

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
Drq . No.									Rev No:
Nomenclature									Date of Issue
Material									10/06/ 2021
OFT/QAP/SRCG/073326A-00									
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
Roller (Raw material)	General appearance	Non Critical	Visual	100%	ACETAL PER ASTM-D-6778 POM 0110 B78670 FUNGUS RESISTANT COLOR BLACK (COMPATIBLE WITH ERTACETAL H AND DELRIN 150 SA).	As per Approved Drq No. 073326A-00	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 Drawing No. 073326A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drq No. 073326A-00	As per Approved Drq No. 073326A-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 Drq No. 073326A-00	As per Approved Drq No. 073326A-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)									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue
									10 /06 / 2021
Drg . No.	Y17775A-00								
Nomenclature	BUSHING, HINGE : FOR HOUSE PIVOT, WELDMENT (Y17776A-00)								
Material	CRES BAR TYPE 316 PER ASTM-A-276								
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
Bushing, Hinge (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 316 PER ASTM-A-276		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 Drawing No. Y17775A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17775A-00	As per Approved Drg No. Y17775A-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. Y17775A-00	As per Approved Drg No. Y17775A-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
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17737A-00								
Nomenclature	WALL, FRONT RIGHT : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	As per Approved Drawing								
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
Wall, Front Right (Raw material)	General appearance	Non Critical	Visual	100%	As per Approved Drawing		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 Drawing NO. Y17737A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17737A-00	As per Approved Drg No. Y17737A-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. Y17737A-00	As per Approved Drg No. Y17737A-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
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17738A-00								
Nomenclature	BASE, MAGAZINE : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	ALUMINUM ALLOY SHEET THICK 3 MM 5083-H321 per AMS-QQ-A-250/6								
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
Base, Magazine (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY SHEET THICK 3 MM 5083-H321 per AMS-QQ-A-250/6		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 Drawing NO. Y17738A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17738A-00	As per Approved Drg No. Y17738A-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. Y17738A-00	As per Approved Drg No. Y17738A-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
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17746A-00								
Nomenclature	PLATE , LOWER MOUNTING : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	ALUMINUM ALLOY PLATE 6 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6								
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, Lower Mounting (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY PLATE 6 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6		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 Drawing No. Y17746A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17746A-00	As per Approved Drg No. Y17746A-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. Y17746A-00	As per Approved Drg No. Y17746A-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
									Rev No:
									Date of Issue
									10/06 / 2021
Drg . No.	Y17747A-00								
Nomenclature	PLATE , UPPER MOUNTING : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	ALUMINUM ALLOY PLATE 6 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6								
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, Upper Mounting (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY PLATE 6 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6		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 Drawing No. Y17747A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17747A-00	As per Approved Drg No. Y17747A-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. Y17747A-00	As per Approved Drg No. Y17747A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17748A-00								OFT/QAP/SRCG/Y17748A-00
Nomenclature	BASE, MAGAZINE BACK : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	ALUMINUM ALLOY SHEET THICK 3 MM 5083-H321 per AMS-QQ-A-250/6								
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
Base, Magazine back (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY SHEET THICK 3 MM 5083-H321 per AMS-QQ-A-250/6		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 Drawing NO. Y17748A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17748A-00	As per Approved Drg No. Y17748A-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. Y17748A-00	As per Approved Drg No. Y17748A-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
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17749A-00								
Nomenclature	BOX, MAGAZINE, WELDMENT : FOR BOX MAGAZINE PAINT (Y25677A-00)								
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
