

QAP No: EFA/DDO/QAP/V46-6/ 6211051000	Date: 18.07-2020
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<b><u>ENGINE FACTORY AVADI</u></b>	
QAP No: EFA/DDO/QAP/ (V46-6 Engine)/(LF No. 6211051000)	Date: 18.07.2020
Revision No	Initial
Item LF	6211051000
Supersedes Previous QAP dated	NIL
Item Description	PISTON WITH RING DRAWING NO. SB 3304- 01- 8

1. The item is required in assembly of high-power diesel engine V46-6 manufactured by EFA.
2. The Quality Requirements are mentioned in relevant drawings and associated technical literature (process sheets and TY specification wherever applicable). The item to comply fully with mentioned requirement.
3. Supplier to thoroughly go through all assembly drawings, associated component drawings and technical literature (process sheets and TY specification wherever applicable) before undertaking manufacture.
4. The supplier will carry out all requisite inspection checks at their end before offering the items for inspection to EFA. While carrying out testing, the supplier to adhere to AQLs for respective components or operations. Pre-Inspection Report as per inspection points indicated in process sheets and QAP to be forwarded to EFA prior to inspection call.
5. The manufacturing methodology of parts/ components/forgings/ castings to be in conformity with specification and process sheets shared. Any abrupt change in manufacturing sequence or technique for critical operation is not permitted. Similarly, abrupt change in sources for critical raw materials and bought out items is not permitted. The source for bought out items of the supplier once approved by EFA cannot be changed without approval of EFA.
6. Castings and Forgings are to be manufactured as per process sheets shared by EFA.
7. In case of new vendor supplying item for first time, three stage inspection will be carried out i.e. Raw Material Stage, Component Stage and Finished/ Assembly Stage.

8. In case of established suppliers where item is regularly being supplied and there are no rejections, exemption of stage inspection may be considered based on performance.
9. In case of new suppliers, at tender stage itself they are required to study all drawings, process sheets and other technical literature to ensure they have requisite facilities and access to specified materials.
10. While offering to EFA, supplier is required to carry out their own inspection for all parameters of specification as indicated in the drawings and process sheets. The checked components by firm should be separately marked on packing for easy identification and cross checking at EFA. Supplier will also scan all documents and email the scanned copy of their inspection/ test report in PDF format to EFA for uploading on NQDBMS system of EFA.
11. Item to be properly packed to make it suitable for long storage without deterioration. Packing to ensure that parts are adequately protected for damage during transportation and protected against deterioration during storage.
12. Alternate materials for manufacture of parts, wherever already approved by EFA/ CQA(HV)/ CQA(MET) can be used citing the authority and enclosing copy of authority. In the absence of permission for alternate materials, the specified materials only are to be used.
13. Based on technical detail, firm will make their own Quality Plan mentioning detailed sequence of operations, inspection check points, instrumentation used for assuring quality of parts/ components. Established firms supplying the particular item regularly to EFA and where there are no rejections, will submit their Quality Plan with inspection checks carried out to EFA while offering for inspection. New firms supplying the particular item for the first order and also established firms whose recent consignments have been rejected, will submit their Quality Plan with inspection checks planned to EFA for approval prior to commencement of manufacture of the item.

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Approved by-

		
GO/DDO	DO/DDO	HOS/DDO