

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y19376A-00									OFT/QAP/SRCG/Y19376A-00
Nomenclature	BRACKET,BASKET,LEFT,WELD									
Material	As per Assembly Part List.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
Bracket, Basket,Left, weld (Raw material)	General appearance	Non Critical	Visual	100%	Material Specification as per Assembly Part list		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 Bending, Forming etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y19376A-00	As per Approved Drg No. Y19376A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
A dry film lubrication in a fluoropolymer organic resin Solvent Color black Class-2.	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y19376A-00	TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W		
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y19376A-00	WELDING PER AWS D1.1 GTAW OR GMAW USING ELECTRODE ER308L PER AWS A5.9 (OR) EQUIVALENT. (REMOVE ALL WELDING RESIDUALS)	Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y19376A-00	As per Approved Drg No. Y19376A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication, Welding and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										