

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05/06 / 2021
Drg . No.	Y00852A-01								OFT/QAP/SRCG/Y00852A
Nomenclature	BUSHING FOREWARD								
Material	COPPER ALLOY BAR 51000 H02 / H04 PER ASTM-B-139								
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
Bushing Forward (Raw material)	General appearance	Non Critical	Visual	100%	COPPER ALLOY BAR 51000 H02 / H04 PER ASTM-B-139	COPPER ALLOY BAR 51000 H02 / H04 PER ASTM-B-139	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.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00852A-01	As per Approved Drg No. Y00852A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Black Chemical Finish	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00852A-01	MIL-F-495 E	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00852A-01	As per Approved Drg No. Y00852A-01	Firm Inspection report	W	
<p>* <b>Note</b> 1. Clause 6, 7, 8.2 indicated in the drawing to be followed. 2. Process audit on Black Chemical Finish and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									