

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drng . No.	Y25649A-01								
Nomenclature	COVER,BLIND,POD,FINISHED								
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
Cover,Blind,Pod, Finished (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 - Milling,Drilling, Reaming, Threading, etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drng No. Y25649A-01	As per Approved Drng No. Y25649A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drng No. Y25649A-01	WELDING PER AWS D1.2 GTAW (VISUAL INSPECTION).	Firm Inspection report	W	
Chromatic Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-5541F	Type-1, Class-3	Firm Inspection report	W	
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-A-8625	Type-2, 15-25 Micron Thick Class-1	Firm Inspection report	W	
Epoxy Primer	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	SAE MA 1567 per MIL-P-53022		Firm Inspection report	W	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Itermediate, Top Coat shall be carried out as per Approved Drng No. Y25649A-01		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drng No. Y25649A-01	As per Approved Drng No. Y25649A-01	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed  2. Process audit on Welding, Chromatic Conversion Coating, Anodic Coating, Epoxy Primer, Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
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Drg . No.	065445A-00								OFT/QAP/SRCG/065445A-00
Nomenclature	COVER BLIND, POD WELDED : FOR COVER,BLIND,POD,FINISHED (065445A-00)								
Material	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11								
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
Cover Blind,Pod, Welded (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11		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. 065445A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 065445A-00	As per Approved Drg No. 065445A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 065445A-00	WELDING PER AWS D1.2 GTAW (VISUAL INSPECTION).	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 065445A-00	As per Approved Drg No. 065445A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Welding Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
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Drg . No.	065446A-00								OFT/QAP/SRCG/065446A-00
Nomenclature	PLATE 2, BLIND COVER, POD : FOR COVER BLIND, POD WELDED (065445A-00)								
Material	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11								
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
Plate 2, Blind cover, Pod (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11		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. 065446A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 065446A-00	As per Approved Drg No. 065446A-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%	Approved Drg No. 065446A-00	As per Approved Drg No. 065446A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 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.	065447A-00								OFT/QAP/SRCG/065447A-00
Nomenclature	BLOCK, BLIND COVER, POD : FOR COVER BLIND, POD WELDED (065445A-00)								
Material	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11								
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
Block, Blind cover, Pod (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINIUM ALLOY PLATE 6061-T651 PER QQ-A-250/11		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. 065447A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 065447A-00	As per Approved Drg No. 065447A-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%	Approved Drg No. 065447A-00	As per Approved Drg No. 065447A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 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>									