

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No: Date of Issue 10 /06 / 2021
Drng . No.	Y17631A-00								OFT/QAP/SRCG/Y17631A-00
Nomenclature	SLIDER LINKS M9 WELDMENT								
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
Slider Links M9 Weldment (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, Forming, etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drng No. Y17631A-00	As per Approved Drng No. Y17631A-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 Drng No. Y17631A-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 Drng No. Y17631A-00	WELDING PER AWS D1.1 GTAW USING ELECTRODE ER308L PER AWS A5.9.	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drng No. Y17631A-00	As per Approved Drng No. Y17631A-00	Firm Inspection report	W	
<p>* Note: 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>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
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Drg . No.	Y17653A-00								
Nomenclature	SLIDER LINKS M9 : FOR SLIDER LINKS M9 WELDMENT (Y17631A-00)								
Material	1.5MM CRES PLATE 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
Slider Links M9 (Raw material)	General appearance	Non Critical	Visual	100%	1.5MM CRES PLATE 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 - As per Approved Drg No. Y17653A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17653A-00	As per Approved Drg No. Y17653A-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. Y17653A-00	As per Approved Drg No. Y17653A-00	Firm Inspection report	W	

* **Note:** 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)

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Drg . No.	Y17654A-00								
Nomenclature	ARM LINKS M9 : FOR SLIDER LINKS M9 WELDMENT (Y17631A-00)								
Material	CRES SHEET 316L, 3 MM THICK, 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
Arm Links M9 (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET 316L, 3 MM THICK, 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 - As per Approved Drg No. Y17654A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17654A-00	As per Approved Drg No. Y17654A-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. Y17654A-00	As per Approved Drg No. Y17654A-00	Firm Inspection report	W	
<p>* Note: 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>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
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Drg . No.	Y18607A-00								
Nomenclature	RIB 1, ARM LINKS : FOR SLIDER LINKS M9 WELDMENT (Y17631A-00)								
Material	CRES SHEET 316L, 2.5 MM THICK, 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
RIB 1, ARM LINKS (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET 316L, 2.5 MM THICK, 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 - As per Approved Drg No. Y18607A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18607A-00	As per Approved Drg No. Y18607A-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. Y18607A-00	As per Approved Drg No. Y18607A-00	Firm Inspection report	W	
<p>* Note: 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.	Y18610A-00								OFT/QAP/SRCG/Y18610A-00
Nomenclature	RIB 2, ARM LINKS : FOR SLIDER LINKS M9 WELDMNT (Y17631A-00)								
Material	CRES SHEET 316L, 2.5 MM THICK, 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
RIB 2, ARM LINKS (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET 316L, 2.5 MM THICK, 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 - As per Approved Drg No. Y18610A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18610A-00	As per Approved Drg No. Y18610A-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. Y18610A-00	As per Approved Drg No. Y18610A-00	Firm Inspection report	W	
<p>* Note: 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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Drng . No.	Y18705A-00								OFT/QAP/SRCG/Y18705A-00
Nomenclature	PLATE COVER : FOR SLIDER LINKS M9 WELDMENT (Y17631A-00)								
Material	CRES SHEET 316L, 1.5 MM THICK, 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
Plate, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET 316L, 1.5 MM THICK, 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 - As per Approved Drg No. Y18705A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18705A-00	As per Approved Drg No. Y18705A-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. Y18705A-00	As per Approved Drg No. Y18705A-00	Firm Inspection report	W	
<p>* Note: 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>									