Box, Magazine, Weldment (Raw material)	General appearance	Non Critical	Visual	100%		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 - As Per Approved Drawing NO. Y17749A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17749A-00	As per Approved Drg No. Y17749A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	WELDING PER AWS D1.2 GTAW OR GMAW USING ELECTRODE ER ER5356 PER AWS A5.10 OR EQUIVALENT. AFTER WELDING APPLY VISUAL INSPECTION		Firm Inspection report	W	
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-A-8625	TYPE II 15 TO 25 MICRON THICK CLASS 1.	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17749A-00	As per Approved Drg No. Y17749A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Anodic Coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17760A-00								
Nomenclature	COVER, MAGAZINE : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 2 MM TYPE 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
Cover Magazine (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 2 MM TYPE 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 Drawing No. Y17760A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17760A-00	As per Approved Drg No. Y17760A-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. Y17760A-00	As per Approved Drg No. Y17760A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17762A-00								
Nomenclature	RIB 2, COVER : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 3 MM TYPE 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
Rib 2, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing No. Y17762A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17762A-00	As per Approved Drg No. Y17762A-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. Y17762A-00	As per Approved Drg No. Y17762A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17763A-00								
Nomenclature	RIB 1, COVER : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 3 MM TYPE 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
Rib 1, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing No. Y17763A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17763A-00	As per Approved Drg No. Y17763A-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. Y17763A-00	As per Approved Drg No. Y17763A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17764A-00								OFT/QAP/SRCG/Y17764A-00
Nomenclature	WING RIGHT, COVER : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 2 MM TYPE 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
Wing Right, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 2 MM TYPE 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 Drawing No. Y17764A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17764A-00	As per Approved Drg No. Y17764A-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. Y17764A-00	As per Approved Drg No. Y17764A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17765A-00								
Nomenclature	WING LEFT, COVER : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 2 MM TYPE 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
Wing Left, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 2 MM TYPE 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 Drawing No. Y17765A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17765A-00	As per Approved Drg No. Y17765A-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. Y17765A-00	As per Approved Drg No. Y17765A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y17766A-00									OFT/QAP/SRCG/Y17766A-00
Nomenclature	COVER MAGAZINE, WELDMENT : FOR COVER MAGAZINE PAINTED (Y25679A-00)									
Material	As Per Approved Drawing No. Y17766A-00									
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	
Cover Magazine, Weldment (Raw material)	General appearance	Non Critical	Visual	100%	As Per Approved Drawing No. Y17766A-00		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 Drawing No. Y17766A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17766A-00	As per Approved Drg No. Y17766A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	WELDING PER AWS D1.1 GTAW OR GMAW CLASS C USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT. AFTER WELDING APPLY VISUAL INSPECTION.					
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17766A-00	As per Approved Drg No. Y17766A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17769A-00								
Nomenclature	PIVOT, ROLLER, COVER : FOR COVER MAGAZINE ASSY (Y25678A-00)								
Material	CRES BAR 316L per ASTM-A-276								
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
Pivot, Roller, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR 316L per ASTM-A-276		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 Drawing No. Y17769A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17769A-00	As per Approved Drg No. Y17769A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	METHOD 1, TYPE 7	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17769A-00	As per Approved Drg No. Y17769A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10 /06 / 2021
Drg . No.	Y17772A-00								
Nomenclature	ROD COVER : FOR MAGAZINE BOX ASSY (Y25676A-00)								
Material	10MM DIA. CRES BAR 316L per ASTM-A-276								
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
Rod Cover (Raw material)	General appearance	Non Critical	Visual	100%	10MM DIA. CRES BAR 316L per ASTM-A-276		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 Drawing NO. Y17772A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17772A-00	As per Approved Drg No. Y17772A-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%	VS-1-3-1-165	Type-1, 5-13 Micron Thick	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17772A-00	As per Approved Drg No. Y17772A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry Film Lubrication Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17774A-00								
