QAP/SRCG/023366A-01			
Material	ALLOY STEEL PLA	TE SAE 4'	130 PER SAE-AMS 63	45.(EQUIVALE	IT STEEL IS PEF	RMITTED AFTER ELBIT APPRO	)VAL)		]			
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			
	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				
PUSHER (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R				
	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement		Approved Drg No. As per Approved Drg No. 023366A-01 023366A-01		Firm Inspection report	W				
Heat tretment	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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted			
Finish: Black-T and Backing	General appearance	Non Critical	Visual and Dimensional Checks		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			As per Approved Drg No. 023366A-01	Firm Inspection report	W				
	dicated in the drawing audit on finish and T		lowed / of Raw materials to Fir	nal Product (Mar	n,Material,Machin	e and Methods)	· · · ·					

			Issue No : 01 Rev No: Date of Issue 10 /06 / 2021									
Drg . No.	rg.No. 066623A-00											
Nomenclature	omenclature PLUNGER : REQD.FOR HEAD COCKING 1 (066237A-00)											
Material	ALLOY STEEL BAR PER SAE-AMS-S-50	-	E 4130 NORMALIZED	PER SAE-AMS-	3-6758 OR SAE 4	,340 NORMALIZED			OFT/QAP/SRCG/066623A-00			
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	T Remarks			
	General appearance	Non Critical	Visual	100%	<b>!</b>		Firm Inspection report	R				
Plunger (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	SAE-AMS-S-6758 O	ALLOY STEEL BAR RND SAE 4130 NORMALIZEDPER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.		R	Sample will be drawn and sealed by Inspection Agency			
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%				R	]			
In process - As per approved Drg.No.066623A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement			. As per Approved Drg No. 066623A-00	Firm Inspection report	W				
Heat tretment	Mechanical properties	Non Critical	Mechanical Lab analysis			. HEAT TREATMENT TO 35 +-3 HRC PER AMS 2759/1.	Firm Inspection report	w 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	N 25001 AVALU	No. 066623A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	n w				
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Pa	Part Drg. No. 066623A-00	Firm Inspection report	w w	-			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks			. As per Approved Drg No. 066623A-00	Firm Inspection report	w				

Clause indicated in the drawing to be followed
Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)

	QUALITY ASSURANCE PLAN (SRCG IM PHASE)										
Drg . No. 071											
Nomenclature INS	nenclature INSERT : REQD.FOR HEAD COCKING 1 (066237A-00)										
Matorial	LLOY STEEL PLAT MS-6359.	E SAE 41	130 NORMALIZED PE	RSAE-AMS-634	5 OR SAE 4340 N	NORMALIZED PER			OFT/QAP/SRCG/071070A-00		
Component Nomenclature/ Cha operations	haracteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks		
Ger	eneral appearance	Non Critical	Visual	100%			Firm Inspection report	R			
Insert (Raw Che material)	nemical properties	Non Critical	Chemical Lab analysis	100%	ALLOY STEEL PLATE SAE 4130 NORMALIZED PERSAE- AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359.		Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency		
proj	echanical roperties	Non Critical	Mechanical Lab analysis	100%		Test report from NABL lab	R				
In process - As per approved Drg.No.071070A-00	mensions Specified the Inspection port of the omponent	Non Critical	Dimensional measurement			As per Approved Drg No. 071070A-00	Firm Inspection report	W			
Hoat trotmont	echanical operties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%		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	eneral appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	No. 071070A-00	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted		
Phosphate Coating Gen	eneral appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Pa	art Drg. No. 071070A-00	Firm Inspection report	W			
Final Inspection Gen	eneral 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			