

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 21 /05 2021
Drg . No.	Y17321A-00								OFT/QAP/SRCG/Y17321A
Nomenclature	CRADLE BASE								
Material	Aluminium Alloy Plate (6061-T651, SAE AMS-QQ-A-250/11)								
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
Cradle Base (Raw material)	General appearance	Critical	Visual	100%	6061-T651, SAE AMS-QQ-A-250/11	As per 6061-T651, SAE AMS-QQ-A-250/11	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	As per Batch			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Milling,Drilling, Tapping	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. Y17321A-00	Approved Drg No. Y17321A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chemical Conversion Coating	General appearance	Critical	Visual and Dimensional Checks	100%	MIL-DTL-5541F Type I Class 3.	As per MIL-DTL-5541F Type I Class 3.	Firm Inspection report	R	
Anodic coating	General appearance	Critical	Visual and Dimensional Checks	100%	MIL-A-8625 Type II, 15 to 25 micron thick class 1.	As per MIL-A-8625 Type II, 15 to 25 micron thick class 1.	Firm Inspection report	R	
Dry Film Lubrication in a FluoroPolymer Organic Resin Solvent colour Black Class I Type 2	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y17321A-00	25-35 micron thick as per VS-1-3-1-165 (or equivalent).	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	Zero Acceptance Number (# ZAN)	Approved Drg No. Y17321A-00	As per Approved Drg No. Y17321A-00	Firm Inspection report	W	

* **Note** 1. Clause 7.4 and 7.5 indicated in Drawing to be followed
2. Process audit on Dry Film Lubrication, Anodic Coating,Chemical Conversion and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)