

QUALITY ASSURANCE PLAN				GAP No: ARDE/QAP(PROV)/JVPC/BODY	
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Component / Assembly			LOOP SLING FRONT		

1 Drawing no. : 0204 03 02 37 39 002 00DB

2 Method of Manufacture : Machining

3 Receiving inspection :

3.1 Raw material : Steel to IS:5517-1993, Gd-40C8 (En-8)

3.2 Tests / Checks and Acceptance Criteria for Raw Material:

Sl. No	Test / Check	Parameter	Acceptance Value
1	Chemical Analysis	Chemical Composition	As per spec.

4 In-Process Inspection : Nil

5 Stage Inspection : Nil

6 Final Inspection :

6.1 Visual Examination : Sample Size -100%

6.1.1 Features for Visual Examination and Acceptance Criteria:

Sl. No	Details of features	Sample Size	Acceptance Criteria
1	Sharp edges, burrs	100%	Not allowed

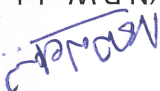
6.2 Dimensional Inspection :

6.2.1 Critical Dimensions : Nil

6.2.2 Geometrical Features : Nil

6.2.3 Major Dimensions : Sample Size - 100%

Sl. No	Dimension / Feature	Drawing Zone	Inspection Method
1.	Ø4.45±0.05	B-4	Micrometer
2.	Ø8.45	B-3	Micrometer
3.	Ø15.0	B-2,3	Micrometer
4.	15.0±0.05	B,C-4	Trimos

Prepared By:  (N B Wadekar)	Recommended By:  (RS Rao)
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QUALITY ASSURANCE PLAN			QAP No: ARDE/QAP(PROV)/JVPC/BODY HOUSING UPPER ASSEMBLY/ 01		
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6.2.4 Minor Dimensions : Nil

6.3 Tests on Finished Items :

6.3.1 Details of Tests / Checks on Finished Items and Acceptance Criteria:

Sl. No	Test / Check	Sample Size	Acceptance Values
1.	Protective Finish	5%	Phosphated to Specification IS: 3618 -1966, Class 'B'.

7 Details of tests and other information: Nil

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