QUALITY ASSURANCE PLAN (SRCG IM PHASE)		Issue No : 01 Rev No:
		Date of Issue 08 /06 / 2021

Drg . No.	**065281A-00**	
Nomenclature	**COVER SOLENOID 1**	**OFT/QAP/SRCG/065281A-00**
Material	**ALUMINIUM ALLOY PLATE 6061-T651 PER AMS-QQ-A-250/11**	

Component Nomenclature/ operations	Characteristics	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
Cover Solenoid 1 (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINIUM ALLOY PLATE 6061-T651 PER AMS-QQ-A-250/11		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, Threading etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 065281A-00	As per Approved Drg No. 065281A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chemical Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-DTL-5541F	Type I Class 3.	Firm Inspection report	R	
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-A-8625	Type-II, 20 ± 5 Micron Thick Class-2, color black #37038 per FED-STD-595	Firm Inspection report	R	
Primer Epoxy	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-P-53022		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 065281A-00	As per Approved Drg No. 065281A-00	Firm Inspection report	W	

* **Note:**   1. Clause 7.3,8, indicated in the drawing to be followed
   2. Process audit on Chemical Conversion coating, Anodic Coating, Primer Epoxy and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)