Nomenclature	PLATE, PIVOT: FOR HOUSE PIVOT, WELDMENT (Y17776A-00)								
Material	CRES PLATE THICK 2 MM TYPE 316 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 Pivot (Raw material)	General appearance	Non Critical	Visual	100%	CRES PLATE THICK 2 MM TYPE 316 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 Drawing No. Y17774A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17774A-00	As per Approved Drg No. Y17774A-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. Y17774A-00	As per Approved Drg No. Y17774A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17776A-00								OFT/QAP/SRCG/Y17776A-00
Nomenclature	HOUSE PIVOT, WELDMENT : FOR HOUSE PIVOT PAINT (Y25677A-00)								
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
House Pivot Weldment (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing No. Y17776A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17776A-00	As per Approved Drg No. Y17776A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	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 Drg No. Y17776A-00	As per Approved Drg No. Y17776A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17777A-00								
Nomenclature	PIVOT 2, COVER : FOR MAGAZINE BOX ASSY (Y25676A-00)								
Material	CRES BAR 316L per ASTM-A-276								
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
Pivot 2, Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR 316L per ASTM-A-276		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 Drawing NO. Y17777A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17777A-00	As per Approved Drg No. Y17777A-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%	VS-1-3-1-165	Type-1, 15± 5 Micron Thick	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17777A-00	As per Approved Drg No. Y17777A-00	Firm Inspection report	W	
<p>* Note: 1. Clause 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>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17864A-00								OFT/QAP/SRCG/Y17864A-00
Nomenclature	ROD, MAGAZINE : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	21mm DIA. ALUMINIUM ALLOY BAR 5086-H111 PER ASTM B-221								
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
Rod, Magazine (Raw material)	General appearance	Non Critical	Visual	100%	21mm DIA. ALUMINIUM ALLOY BAR 5086-H111 PER ASTM B-221		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 Drawing NO. Y17864A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17864A-00	As per Approved Drg No. Y17864A-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. Y17864A-00	As per Approved Drg No. Y17864A-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
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y17866A-00								
Nomenclature	WALL, FRONT LEFT : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	As per Approved Drawing								
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
Wall, Front Left (Raw material)	General appearance	Non Critical	Visual	100%	As per Approved Drawing		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 Drawing NO. Y17866A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17866A-00	As per Approved Drg No. Y17866A-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. Y17866A-00	As per Approved Drg No. Y17866A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17879A-00								
Nomenclature	RIB , COVER : FOR COVER MAGAZINE, WELDMENT (Y17766A-00)								
Material	CRES SHEET THICK 3 MM TYPE 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
Rib , Cover (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing No. Y17879A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17879A-00	As per Approved Drg No. Y17879A-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. Y17879A-00	As per Approved Drg No. Y17879A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y18022A-00									OFT/QAP/SRCG/Y18022A-00
Nomenclature	SWING, SENSOR : FOR AMMO MECHANISM, WELDING (Y18222A-00)									
Material	CRES SHEET THICK 3 MM TYPE 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	
Swing, Sensor (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing NO. Y18022A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18022A-00	As per Approved Drg No. Y18022A-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. Y18022A-00	As per Approved Drg No. Y18022A-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	
									Rev No:	
									Date of Issue	
									10 /06 / 2021	
Drg . No.	Y18076A-00									OFT/QAP/SRCG/Y18076A-00
Nomenclature	MOUNT, PLATE : FOR AMMO MECHANISM, WELDING (Y18222A-00)									
Material	CRES SHEET THICK 3 MM TYPE 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	
Mount, Plate (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing NO. Y18076A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18076A-00	As per Approved Drg No. Y18076A-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. Y18076A-00	As per Approved Drg No. Y18076A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y18217A-00									OFT/QAP/SRCG/Y18217A-00
Nomenclature	PLATE, SMALL : FOR AMMO MECHANISM, WELDING (Y18222A-00)									
Material	CRES SHEET THICK 3 MM TYPE 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	
Plate, Small (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 3 MM TYPE 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 Drawing NO. Y18217A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18217A-00	As per Approved Drg No. Y18217A-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. Y18217A-00	As per Approved Drg No. Y18217A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y18221A-00								OFT/QAP/SRCG/Y18221A-00
