

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 10 /06 / 2021
Drg . No.	064391A-01								OFT/QAP/SRCG/064391A-01
Nomenclature	BRACKET ASSY 1								
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
Bracket Assy 1 (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 - Turning, 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 Drg No. 064391A-01	As per Approved Drg No. 064391A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment (for 062341A-00)	General appearance	Non Critical	Visual and Dimensional Checks	100%	AMS-2700	Method 1, Type 8	Firm Inspection report	R	
Baking (for 062341A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064391A-01	BAKE PART AFTER PLATING WITIN 3 HOURS PER AMS-2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 C.	Firm Inspection report	R	
Phosphate Coating (for 062339A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-16232	Type M, Class-2, 0.005-0.010mm.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064391A-01	As per Approved Drg No. 064391A-01	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment, baking, Phosphate Coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	062341A-00								OFT/QAP/SRCG/062341A-00
Nomenclature	SHAFT, BELLEVILLE : FOR BRACKET ASSY 1 (064391A-01)								
Material	CRES BAR TYPE 17-4PH PER AMS 5643.								
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
Shaft, Belleville (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS 5643.		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. 062341A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 062341A-00	As per Approved Drg No. 062341A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment	General appearance	Non Critical	Visual and Dimensional Checks	100%	AMS-2700	Method 1, Type 8	Firm Inspection report	R	
Baking	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 062341A-00	BAKE PART AFTER PLATING WITHIN 3 HOURS PER AMS-2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 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. 062341A-00	As per Approved Drg No. 062341A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment, baking and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	062339A-00								OFT/QAP/SRCG/062339A-00
Nomenclature	BRACKET, BELLEVILLE : FOR BRACKET ASSY 1 (064391A-01)								
Material	STEEL ALLOY BAR SAE 4130 PER SAE-AMS-S-6758 OR SAE 4340 PER SAE-AMS-S-5000.								
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
Bracket, Belleville (Raw material)	General appearance	Non Critical	Visual	100%	STEEL ALLOY BAR SAE 4130 PER SAE-AMS-S-6758 OR SAE 4340 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 - As per Approved Drg No. 062339A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 062339A-00	As per Approved Drg No. 062339A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Heat Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 062339A-00	QUENCH AND TEMPER ENTIRE PART; HARDNESS 35± 4 HRC.	Firm Inspection report	W	
Phosphate Coating (for 062339A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-16232	Type M, Class-2, 0.005-0.010mm.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 062339A-00	As per Approved Drg No. 062339A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Phosphate Coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									