	QUALITY ASSURANCE PLAN (SRCG IM PHASE)	Issue No : 01 Rev No:
		Date of Issue 05/06/ 2021
Drg . No.	**077851A-00**	
Nommenclature	**BUSHING THREAD FRONT 1**	**OFT/QAP/SRCG/077851A**
Material	**CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.**	

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
Bushing Thread Front 1 (Raw material)	General appearance	Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Turning , ,Drilling, Reaming,Threading	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 077851A-00	As per Approved Drg No. 077851A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation treatment	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077851A-00	PER AMS-2700 METHOD 1 TYPE 8.	Firm Inspection report	W	
Baking	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077851A-00	Bake part after plating within 3 hours as per AMS-2759/9 Table 1 for 3 hours minimum at 191°C.	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077851A-00	As per Approved Drg No.077851A-00	Firm Inspection report	W	

* **Note**   Process audit on passivation treatment, Backing and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)