Nomenclature	HOUSING, TUBE : FOR AMMO MECHANISM, WELDING (Y18222A-00)								
Material	CRES BAR TYPE 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
Housing, Tube (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 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 Drawing NO. Y18221A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18221A-00	As per Approved Drg No. Y18221A-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. Y18221A-00	As per Approved Drg No. Y18221A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y18222A-00									OFT/QAP/SRCG/Y18222A-00
Nomenclature	AMMO MECHANISM, WELDING : FOR AMMO MECHANISM, MACHINING (Y18258A-00)									
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	
Ammo, Mechanism, Welding (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing NO. Y18222A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18222A-00	As per Approved Drg No. Y18222A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	WELDING PER AWS D1.1 GTAW OR GMAW CLASS C USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT. AFTER WELDING APPLY VISUAL INSPECTION.		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18222A-00	As per Approved Drg No. Y18222A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06 / 2021
Drg . No.	Y18227A-00								OFT/QAP/SRCG/Y18227A-00
Nomenclature	PIN AND LEVER ASSY : FOR MAGAZINE BOX ASSY (Y25676A-00)								
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
Pin and Lever Assy (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing No. Y18227A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18227A-00	As per Approved Drg No. Y18227A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	WELDING PER AWS D1.1 GTAW OR GMAW CLASS C USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT. MANDATORY NDT INSPECTION OF WELDING: VISUAL IVSPECTION.		Firm Inspection report	W	
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%	VS-1-3-1-165	Type-1, 15± 5 Micron Thick	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18227A-00	As per Approved Drg No. Y18227A-00	Firm Inspection report	W	

* **Note:** 1. Clause indicated in the drawing to be followed
2. Process audit on Welding, Dry Film Lubrication and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y18228A-00								OFT/QAP/SRCG/Y18228A-00
Nomenclature	LEVER, SMALL : FOR PIN AND LEVER ASSY (Y18227A-00)								
Material	CRES SHEET THICK 2 MM TYPE 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
Lever, Small (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET THICK 2 MM TYPE 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 Drawing No. Y18228A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18228A-00	As per Approved Drg No. Y18228A-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. Y18228A-00	As per Approved Drg No. Y18228A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y18238A-00									OFT/QAP/SRCG/Y18238A-00
Nomenclature	PIN, 8mm, LONG : FOR PIN AND LEVER ASSY (Y18227A-00)									
Material	CRES BAR 316L per ASTM-A-276									
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	
Pin, 8mm Long (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR 316L per ASTM-A-276		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 Drawing No. Y18238A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18238A-00	As per Approved Drg No. Y18238A-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. Y18238A-00	As per Approved Drg No. Y18238A-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
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y18258A-00								
Nomenclature	AMMO MECHANISM, MACHINING : FOR MAGAZINE BOX ASSY (Y25676A-00)								
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
Ammo, Mechanism, Machining (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing NO. Y18258A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18258A-00	As per Approved Drg No. Y18258A-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%	VS-1-3-1-165	Type-1, 15± 5 Micron Thick	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18258A-00	As per Approved Drg No. Y18258A-00	Firm Inspection report	W	
<p>* Note: 1. Clause 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>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10 /06/ 2021
Drg . No.	Y18302A-00								
Nomenclature	SPRING, TORSION, LEFT : FOR MAGAZINE BOX ASSY (Y25676A-00)								
Material	17-7PH DIAMETER 1.5 MM PER ASTM A313(631) or AMS 5678E or UNS S17700.								
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
Spring, Torsion, Left (Raw material)	General appearance	Non Critical	Visual	100%	17-7PH DIAMETER 1.5 MM PER ASTM A313(631) or AMS 5678E or UNS S17700.		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 Drawing No. Y18302A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18302A-00	As per Approved Drg No. Y18302A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Cataphoretic Finish	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-0053084A (MR)		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18302A-00	As per Approved Drg No. Y18302A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Cataphoretic Finish and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y18309A-00								
Nomenclature	SPRING, TORSION, RIGHT : FOR MAGAZINE BOX ASSY (Y25676A-00)								
Material	17-7PH DIAMETER 1.5 MM PER ASTM A313(631) or AMS 5678E or UNS S17700.								
