

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/ 06/ 2021
Drg . No.	080780A-00								
Nomenclature	INLET ASSY								
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
Inlet Assy (Raw material)	General appearance	Non Critical	Visual	100%	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. 080780A-00	As per Approved Drg No. 080780A-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. 080780A-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. 080780A-00	WELDING PER AWS D1.1 GTAW OR GMAW USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT AFTER WELDING APPLY VISUAL INSPECTION	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 080780A-00	As per Approved Drg No. 080780A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 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>									

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Drg . No.	Y17233A-00								
Nomenclature	BASE INLET : FOR INLET ASSY (080780A-00)								
Material	3mm CRES SHEET 316L PER ASTM-A-240.								
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
Base Inlet (Raw material)	General appearance	Non Critical	Visual	100%	3mm CRES SHEET 316L PER ASTM-A-240.	As per Approved Drg No. Y17233A-00	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. Y17233A-00	As per Approved Drg No. Y17233A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17233A-00	As per Approved Drg No. Y17233A-00	Firm Inspection report	W	
<p><b>* Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y17264A-00								OFT/QAP/SRCG/Y17264A-00
Nomenclature	GUSSET BASE : FOR INLET ASSY (080780A-00)								
Material	4mm CRES SHEET 316L PER ASTM-A-240.								
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
Gusset Base (Raw material)	General appearance	Non Critical	Visual	100%	4mm CRES SHEET 316L PER ASTM-A-240.		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, 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. Y17264A-00	As per Approved Drg No. Y17264A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17264A-00	As per Approved Drg No. Y17264A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y17257A-00								OFT/QAP/SRCG/Y17257A-00
Nomenclature	SHEE 1, INLET : FOR INLET ASSY (080780A-00)								
Material	1.5mm CRES SHEET 316L PER ASTM-A-240.								
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
Sheet 1, Inlet (Raw material)	General appearance	Non Critical	Visual	100%	1.5mm CRES SHEET 316L PER ASTM-A-240.	As per Approved Drg No. Y17257A-00	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, 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. Y17257A-00	As per Approved Drg No. Y17257A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17257A-00	As per Approved Drg No. Y17257A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y18682A-00								OFT/QAP/SRCG/Y18682A-00
Nomenclature	SHEE 2, INLET : FOR INLET ASSY (080780A-00)								
Material	1.5mm CRES SHEET 316L PER ASTM-A-240.								
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
Sheet 2, Inlet (Raw material)	General appearance	Non Critical	Visual	100%	1.5mm CRES SHEET 316L PER ASTM-A-240.	As per Approved Drg No. Y18682A-00	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, 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. Y18682A-00	As per Approved Drg No. Y18682A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18682A-00	As per Approved Drg No. Y18682A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y17255A-00									OFT/QAP/SRCG/Y17255A-00
Nomenclature	SHEE 3, INLET : FOR INLET ASSY (080780A-00)									
Material	1.5mm CRES SHEET 316L PER ASTM-A-240.									
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	
Sheet 3, Inlet (Raw material)	General appearance	Non Critical	Visual	100%	1.5mm CRES SHEET 316L PER ASTM-A-240.	As per Approved Drg No. Y17255A-00	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, 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. Y17255A-00	As per Approved Drg No. Y17255A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17255A-00	As per Approved Drg No. Y17255A-00	Firm Inspection report	W		
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	Y17231A-00								OFT/QAP/SRCG/Y17231A-00
Nomenclature	SHEE 4, INLET : FOR INLET ASSY (080780A-00)								
Material	1.5mm CRES SHEET 316L PER ASTM-A-240.								
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
Sheet 4, Inlet (Raw material)	General appearance	Non Critical	Visual	100%	1.5mm CRES SHEET 316L PER ASTM-A-240.	As per Approved Drg No. Y17231A-00	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, 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. Y17231A-00	As per Approved Drg No. Y17231A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17231A-00	As per Approved Drg No. Y17231A-00	Firm Inspection report	W	
<p>* <b>Note:</b> 1. Clause indicated in the drawing to be followed 2. Process audit on Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									