QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 05 /06 / 2021
Drg . No.	**Y17478A-00**								**OFT/QAP/SRCG/Y17478A**
Nommenclature	**BASE LIMITER**								
Material	**CARBON STEEL PLATE SAE 1020 PER ASTM A827.**								
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**
Base Limiter (Raw material)	General appearance	Non Critical	Visual	100%	ACARBON STEEL PLATE SAE 1020 PER ASTM A827.	CARBON STEEL PLATE SAE 1020 PER ASTM A827.	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. Y17478A-00	As per Approved Drg No. Y17478A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Dry Film Lubrication in a FluoroPolymer Organic Resin Class 2 colour Matt Black Type 1	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17478A-00	5-13 Micron Thick per VS-1-3-1-165 (or equivalent)	Firm Inspection report	W	
Phosphate Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17478A-00	Approved Drg No. Y17478A-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. Y17478A-00	As per Approved Drg No. Y17478A-00	Firm Inspection report	W	

* **Note** 1. Clause 6,8.1,11 indicated in Drawing to be followed
2. Process audit on Dry Film Lubrication,Phosphating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)