Issue No: 01 Rev No: **QUALITY ASSURANCE PLAN** (SRCG IM PHASE) Date of Issue 10 /06/ 2021 Drg. No. Y18784A-00 Nomenclature CAP ASSY OFT/QAP/SRCG/Y18784A-00 Material As per Assembly Part List. Component Quantum of Reference Format of Inspection by GM/OFT Nomenclature/ Characteristics Class Type of check Acceptance norms Remarks (Review/Witness) check document record operations Firm Inspection Non General appearance Visual 100% R Critical report Sample will be drawn Test report Cap Assy Non and sealed by Chemical properties Chemical Lab analysis 100% Material Specification as per Assembly Part list from R (Raw material) Critical Inspection Agency NABL lab Test report Mechanical Non Mechanical Lab 100% from R properties Critical analysis NABL lab In process -**Dimensions Specified** Turning, in the Inspection Non IS 2500 Level II Approved Drg No. As per Approved Drg No. Firm Inspection Dimensional Milling, Drilling, W report of the Critical measurement AQL 2.5% Y18784A-00 Y18784A-00 report Reaming, Knurling component etc., A dry film lubrication in a fluoropolymer TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR Non Visual and IS 2500 Level II Approved Drg No organic resin General appearance R Critical **Dimensional Checks** AQL 2.5% Y18784A-00 report Solvent Color Black EQUIVALENT). Firm will be undertaking Class-2 100 % Checks and (for Y18744A-00) Pre inspection Report for the same be submitted ON ONE SIDE OF THE PART APPLY PRESSURE Adhesive Non Mechanical Lab SENSITIVE ADHESIVE 3M 467MP. THE Firm Inspection 100% R General appearance (for Y18747A-00) Critical PROTECTIVE LINER SHALL COVER THE ENTIRE analysis report SIDE OF THE ADHESIVE. Firm Inspection Non Visual and IS 2500 Level II Approved Drg No. As per Approved Drg No. Final Inspection General appearance W Critical **Dimensional Checks** AQL 2.5% Y18784A-00 Y18784A-00 report

Note: 1. Clause indicated in the drawing to be followed

^{2.} Process audit on Dry film lubrication, Adhesive 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.	Y18744A-00								
Nomenclature	CAP,GUN LOCK : R	OFT/QAP/SRCG/Y18744A-00							
Material	CRES 316 PER AST								
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
Cap, Gun Lock (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%	CRES 31	6 PER ASTM-A-240.	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. Y18744A-00	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. Y18744A-00	Firm Inspection report	W	
A dry film lubrication in a fluoropolymer organic resin Solvent Color Black Class-2	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%		TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	R	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. Y18744A-00	As per Approved Drg No. Y18744A-00	Firm Inspection report	W	

^{*} Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication, Adhesive 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.	Y18747A-00		OFT/QAP/SRCG/Y18747A-00						
Nomenclature	CAP,SEAL : REQD								
Matarial	NEOPRENE RUBBE EO34 F17 Z1 Z2 Z3								
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
Cap, Seal (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	
	Chemical properties	Non Critical	Chemical Lab analysis	100%	721 A1	ER PER ASTM D2000 M3 BC 14 B14 C12 EO14 F17 Z1 Z2 Z3 Z4.	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. Y18747A-00	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. Y18747A-00	Firm Inspection report	W	
Adhesive	General appearance	Non Critical	Mechanical Lab analysis	100%	ON ONE SIDE OF THE PART APPLY PRESSURE SENSITIVE ADHESIVE 3M 467MP . THE PROTECTIVE LINER SHALL COVER THE ENTIRE SIDE OF THE ADHESIVE.		Firm Inspection report	R	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%		As per Approved Drg No. Y18747A-00	Firm Inspection report	W	

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