

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	081102A-00								OFT/QAP/SRCG/081102A
Nomenclature	BRACKET SOLENOID								
Material	Aluminium Alloy Plate 6061-T651 PER SAE AMS-QQ-A-250/11.								
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
Bracket Solenoid (Raw material)	General appearance	Non Critical	Visual	100%	Aluminium Alloy Plate 6061-T651 PER SAE AMS-QQ-A-250/11	Aluminium Alloy Plate 6061-T651 PER SAE AMS-QQ-A-250/11	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, Threading.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 081102A-00	As per Approved Drg No. 081102A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chemical 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-III with PTFE, 50± 5 Micron Thick Class-2, Color black #37038 per FED-STD-595	Firm Inspection report	R	
Primer Epoxy	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-P-53022		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 081102A-00	As per Approved Drg No. 081102A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause 7.3,8 indicated in the drawing to be followed  2. Process audit on Chemical Conversion coating, Anodic Coating, Primer Expxy and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									