

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 05 /06/ 2021
Drg . No.	077853A-00								
Nomenclature	BUSHING THREAD REAR 1								
Material	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.								
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
Bushing Thread Rear 1 (Raw material)	General appearance	Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.	CRES BAR TYPE 17-4PH PER AMS-5643 PURCHASED IN CONDITION H1150.	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 ,Milling ,Drilling, Reaming,Threading	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 077853A-00	As per Approved Drg No. 077853A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation treatment	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077853A-00	PER AMS-2700 METHOD 1 TYPE 8.	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Baking	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077853A-00	Bake part after plating within 3 hours as per AMS-2759/9 Table 1 for 3 hours minimum at 191°C.	Firm Inspection report	W	
Final inspection	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 077853A-00	As per Approved Drg No.077853A-00	Firm Inspection report	W	
* Note Process audit on passivation treatment, Backing and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)									