

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 05/06/ 2021
Drq . No.	031682A-00								OFT/QAP/SRCG/031682A
Nomenclature	INSERT M4, ALTERED ITEM								
Material	ALUMINUM ALLOY BAR 6061-T651 PER AMS-QQ-A-225/8.								
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
Insert M4, Altered Item (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY BAR 6061-T651 PER AMS-QQ-A-225/8.	ALUMINUM ALLOY BAR 6061-T651 PER AMS-QQ-A-225/8.	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, Drilling, Reaming.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drq No. 031682A-00	As per Approved Drq No. 031682A-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-5541	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-2, Color Black	Firm Inspection report	R	
Primer Epoxy	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-P-53022		Firm Inspection report		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drq No. 031682A-00	As per Approved Drq No. 031682A-00	Firm Inspection report	W	
<p>* Note: 1. Clause 5.2, 6 indicated in the drawing to be followed 2. Process audit on Chromatic Conversion coating, Anodic Coating, Paint,Primer Epoxy and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									