

**QUALITY ASSURANCE PLAN
(SRCG IM PHASE)**

Issue No : 01
Rev No:
Date of Issue
08/06/2021

Drig. No.	Y19388A-00											
Nomenclature	FRAME_BASKET_WELD										OFT/QAP/SRCG/Y19388A-00	
Material	As per Assembly Part List.											
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			
												General appearance
Frame, Basket, Weld (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	Material Specification as per Assembly Part list	As per Approved Drig No. Y19388A-00	Firm inspection report from NABL lab	R	Sample will be drawn and sealed by Inspection Agency			
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%								
In process - Milling, Drilling, Reaming, Threading, Bending, Forming etc.,	Dimensions Specified in the inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drig No. Y19388A-00	As per Approved Drig No. Y19388A-00	Firm inspection report	W				
A dry film lubrication in a fluoropolymer organic resin Solvent Color black Class-2.	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drig No. Y19388A-00	TYPE 1, 30-40 MICRON THICK PER V5-1-3-1-165 (OR EQUIVALENT).	Firm inspection report	W				
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drig No. Y19388A-00	WELDING PER AWS D1.1 GTAW OR GMAW USING ELECTRODE ER308L PER AWS A5.9, JIG IF NEEDED. (OR EQUIVALENT. (REMOVE ALL WELDING RESIDUALS)	Firm inspection report	W				
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drig No. Y19388A-00	As per Approved Drig No. Y19388A-00	Firm inspection report	W				

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

Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted