

(Doc. No.: QAP/OFDC/Flexible Drive Adaptor TU-1111)

QUALITY ASSURANCE PLAN

- 1.0 Nomenclature : **FLEXIBLE DRIVE ADAPTOR**
- 2.0 Drg. No. & Det. No. : ARDE 2139; Det. No.-57 Sht. No. : 3
- 3.0 Nature of Item : **Non – Critical**
- 4.0 Inspecting Officer
- (a) Raw Material : **G.M., O.F.D.C.**
- (b) Advance Sample : **Authorised AQAW (A), if applicable.**
- (c) Bulk : **G.M., O.F.D.C.**
- 5.0 Method of Manufacture : **Machining**
- 6.0 Raw Material : **Steel to IS : 2004 Class – 2 / 2A Normalised Condition**
- Or IS : 226 Fe 410 - S
- 7.0 Tests / Checks and Acceptance Criteria of Raw Material:

Sl. No.	Tests / Checks	As per Specn	Acceptance
1	Chemical Composition & Mechanical Properties	IS : 2004 Class – 2 (Normalised condition), 1978	Chemical Composition : (%) C:0.15 to 0.25, Si : 0.15 to 0.35, P : 0.05 (max),S: 0.05 (max.),Mn: 0.60 to 0.90 Mechanical Properties : Tensile strength :- 430 N/mm ² (min.) Yield strength :- 230 N/mm ² (min) Elongation % :- 24 (min.) (5.65V _{So}) Hardness :- 120 BHN(Min.) Normalising Temp.:- (880-910) °C
		IS : 2004 Class – 2A (Normalised Condition), 1978	Chemical Composition : (%) C:0.20 to 0.30, Si : 0.15 to 0.35, P :- 0.05 (max),S: 0.05 (max.),Mn: 0.60 to 0.90 Mechanical Properties : Tensile strength :- 460 MPa(min.) Yield strength :- 250MPa (min) Elongation % :- 22 (min.) (5.65V _{So}) Hardness :- 130 BHN (Min.) Normalising Temp.:- (880-910)°C
		IS : 226 Fe 410 – S, 1975	Chemical Composition : (%) (Max.) C:0.23 , P : 0.055 ,S: 0.055 Mechanical Properties : Tensile strength :- 410 - 530 N/mm ² Yield strength :- 250 N/mm ² (min) Elongation % :- 23 (min.) (5.65V _S)

Note: Raw material should be tested from NABL / Govt. lab.

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8.0 Inspection:

8.1 Visual Inspection:

Sl. No.	Features	Sample Size	Acceptance Criteria
1	Sharp Edges & Burrs	100%	Not Allowed
2	Tool Marks/Scratches	100%	Not Allowed

8.2 Dimensional Inspection:

Sl. No.	Dimensions / Features	Nature	Sample Size	Inspection Method
1	Ø75.0	Major	10%	GE
2	15°			
3	1 X 45° (2 Features)	Minor		
4	Ø64.5 -0.5	Major		
5	9.0	Minor		
6	14.0			
View A-A				
7	M 56 X 2 – 6H to IS:4218,Pt-V	Critical	100%	Gauge
8	1.5 X 45°(2 Features)	Minor	10%	GE

Note: 1. Sample size (for inspection) may vary at the discretion of Inspecting Authority.




2. Gauges as per Gauge Schedule No. **Not Available.**


9.0 Tests Checks on Finished Items & Acceptance Criteria :

Sl. No.	Details of Feature	Sample Size	Acceptance Criteria
1	Phosphated to IS : 3618 CI – B	Base material test Coupon for every Batch	Coating Weight : 4.3 g/m ²

Note: Testing (Phosphating) to be done from NABL accredited/Govt. Lab

Dated :

 Prepared By **Amitava, CM(T)**
 Checked By **S. Shaw, JWM/DC**
 Approved By **Raj Kishore, DGM/RD**

 Authenticated By
Sealed By 
RD, RCMA(AA)
22 May 2015