

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
<b>Drg . No.</b>	Y28656A-00								<b>OFT/QAP/SRCG/Y28656A</b>
<b>Nomenclature</b>	WRENCH								
<b>Material</b>	ALLOY STEEL PLATE SAE 4130 NORMALIZED PER SAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359								
<b>Component Nomenclature/ operations</b>	<b>Charateristics</b>	<b>Class</b>	<b>Type of check</b>	<b>Quantum of check</b>	<b>Reference document</b>	<b>Acceptance norms</b>	<b>Format of record</b>	<b>Inspection by QAE(N), Chennai or by Nominated Agency (Review/Witness)</b>	<b>Remarks</b>
Wrench (Raw material)	General appearance	Non Critical	Visual	100%	ALLOY STEEL PLATE SAE 4130 NORMALIZED PER SAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359	ALLOY STEEL PLATE SAE 4130 NORMALIZED PER SAE-AMS-6345 OR SAE 4340 NORMALIZED PER AMS-6359	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 - Milling,Drilling, Reaming	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y28656A-00	As per Approved Drg No. Y28656A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Dry Film Lubrication in a FluoroPolymer Organic Resin Class 2 colour Matte Black Type 1	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y28656A-00	5-25 Micron Thick per VS-1-3-1-165 (or equivalent)	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y28656A-00	As per Approved Drg No. Y28656A-00	Firm Inspection report	W	
<b>* Note</b> 1. Clause 7 indicated in Drawing to be followed 2. Process audit on Dry Film Lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									