

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	066427A-00								OFT/QAP/SRCG/066427A
Nomenclature	SLEEVE LIMITER								
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
Sleeve Limiter (Raw material)	General appearance	Non 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	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	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 066427A-00	As per Approved Drg No. 066427A-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. 066427A-00	5-13 Micron Thick per VS-1-3-1-165 (or equivalent)	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066427A-00	Approved Drg No. 066427A-00	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 066427A-00	As per Approved Drg No. 066427A-00	Firm Inspection report	W	
<p>* Note 1. Clause 8.1 indicated in Drawing to be followed 2. Process audit on Dry Film Lubrication,Phosphating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									