

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10 /06/ 2021
Drg . No.	077231A-00								
Nomenclature	CABLE ASSY, WPKS7								
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
Cable Assy, WPKS7 (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. 077231A-00	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. 077231A-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%		As per Approved Drg No. 077231A-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>									

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Drg . No.	044567A-00								
Nomenclature	BACKSHELL D38999-11 : REQD.FOR CABLE ASSY, WPKS7 (077231A-00)								
Material	ALUM. ALLOY PLATE 6061-T6 OR 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
Backshell D38999-11 (Raw material)	General appearance	Non Critical	Visual	100%	ALUM. ALLOY PLATE 6061-T6 OR 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. 044567A-00	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. 044567A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Chemical conversion coating	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	PER MIL-DTL-5541	TYPE I CLASS 3.	Firm Inspection report	W	
Primer Epoxy	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%		MIL-P-53022 TYPE II 25 MICRON THICK.	Firm Inspection report	W	
Paint	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%		TOP COAT POLYURETHANE HS COLOR RAL6031-F9 (BRONZE GREEN) PER BI-CP 454 STANGAE 4360 60 MICRON THICK.	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%		As per Approved Drg No. 044567A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Chemical conversion coating,Primer Epoxy,Paint and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									