

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	077915A-00								
Nomenclature	PIN LOCKING FRONT 1 : FOR PIN FRONT 1 ASSY (077901A-00)								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000								
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%	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED 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 - 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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
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	
<p>* 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)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	077910A-00								
Nomenclature	NUT SPECIAL 1 : FOR PIN FRONT 1 ASSY (077901A-00)								
Material	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000								
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%	ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED 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 - 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	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
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	
<p>* 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)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue
									10 /06 / 2021
Drg . No.	077905A-00								
Nomenclature	HANDLE FRONT 1 : FOR PIN FRONT 1 ASSY (077901A-00)								
Material	CRES ROD 303 PER ASTM-A-582.								
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
Handle Front 1 (Raw material)	General appearance	Non Critical	Visual	100%	CRES ROD 303 PER ASTM-A-582.		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 - as per Approved Drg No. 077905A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 077905A-00		Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
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	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077905A-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. 077905A-00	As per Approved Drg No. 077905A-00	Firm Inspection report	W	
<p>* 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)</p>									