

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01 Rev No:
									Date of Issue 21/05/ 2021
Drg . No.	Y03740A-00								
Nomenclature	LEVER TRIGGER								
Material	CRES PLATE TYPE 17-4 PH AS PER AMS-5604								
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
Lever Trigger (Raw material)	General appearance	Critical	Visual	100%	CRES Plate Type 17-4 PH as per AMS-5604	As per CRES Plate Type 17-4 PH as per AMS-5604	Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Critical	Chemical Lab analysis	As per Batch			Test report from NABL lab	R	
	Mechanical properties	Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Milling,Drilling, Threading	Dimensions Specified in the Inspection report of the component	Critical	Dimensional measurement	Zero Acceptance Number (# ZAN)	Approved Drg No. Y03740A-00	As per Approved Drg No. Y03740A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Dry Film Lubrication in a FluoroPolymer Organic Resin Class 2 colour Matte Black Type 1	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. 065600A-00	8-16 micron thick as per VS-1-3-1-165 (or equivalent)	Firm Inspection report	W	
Baking	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y03740A-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	R	
Final Inspection	General appearance	Critical	Visual and Dimensional Checks	Zero Acceptance Number (# ZAN)	Approved Drg No. Y03740A-00	As per Approved Drg No. Y03740A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
<p>* Note 1. Clause 8.1 indicated in Drawing to be followed 2. Process audit on Dry Film Lubrication, Baking and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									