

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 21/05/ 2021
Drg . No.	065286A-00								OFT/QAP/SRCG/065286A
Nomenclature	BASE BLOCK								
Material	ALLOY STEEL PLATE SAE 4130 NORMALISED AS PER SAE-AMS-6345 OR SAE 4340 NORMALISED AS PER AMS-6359.								
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 Block (Raw material)	General appearance	Critical	Visual	100%	Alloy Steel plate SAE 4130 Normalised as per SAE-AMS-6345 OR SAE 4340 Normalised as per AMS-6359.	As per Alloy Steel plate SAE 4130	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	As per Batch		Normalised as per SAE-AMS-6345 OR	Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%		SAE 4340 Normalised as per AMS-6359.	Test report from NABL lab	R	
In process - Milling,Drilling, Grinding, Reaming,Threading	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. 065286A-00	As per Approved Drg No. 065286A-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 Matte Black Type 1	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065286A-00	5-13 micron thick as per VS-1-3-1-165 (or equivalent).	Firm Inspection report	W	
Phosphate Coating	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065286A-00	As per Approved Drg No. 065286A-00	Firm Inspection report	W	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065286A-00	As per Approved Drg No. 065286A-00	Firm Inspection report	W	
<p>* Note 1. Clause 8.1 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)</p>									