

| QUALITY ASSURANCE PLAN (SRCG IM PHASE) | | | | | | | | | Issue No : 01 Rev No: |
|--|---|--------------|-------------------------------|---------------------------|---|--|---------------------------|---|---|
| | | | | | | | | | Date of Issue 05/06 / 2021 |
| Drg . No. | 075150A-00 | | | | | | | | OFT/QAP/SRCG/075150A |
| Nomenclature | LIMITER EXTERNAL | | | | | | | | |
| Material | ALLOY STEEL BAR RND SAE 4130 AS PER SAE-AMS-S-6758 OR SAE 4340 AS PER SAE-AMS-S-5000. | | | | | | | | |
| 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 |
| Limiter External (Raw material) | General appearance | Non Critical | Visual | 100% | Alloy Steel Bar SAE 4130 as per SAE-AMS-S-6758 OR SAE 4340 as per SAE-AMS-S-5000. | Alloy Steel Bar SAE 4130 as per SAE-AMS-S-6758 OR SAE 4340 as per SAE-AMS-S-5000. | 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. | Dimensions Specified in the Inspection report of the component | Non Critical | Dimensional measurement | IS 2500 Level II AQL 2.5% | Approved Drg No. 075150A-00 | As per Approved Drg No. 075150A-00 | Firm Inspection report | W | Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted |
| Dry Film Lubrication in a FluoroPolymer Organic Resin Solvent Color Black Class 2 Type 1 | General appearance | Critical | Visual and Dimensional Checks | IS 2500 Level II AQL 2.5% | Approved Drg No. 075150A-00 | 15 ± 5 Micron Thick | Firm Inspection report | W | |
| Baking | General appearance | Critical | Visual and Dimensional Checks | IS 2500 Level II AQL 2.5% | Approved Drg No. 075150A-00 | Bake part after plating within 3 hours as per MIL-DTL-16232 Table 1 for 8 hours 98°C to 107°C. | Firm Inspection report | R | |
| Final Inspection | General appearance | Non Critical | Visual and Dimensional Checks | IS 2500 Level II AQL 2.5% | Approved Drg No. 075150A-00 | As per Approved Drg No. 075150A-00 | Firm Inspection report | W | |
| * Note 1. Process audit on Dry Film Lubrication, Baking and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods) | | | | | | | | | |