

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 08 / 06 / 2021
Drg . No.	Y25686A-00								OFT/QAP/SRCG/Y25686A-00
Nomenclature	ARM COVER RIGHT								
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 QAE(N), Chennai or by Nominated Agency (Review/Witness)	Remarks
Arm Cove Right (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, 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. Y25686A-00	As per Approved Drg No. Y25686A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25686A-00	WELDING PER AWS D1.2 GTAW OR GMAW CLASS C USING ELECTRODE ER5356 PER AWS A5.10 OR EQUIVALENT AFTER WELDING APPLY VISUAL INSPECTION.	Firm Inspection report	W	
Chromatic Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-5541F	Type-1, Class-3	Firm Inspection report	W	
Primer	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-PRF-23377	Type-1, Class-C2	Firm Inspection report	W	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Intermediate, Top Coat shall be carried out as per Approved Drg No. Y25686A-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25686A-00	As per Approved Drg No. Y25686A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Chromatic Conversion Coating, Primer, Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									