

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 10/06/ 2021
Drng . No.	Y25683A-00								OFT/QAP/SRCG/Y25683A-00
Nomenclature	ADAPTOR MAGAZINE								
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
Adaptor Magazine (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 - As per Approved Drg No. Y25683A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25683A-00	As per Approved Drg No. Y25683A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25683A-00	WELDING PER AWS D1.2 GTAW OR GMAW CLASS C USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT AFTER WELDING APPLY VISUAL INSPECTION PER ASTM E 1417 TYPE1 LEVEL-3	Firm Inspection report	W	
Passivation Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	Method-1, Type 7	Firm Inspection report	W	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Itermediate, Top Coat shall be carried out as per Approved Drg No. Y25683A-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. Y25683A-00	As per Approved Drg No. Y25683A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Passivation Treatment, Paint 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.	Y18768A-00									OFT/QAP/SRCG/Y18768A-00
Nomenclature	ADAPTOR,PLATE,WELD : REQD.FOR ADAPTOR MAGAZINE (Y25683A-00)									
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	
Adaptor Plate,Weld (Raw material)	General appearance	Non Critical	Visual	100%	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 - As per Approved Drg No. Y18768A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18768A-00	As per Approved Drg No. Y18768A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18768A-00	WELDING PER AWS D1.2 GTAW OR GMAW CLASS C USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT AFTER WELDING APPLY VISUAL INSPECTION PER ASTM E 1417 TYPE1 LEVEL-3	Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18768A-00	As per Approved Drg No. Y18768A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Passivation Treatment, Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	Y18769A-00									OFT/QAP/SRCG/Y18769A-00
Nomenclature	PLATE,MAGAZINE : REQD.FOR ADAPTOR, PLATE,WELD (Y18768A-00)									
Material	CRES SHEET THICK 10 MM TYPE 316L per ASTM-A-240									
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	
Plate,Magazine (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 10 MM TYPE 316L per ASTM-A-240		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. Y18769A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18769A-00	As per Approved Drg No. Y18769A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18769A-00	As per Approved Drg No. Y18769A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on 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.	Y18882A-00									OFT/QAP/SRCG/Y18882A-00
Nomenclature	SPACER,PLATE,SHORT : REQD.FOR ADAPTOR, PLATE,WELD (Y18768A-00)									
Material	CRES BAR TYPE 316L PER ASTM-A-276.									
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	
Spacer, Plate,Long (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 316L PER ASTM-A-276.		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. Y18882A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18882A-00	As per Approved Drg No. Y18882A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18882A-00	As per Approved Drg No. Y18882A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	Y18935A-00								
Nomenclature	BOSS,M10,PLATE : REQD.FOR ADAPTOR, PLATE,WELD (Y18768A-00)								
Material	CRES BAR TYPE 316L PER ASTM-A-276.								
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
Boss,M10, Plate, (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 316L PER ASTM-A-276.		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. Y18935A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18935A-00	As per Approved Drg No. Y18935A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18935A-00	As per Approved Drg No. Y18935A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y18885A-00									OFT/QAP/SRCG/Y18885A-00
Nomenclature	SPACER,PLATE,LONG : REQD.FOR ADAPTOR, PLATE,WELD (Y18768A-00)									
Material	CRES BAR TYPE 316L PER ASTM-A-276.									
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	
Spacer, Plate,Long (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 316L PER ASTM-A-276.		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. Y18885A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18885A-00	As per Approved Drg No. Y18885A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18885A-00	As per Approved Drg No. Y18885A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										