

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05/06 / 2021
Drg . No.	Y03741A-00								OFT/QAP/SRCG/Y03741A
Nomenclature	BOLT CALIBRATOR								
Material	CRES ROD 303 PER ASTM-A-582.								
Component Nomenclature/ operations	Characteristics	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
Bolt Calibrator (Raw material)	General appearance	Critical	Visual	100%	CRES ROD 303 PER ASTM-A-582.	CRES ROD 303 PER ASTM-A-582.	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Turning,Threading Milling	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y03741A-00	As per Approved Drg No. Y03741A-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 matt Black	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y03741A-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
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y03741A-00	As per Approved Drg No.Y03741A-00	Firm Inspection report	W	
<p>* Note 1. Clause 6&7 indicated in the drawing to be followed 2.Process audit on a dry film lubrication fluoropolymer organic resin and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									