	Issue No : 01 Rev No: Date of Issue 10/06/ 2021								
Drg . No.	OFT/QAP/SRCG/077915A-00								
Nomenclature									
Material	ALLOY STEEL BAR								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Pin Locking Front 1 (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	
	Chemical properties	Non Critical	Chemical Lab analysis	100%	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE- AMS-S-5000		Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - as per Approved Drg No. 077915A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 077915A-00		Firm Inspection report	W	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	AMS 2759/1	35 ± 3 HRC	Firm Inspection report	W	
A dry film lubrication in a fluoropolymer organic resin Class- 2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).		Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077915A-00	As per Approved Drg No. 077915A-00	Firm Inspection report	W	

Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

	Issue No : 01 Rev No: Date of Issue 10/06/ 2021								
Drg . No.	OFT/QAP/SRCG/077910A-00								
Nomenclature									
Material	ALLOY STEEL BAR								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Nut Special 1 (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	
	Chemical properties	Non Critical	Chemical Lab analysis	100%	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000		Test report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - as per Approved Drg No. 077910A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 077910A-00		Firm Inspection report	W	
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	AMS 2759/1	35 ± 3 HRC	Firm Inspection report	w	
A dry film lubrication in a fluoropolymer organic resin Class- 2 Color matte black	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	TYPE I, 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).		Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077910A-00	As per Approved Drg No. 077910A-00	Firm Inspection report	W	

Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

Issue No: 01 Rev No: **QUALITY ASSURANCE PLAN** (SRCG IM PHASE) Date of Issue 10 /06 / 2021 077905A-00 Drg . No. HANDLE FRONT 1 : FOR PIN FRONT 1 ASSY (077901A-00) Nomenclature OFT/QAP/SRCG/077905A-00 Material CRES ROD 303 PER ASTM-A-582. Component Inspection by GM/OFT Quantum of Reference Format of Nomenclature/ Characteristics Class Type of check Acceptance norms Remarks (Review/Witness) check document record operations Non Firm Inspection General appearance Visual 100% R Critical report Sample will be drawn Test report Handle Front 1 Non CRES ROD 303 PER ASTM-A-582. and sealed by Chemical properties Chemical Lab analysis 100% from R (Raw material) Critical Inspection Agency NABL lab Test report Mechanical Non Mechanical Lab 100% R from properties Critical analysis NABL lab Dimensions Specified In process - as per in the Inspection Non Dimensional IS 2500 Level II Firm Inspection Approved Drg No. Approved Drg No. 077905A-00 W Critical AQL 2.5% report of the measurement report 077905A-00 component A dry film lubrication in a IS 2500 Level II Non Visual and TYPE I, 5-13 MICRON Firm Inspection fluoropolymer General appearance W Critical **Dimensional Checks** AQL 2.5% THICK PER VS-1-3-1-165 (OR EQUIVALENT). report Firm will be undertaking organic resin Class-100 % Checks and 2 Color matte black Pre inspection Report for the same be submitted Non Visual and IS 2500 Level II Firm Inspection Phosphate Coating General appearance Approved Drg No. 077905A-00 W Dimensional Checks AQL 2.5% Critical report Visual and IS 2500 Level II Approved Drg As per Approved Drg No. Non Firm Inspection Final Inspection General appearance W Dimensional Checks No. 077905A-00 Critical AQL 2.5% 077905A-00 report

^{*} Note: 1. Clause indicated in the drawing to be followed

^{2.} Process audit on Dry film lubrication, Phosphate Coating and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)