

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 21/05/ 2021
Drg . No.	Y05288A-01								OFT/QAP/SRCG/Y05288A
Nomenclature	PUSHER TRIGGER								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALISED AS PER SAE-AMS-S-6758 OR SAE 4340 NORMALISED AS PER SAE-AMS-S-5000.								
Component Nomenclature/ operations	Charateristics	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
Pusher Trigger (Raw material)	General appearance	Critical	Visual	100%	Alloy Steel Bar Rnd SAE 4130 Normalised as per SAE-AMS-S-6758 OR SAE 4340 Normalised as per SAE-AMS-S-5000.	As per Alloy Steel Bar Rnd SAE 4130 Normalised as per SAE-AMS-S-6758 OR SAE 4340 Normalised as per SAE-AMS-S-5000.	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	As per Batch			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Facing, Milling , Turning	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. Y05288A-01	As per Approved Drg No. Y05288A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Phosphate Mangnese Coating as per MIL-DTL-16232 TYPE M CLASS 2	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y05288A-01	5-10 Micron Thick with Lubricante Oil as per MIL-PRF-16173 Grade 3 OR MIL-PRF-3150.	Firm Inspection report	W	
Baking	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y05288A-01	Bake part after plating within 3 hours as per MIL-DTL-16232 Table 1 for 8 hours at 98°C to 107°C.	Firm Inspection report	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y05288A-01	As per Approved Drg No. Y05288A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted

* **Note** Process audit on Phosphate Mangnese Coating, Baking and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)