

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 10 /06/ 2021
Drg . No.	Y18784A-00								OFT/QAP/SRCG/Y18784A-00
Nomenclature	CAP ASSY								
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
Cap Assy (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 - Turning, Milling, Drilling, Reaming, Knurling etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18784A-00	As per Approved Drg No. Y18784A-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 Solvent Color Black Class-2 (for Y18744A-00)	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18784A-00	TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	R	
Adhesive (for Y18747A-00)	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	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18784A-00	As per Approved Drg No. Y18784A-00	Firm Inspection report	W	
<p>* 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)</p>									

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Drg . No.	Y18744A-00								OFT/QAP/SRCG/Y18744A-00
Nomenclature	CAP,GUN LOCK : REQD FOR CAP ASSY(Y18784A-00)								
Material	CRES 316 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
Cap, Gun Lock (Raw material)	General appearance	Non Critical	Visual	100%	CRES 316 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. Y18744A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18744A-00	As per Approved Drg No. Y18744A-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 Solvent Color Black Class-2	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18744A-00	TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	R	
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	
<p>* 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)</p>									

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Drg . No.	Y18747A-00								OFT/QAP/SRCG/Y18747A-00
Nomenclature	CAP,SEAL : REQD FOR CAP ASSY(Y18784A-00)								
Material	NEOPRENE RUBBER PER ASTM D2000 M3 BC 721 A14 B14 C12 EO14 EO34 F17 Z1 Z2 Z3 Z4.								
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%	NEOPRENE RUBBER PER ASTM D2000 M3 BC 721 A14 B14 C12 EO14 EO34 F17 Z1 Z2 Z3 Z4.		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. Y18747A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18747A-00	As per Approved Drg No. Y18747A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18747A-00	As per Approved Drg No. Y18747A-00	Firm Inspection report	W	
<p>* 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)</p>									