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
Spring, Torsion, Right (Raw material)	General appearance	Non Critical	Visual	100%	17-7PH DIAMETER 1.5 MM PER ASTM A313(631) or AMS 5678E or UNS S17700.		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 Drawing No. Y18309A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18309A-00	As per Approved Drg No. Y18309A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Cataphoretic Finish	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-0053084A (MR)		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18309A-00	As per Approved Drg No. Y18309A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Cataphoretic Finish and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue
									10/06/ 2021
Drg . No.	Y18350A-00								
Nomenclature	PLATE , SUPPORT, SMALL : FOR BOX, MAGAZINE, WELDMENT (Y17749A-00)								
Material	ALUMINUM ALLOY PLATE 4 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6								
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, Support, Small (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY PLATE 4 MM THICK TYPE 5083-H321 per AMS-QQ-A-250/6		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 Drawing No. Y18350A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18350A-00	As per Approved Drg No. Y18350A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Epoxy Primer	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-P-53022		Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18350A-00	As per Approved Drg No. Y18350A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Epoxy Primer , Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y25676A-00								OFT/QAP/SRCG/Y25676A-00
Nomenclature	MAGAZINE BOX ASSY								
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
Magazine Box Assy (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 - As Per Approved Drawing NO. Y25676A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25676A-00	As per Approved Drg No. Y25676A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Welding, Dry Film Lubrication, Anodic Coating, Passivation Treatment, Cataphoretic Finish, Epoxy Primer, Paint.	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	As per Approved Drg No. Y25676A-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25676A-00	As per Approved Drg No. Y25676A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Welding, Dry Film Lubrication, Anodic Coating, Passivation Treatment, Cataphoretic Finish, Epoxy Primer, Paint. and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y25677A-00								OFT/QAP/SRCG/Y25677A-00
Nomenclature	BOX MAGAZINE PAINT : FOR MAGAZINE BOX ASSY (Y25676A-00)								
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
Box Magazine Paint (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing NO. Y25677A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25677A-00	As per Approved Drg No. Y25677A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
PAINT	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Intermediate, Top coat shall be carried out as per Approved Drg No. Y25677A-00		Firm Inspection report	W	
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%	VS-1-3-1-165	Type 2, 15 ± 5 Micron Thick		R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25677A-00	As per Approved Drg No. Y25677A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Paint, Dry Film Lubrication Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
									Rev No:	
									Date of Issue 10 /06 / 2021	
Drg . No.	Y25678A-00									OFT/QAP/SRCG/Y25678A-00
Nomenclature	COVER MAGAZINE ASSY : FOR MAGAZINE BOX ASSY (Y25676A-00)									
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	
Cover Magazine Assy (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing NO. Y25678A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25678A-00	As per Approved Drg No. Y25678A-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. Y25678A-00	As per Approved Drg No. Y25678A-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	
									Rev No:	
									Date of Issue 10/06/ 2021	
Drg . No.	Y25679A-00									OFT/QAP/SRCG/Y25679A-00
Nomenclature	COVER MAGAZINE PAINTED : FOR COVER MAGAZINE ASSY (Y25678A-00)									
Material	As Per Approved Drawing No. Y25679A-00									
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	
Cover Magazine Painted (Raw material)	General appearance	Non Critical	Visual	100%	As Per Approved Drawing No. Y25679A-00		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 Drawing No. Y25679A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25679A-00	As per Approved Drg No. Y25679A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Passivation Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	METHOD 1, TYPE 7	Firm Inspection report	R		
Paint	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Intermediate, Top coat shall be carried out as per Approved Drg No. Y25679A-00		Firm Inspection report	W		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25679A-00	As per Approved Drg No. Y25679A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment, Paint Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y25680A-00								OFT/QAP/SRCG/Y25680A-00
Nomenclature	HOUSE PIVOT PAINT : FOR MAGAZINE BOX ASSY (Y25676A-00)								
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
House Pivot Paint (Raw material)	General appearance	Non Critical	Visual	100%	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 - As Per Approved Drawing No. Y25680A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25680A-00	As per Approved Drg No. Y25680A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivatin Treatment	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	Method 1, Type 7	Firm Inspection report	W	
PAINT	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Intermediate, Top coat shall be carried out as per Approved Drg No. Y25680A-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25680A-00	As per Approved Drg No. Y25680A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment , Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

QUALITY ASSURANCE PLAN (SRCG IM PHASE)								Issue No : 01	
								Rev No:	
								Date of Issue 10/06/ 2021	
Drg . No.	Y25681A-00							OFT/QAP/SRCG/Y25681A-00	
Nomenclature	NUT SENSOR : FOR MAGAZINE BOX ASSY (Y25676A-00)								
Material	ALUMINUM ALLOY PLATE 6061-T651 PER AMS-QQ-A-250/11.								
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
Nut Sensor (Raw material)	General appearance	Non Critical	Visual	100%	ALUMINUM ALLOY PLATE 6061-T651 PER AMS-QQ-A-250/11.		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 Drawing NO. Y25681A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25681A-00	As per Approved Drg No. Y25681A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-A-8625, Type-II	15 to 25 Micron Thick Class 1.	Firm Inspection report	W	
PAINT	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Primer, Intermediate, Top coat shall be carried out as per Approved Drg No. Y25681A-00		Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25681A-00	As per Approved Drg No. Y25681A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Anodic Coating, Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									