

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 05 /06 2021
Drg . No.	Y25645A-00								
Nomenclature	SECTOR BACK COVER FNSH								
Material	ALUMINIUM ALLOY SAND CASTING A356.0 T6. PER ASTM B26M								
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
Sector Back Cover FNSH (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINIUM ALLOY SAND CASTING A356.0 T6. PER ASTM B26M	ALUMINIUM ALLOY SAND CASTING A356.0 T6. PER ASTM B26M	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. Y25645A-00	As per Approved Drg No. Y25645A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chromatic Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-DTL-5541F	Type I Class 3.	Firm Inspection report	R	
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-A-8625	Type-II, 15to 25 Micron Thick Class-1	Firm Inspection report	R	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	100%	Primer , Intermediate, Top Coat as per specification standard in the drawing.		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25645A-00	As per Approved Drg No. Y25645A-00	Firm Inspection report	W	
<p>* Note: 1. Clause 6,7,3,8.4,8.5,11 indicated in the drawing to be followed 2. Process audit on Chromatic Conversion coating, Anodic Coating, Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									