	Issue No : 01 Rev No: Date of Issue 10/ 06 / 2021								
Drg . No.	064595A-01	OFT/QAP/SRCG/064595A-01							
Nomenclature	BRACKET ASSY 2								
Material	As per Assembly Pa								
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
	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
Bracket Assy 2 (Raw material)	Chemical properties	Non Critical	Chemical Lab analysis	100%	As per A	Assembly Part List.	Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Turning, Milling,Drilling, Reaming, Threading etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement			As per Approved Drg No. 064595A-01	Firm Inspection report	W	
Passivation Treatment (for 062341A-00)	General appearance	Non Critical	Visual and Dimensional Checks	100%	AMS-2700	Method 1, Type 8	Firm Inspection report	R	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Baking (for 062341A-00)	General appearance	Critical	Visual and Dimensional Checks		Approved Drg No. 064595A-01	BAKE PART AFTER PLATING WITIN 3 HOURS PER AMS- 2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 C.	Firm Inspection report	R	
Phosphate Coating (for 064597A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-16232	Type M, Class-2, 0.005- 0.010mm.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks			As per Approved Drg No. 064595A-01	Firm Inspection report	W	

^{*} Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Passivation Treatment, baking, Phosphate Coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)

Issue No : 01 Rev No: **QUALITY ASSURANCE PLAN** (SRCG IM PHASE) Date of Issue 10 /06 / 2021 062341A-00 Drg. No. SHAFT, BELLEVILLE: FOR BRACKET ASSY 2 (064595-01) Nomenclature OFT/QAP/SRCG/062341A-00 CRES BAR TYPE 17-4PH PER AMS 5643. Material Inspection by QAE(N), Component Quantum of Reference Format of Chennai or by Nomenclature/ Characteristics Class Type of check Acceptance norms Remarks check document record Nominated Agency operations (Review/Witness) Firm Inspection Non R General appearance Visual 100% Critical report Sample will be drawn Test report Shaft, Belleville Non CRES BAR TYPE 17-4PH PER AMS 5643. R and sealed by Chemical properties Chemical Lab analysis 100% from (Raw material) Critical Inspection Agency NABL lab Test report Mechanical Non Mechanical Lab 100% R from Critical analysis properties NABL lab **Dimensions Specified** In process - As per in the Inspection Non Dimensional IS 2500 Level II Approved Drg As per Approved Drg No. Firm Inspection Approved Drg No. W report of the Critical measurement AQL 2.5% No. 062341A-00 062341A-00 report 062341A-00 component Mechanical Non Mechanical Lab IS 2500 Level II MIL-H-6875, Firm Inspection Heat Treatment H1150 W AQL 2.5% CLASS D properties Critical analysis report Passivation IS 2500 Level II Non Visual and Firm Inspection AMS-2700 R General appearance Method 1, Type 8 Treatment Firm will be undertaking **Dimensional Checks** AQL 2.5% Critical report (for 062341A-00) 100 % Checks and Pre inspection Report for the same be BAKE PART AFTER PLATING submitted WITIN 3 HOURS PER AMS-Baking Visual and IS 2500 Level II Approved Drg Firm Inspection Critical 2759/9 R General appearance (for 062341A-00) **Dimensional Checks** AQL 2.5% No. 062341A-00 report TABLE 1 FOR 3 HOURS MINIMUM AT 191 C. Firm Inspection Non Visual and IS 2500 Level II Approved Drg As per Approved Drg No. Final Inspection General appearance W Critical **Dimensional Checks** AQL 2.5% No. 062341A-00 062341A-00 report

^{*} **Note:** 1. Clause indicated in the drawing to be followed

^{2.} Process audit on Passivation Treatment, baking and Traceability of Raw materials to Final Product (Man, Material, Machine and Methods)

	Issue No : 01 Rev No: Date of Issue 10 /06/ 2021								
Drg . No.	064597A-00	OFT/QAP/SRCG/064597A-00							
Nomenclature	SUPPORT, BELLE								
Material	STEEL ALLOY BAF								
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
Support, Belleville (Raw material)	General appearance	Non Critical	Visual	100%			Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%		R SAE 4130 PER SAE-AMS-S- 340 PER SAE-AMS-S-5000	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 Drg No. 064597A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064597A-00	As per Approved Drg No. 064597A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Heat Treatment	Mechanical properties	Non Critical	Mechanical Lab analysis	IS 2500 Level II AQL 2.5%	Approved Drg No. 064597A-00	QUENCH AND TEMPER ENTIRE PART; HARDNESS 35±4 HRC.	Firm Inspection report	W	
Phosphate Coating (for 064597A-00)	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	MIL-DTL-16232	Type M, Class-2, 0.005- 0.010mm.	Firm Inspection report	R	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. 064597A-00	As per Approved Drg No. 064597A-00	Firm Inspection report	W	

^{*} Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Phosphate Coating and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)