

(Doc. No.: QAP/OFDC/ Flexible Drive Adaptor TU-450)

QUALITY ASSURANCE PLAN

- 1.0 Nomenclature : **FLEXIBLE DRIVE ADAPTOR**
- 2.0 Drg. No. & Det. No. : ARDE 2121; Det. No.-52 Sht. No.- 3
- 3.0 Nature of Item : **Non – Critical**
- 4.0 Inspecting Officer
 - (a) Raw Material : **G.M., O.F.D.C.**
 - (b) Advance Sample : **Authorised AQAW (A), if applicable.**
 - (c) Bulk : **G.M., O.F.D.C.**
- 5.0 Method of Manufacture : **Machining**
- 6.0 Raw Material : **Steel to IS: 2004 Class – 2/2A Normalised Condition Or
IS: 226 Fe 410 – S**
- 7.0 Tests / Checks and Acceptance Criteria of Raw Material:

Sl. No.	Tests / Checks	As per Specn	Acceptance
1	Chemical Composition & Mechanical Properties	IS : 2004 Class – 2 (Normalised condition), 1978	<u>Chemical Composition : (%)</u> C:0.15 to 0.25, Si : 0.15 to 0.35, P : 0.05 (max),S: 0.05 (max.),Mn: 0.60 to 0.90 <u>Mechanical Properties :</u> Tensile strength :- 430 N/mm ² (min.) Yield strength :- 230 N/mm ² (min) Elongation % :- 24 (min.) (5.65V _{So}) Hardness : 120 BHN (min.) Normalizing Temp.: (880-910)°C
		IS : 2004 Class – 2A (Normalised Condition), 1978	<u>Chemical Composition : (%)</u> C:0.20 to 0.30, Si : 0.15 to 0.35, P : 0.05 (max),S: 0.05 (max.),Mn: 0.60 to 0.90 <u>Mechanical Properties :</u> Tensile strength :- 460 N/mm ² (min.) Yield strength :- 250 N.mm ² (min) Elongation % :- 22 (min.) (5.65V _{So}) Hardness : 130 BHN (min.) Normalizing Temp.: (880-910)°C
		IS : 226 Fe 410 – S, 1975	<u>Chemical Composition : (%) (Max.)</u> C:0.3 , P : 0.055 ,S: 0.055 <u>Mechanical Properties :</u> Tensile strength :- 410 - 530 N/mm ² Yield strength :- 230 N/mm ² (min) Elongation % :- 23 (min.) (5.65V _{So})

Note : Raw material should be tested from NABL / Govt. lab.

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8.0 Inspection:

8.1 Visual Inspection:

Sl. No.	Features	Sample Size	Acceptance Criteria
1	Sharp Edges & Burrs	100%	Not Allowed
2	Tool Marks/Scratches	100%	Not Allowed

8.2 Dimensional Inspection:

Sl. No.	Dimensions / Features	Nature	Sample Size	Inspection Method
1	$\varnothing 88.0 \pm 0.3$	Minor	10%	Gauge
2	1 X 45°			GE
3	14.0			
4	9.0			
5	$\varnothing 64.5 -0.5$	Major		Gauge
6	7°	Minor		GE
7	72.0 ± 0.3			Gauge
8	M56 X 2 – 6H to IS:4218	Critical		100%

Note : 1. Sample size (for inspection) may vary at the discretion of Inspecting Authority.

2. Gauges as per Gauge Schedule No. **G.S/26/41**.

3. Gauges calibration report / certificate to be submitted.


9.0 Tests / Checks on Finished Items & Acceptance Criteria :

Sl. No.	Details of Feature	Sample Size	Acceptance Criteria
1	Phosphating to IS : 3618 Class - B	Base material test coupon for every Batch	Coating Weight : 4.3 g/m ²

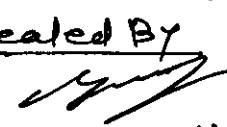
Note: Testing (Phosphating) to be done from NABL accredited/Govt. Lab.

Dated:


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