

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06 / 2021
Drg . No.	062358A-00								
Nomenclature	BUMPER ARM								
Material	Aluminium Alloy Plate 6061-T6 PER SAE AMS-QQ-A-250/11 (or) T651								
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
Bumper Arm (Raw material)	General appearance	Non Critical	Visual	100%	Aluminium Alloy Plate 6061-T6 PER SAE AMS-QQ-A-250/11 (or) T651	Aluminium Alloy Plate 6061-T6 PER SAE AMS-QQ-A-250/11 (or) T651	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. 062358A-00	As per Approved Drg No. 062358A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chromatic Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-DTL-5541F	Type II, Class 3.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 062358A-00	As per Approved Drg No. 062358A-00	Firm Inspection report	W	
* Note: Process audit on Chromatic Conversion coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									