

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01	
									Rev No:	
									Date of Issue 05 /06 / 2021	
Drng . No.	Y25689A-00									OFT/QAP/SRCG/Y25689A
Nomenclature	COVER BLIND FRONT FINISH									
Material	Aluminium Alloy Plate 6061-T651 PER SAE AMS-QQ-A-250/11.									
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	
Cover Blind Front finish (Raw material)	General appearance	Non Critical	Visual	100%	Aluminium Alloy Plate 6061-T651 PER SAE AMS-QQ-A-250/11	Aluminium Alloy Plate 6061-T651 PER SAE 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 - Milling,Drilling, Reaming, Threading, Knurling	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25689A-00	As per Approved Drg No. Y25689A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Chromatic Conversion Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-DTL-5541F	Type I Class 3.	Firm Inspection report	R		
Anodic Coating	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-A-8625	Type-II, 15to 25 Micron Thick Class-1	Firm Inspection report	R		
Paint	General appearance	Non Critical	Visual and Dimensional Checks	100%	Primer , Intermediate, Top Coat as per specification standard in the drawing.		Firm Inspection report	R		
Primer Epoxy	General appearance	Non Critical	Visual and Dimensional Checks	100%	MIL-P-53022		Firm Inspection report			
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y25689A-00	As per Approved Drg No. Y25689A-00	Firm Inspection report	W		

* **Note:** 1. Clause 5.3,6,7.4,9 indicated in the drawing to be followed
2. Process audit on Chromatic Conversion coating, Anodic Coating, Paint,Primer Epoxy and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)