



Order Number:

QUALITY ASSURANCE PLAN

Exports/ Domestic:

DATE:

(Impact Sockets: 12 points, 6 points, 5 spline and 4 spline)

* tools with perfection

SN	Component Name/Activity	Characteristic to be verified	Extent of Inspection	Acceptance Criteria	Format of Records	Responsibility			Remarks
						V	CL	C	
A	Raw Material								
1	Round Bar	To determine internal defects	100%	As per ASME Sec VIII Div-2 Article 23	Ultrasonic test certificate		W	R	
2	Round Bar	Chemical Composition	1 small piece/lot	As per standard EN 47/AISI-6150	Mill Test Certificates/ Lab Test Reports				
B	Machining								
1	Cutting	Dimension, Geometry	100%	No stains, dimension as per drawing	-				
2	Pre turning	Surface finish	100%	Dimension as per drawing	-				
3	Turning	Shape and Dimension	100%	No cracks, dimension as per diagram	Pre slotting inspection report as per drawing with vernier				
4	Slotting (VMC: 6 points) Squaring (Broaching) Slotting M/C (Bi hex)	Dimension, edges and finish	100%	Dimensions as per diagram	Gauge checking report for square and hex portion as per drawing				
5	Chamfering	Corners and Flatness	100%	Smooth surface	-				
6	Drilling	Diameter	100%	Dimensions	-				
7	Deburring	Shape and Dimension	100%	No burrs and smooth surface	Gauge checking report considering lengths, diameters before pre hardening as per drawing				
	Engraving to be done if required								
C	Heat Treatment (HT)								
1	Hardening	Hardening as per specification	10% of the lot to be check	Hardening as per material standards measured in HRC units	Hardness certificate				
	Engraving to be done if required								

Contd....

SN	Component Name/Activity	Characteristic to be verified	Extent of Inspection	Acceptance Criteria	Format of Records	Agency/Responsibility			Remarks
						V	CL	C	
D Surface Treatment									
1	Shot Blasting	Smoothness	100%	No stains and surface finishing	Inspection report				
2	Black oxidizing	Mat finish	100%	Proper finishing	Inspection report				
Marking Laser to be done if required									
E Final Inspection									
1	Final Inspection	Dimension, Geometry, lot number identification	100%	As per diagram and clients requirement	In process reports which includes pre slotting report, pre hardening report, black oxidizing to be visually checked, correct marking, correct quantity and packing to be checked				
2	Packing	Dispatch Boxes	100%	Properly packed sockets	Packing list				
Complete report to be submitted before dispatch to marketing department head									
F Dispatch									
1	Post Packing (Domestic)	Packing list, Place of delivery, Road permit, Invoice	100%	Ensure all required document has been sent to clients	Document folder and release order as per domestic criteria				
2	Post shipment (Foreign)	Packing List, Docket information, Hard copy of invoice, payment	100%	Ensure all required document has been sent to clients	Document folder and release order as per foreign criteria				
LEGENDS									
V: Vendor/Supplier		CL: Client Inspection	C: Customer Inspection		W: Witness	R: Review of reports			

Authorized Signature