

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05/06 / 2021
Drg . No.	Y00964A-00								
Nomenclature	SCREW SHANK								
Material	CRES BAR RND TYPE 303 PER ASTM-A-582.								
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
Screw Shank material) (Raw	General appearance	Critical	Visual	100%	CRES BAR RND TYPE 303 PER ASTM-A-582.	CRES BAR RND TYPE 303 PER ASTM-A-582.	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Turning, Threading, Milling	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00964A-00	As per Approved Drg No. Y00964A-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 Solvent color Black #37038.	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00964A-00	CLASS 2 TYPE I; 8-12 MICRON THICK PER VS-1-3-165 (OR EQUIVALENT).	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y00964A-00	As per Approved Drg No. Y00964A-00	Firm Inspection report	W	
<p>* Note 1. Clause 6.1 indicated in the drawing to be followed 2. Process audit on Dry film lubrication and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)</p>									