

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
									Rev No:	
									Date of Issue 10 /06 / 2021	
Drg . No.	Y18506A-00									OFT/QAP/SRCG/Y18506A-00
Nomenclature	CABLE ASSY, WPKS12B									
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 GM/OFT (Review/Witness)	Remarks	
Cable Assy, WPKS12B (Raw material)	General appearance	Non Critical	Visual	100%	Material Specification as per Assembly Part list		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 Drawing No. Y18506A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%		As per Approved Drg No. Y18506A-00	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%		As per Approved Drg No. Y18506A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	031518D-03								
Nomenclature	ADAPTOR D38999-III-15-05 : REQD.FOR CABLE ASSY,WPKS12B (Y18506A-00)								
Material	ALUM. ROD 6061-T6 PER AMS-QQ-A-225/8								
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
ADAPTOR D38999-III-15-05 (Raw material)	General appearance	Non Critical	Visual	100%	ALUM. ROD 6061-T6 PER AMS-QQ-A-225/8		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 Drawing No. 031518D-03/031518D-TB	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	As per Approved Drg No. 031518D-03		Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Zinc Coating	General appearance	Non Critical	Visual and Dimensional checks	IS 2500 Level II AQL 2.5%	OVER ELECTROLESS NICKEL	ELECTROLESS NICKEL CLASS 3 GRADE B, 13 MICRON THICK PER MIL-C-26074 ZINC COATING ELECTRODEPOSITED TYPE II ,COLOR BLACK, CLASS 3 (OR SC2), 8 MICRON THICK PER ASTM B 633.	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	As per Approved Drg No. 031518D-03		Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Zinc coatingand 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.	031518E-03								
Nomenclature	ADAPTOR D38999-III-17-05 : REQD.FOR CABLE ASSY,WPKS12B (Y18506A-00)								
Material	ROD 6061-T6 PER AMS-QQ-A-225/8								
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
ADAPTOR D38999-III-17-05 (Raw material)	General appearance	Non Critical	Visual	100%	ROD 6061-T6 PER AMS-QQ-A-225/8		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 Drawing No. 031518E-03/031518E-TB	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%		As per Approved Drg No. 031518E-03	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Zinc Coating	General appearance	Non Critical	Visual and Dimensional checks	IS 2500 Level II AQL 2.5%	OVER ELECTROLESS NICKEL	ELECTROLESS NICKEL CLASS 3 GRADE B, 13 MICRON THICK PER MIL-C-26074 ZINC COATING ELECTRODEPOSITED TYPE II ,COLOR BLACK, CLASS 3 (OR SC2), 8 MICRON THICK PER ASTM B 633.	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%		As per Approved Drg No. 031518E-03	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Zinc coatingand Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									