

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	062361A-00								OFT/QAP/SRCG/062361A
Nomenclature	ANGLE LIMITER, RIGHT								
Material	STEEL ALLOY PLATE SAE 4130 PER SAE-AMS 6345 OR SAE 4340 PER AMS 6359								
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
Angle Limiter,Right (Raw material)	General appearance	Critical	Visual	100%	STEEL ALLOY PLATE SAE 4130 PER SAE-AMS 6345 OR SAE 4340 PER AMS 6359	STEEL ALLOY PLATE SAE 4130 PER SAE-AMS 6345 OR SAE 4340 PER AMS 6359	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 - Milling,Drilling,Reaming	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 062361A-00	As per Approved Drg No. 062361A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Phosphate Coating	General appearance	Critical	Visual and Dimensional Checks	100%	MIL-DTL-16232	TYPE M, Class 2 005-0.010 MM THICK	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. 062361A-00	As per Approved Drg No.062361A-00	Firm Inspection report	W	
* Note Process audit on Phosphate coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									