

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									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 Part List.								
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
Bracket Assy 2 (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 - Turning, Milling, Drilling, Reaming, Threading etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. 064595A-01	As per Approved Drg No. 064595A-01	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
Passivation Treatment (for 062341A-00)	General appearance	Non Critical	Visual and Dimensional Checks	100%	AMS-2700	Method 1, Type 8	Firm Inspection report	R	
Baking (for 062341A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	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	IS 2500 Level II AQL 2.5%	Approved Drg No. 064595A-01	As per Approved Drg No. 064595A-01	Firm Inspection report	W	
<p>* 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)</p>									

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Drng . No.	062341A-00									OFT/QAP/SRCG/062341A-00
Nomenclature	SHAFT, BELLEVILLE : FOR BRACKET ASSY 2 (064595-01)									
Material	CRES BAR TYPE 17-4PH PER AMS 5643.									
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	
Shaft, Belleville (Raw material)	General appearance	Non Critical	Visual	100%	CRES BAR TYPE 17-4PH PER AMS 5643.		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 Drng No. 062341A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drng No. 062341A-00	As per Approved Drng No. 062341A-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%	MIL-H-6875, CLASS D	H1150	Firm Inspection report	W		
Passivation Treatment (for 062341A-00)	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	AMS-2700	Method 1, Type 8	Firm Inspection report	R		
Baking (for 062341A-00)	General appearance	Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drng No. 062341A-00	BAKE PART AFTER PLATING WITIN 3 HOURS PER AMS-2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 C.	Firm Inspection report	R		
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drng No. 062341A-00	As per Approved Drng No. 062341A-00	Firm Inspection report	W		
<p>* 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)</p>										

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Drq . No.	064597A-00							OFT/QAP/SRCG/064597A-00	
Nomenclature	SUPPORT, BELLEVILLE : FOR BRACKET ASSY 2 (064595-01)								
Material	STEEL ALLOY BAR SAE 4130 PER SAE-AMS-S-6758 OR SAE 4340 PER SAE-AMS-S-5000								
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%	STEEL ALLOY BAR SAE 4130 PER SAE-AMS-S-6758 OR SAE 4340 PER SAE-AMS-S-5000		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 Drq No. 064597A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drq No. 064597A-00	As per Approved Drq 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 Drq 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 Drq No. 064597A-00	As per Approved Drq No. 064597A-00	Firm Inspection report	W	
<p>* 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)</p>									