

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	020054A-00								OFT/QAP/SRCG/020054A
Nomenclature	BOLT CENTERING								
Material	STEEL ALLOY SAE 4340 AS PER SAE-AMS-S-5000.								
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
Bolt Centering (Raw material)	General appearance	Non Critical	Visual	100%	Steel Alloy SAE 4340 as per SAE-AMS-S-5000.	Steel Alloy SAE 4340 as per SAE-AMS-S-5000.	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. 020054A-00	As per Approved Drg No. 020054A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Phosphate Coating Type M,Class 2, 0.005-0.010mm thick	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 020054A-00	as per MIL-DTL-16232	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 020054A-00	As per Approved Drg No. 020054A-00	Firm Inspection report	W	
* Note 1. Process audit on Phosphating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									