



ANNEXURE-I

QUALITY ASSURANCE PLAN

MACHINE DESCRIPTION : 5Axis CNC FIAT BOGIE FRAME MACHINING CENTRE.

Category	S. No.	Component/ Process	Sample Size	Type Of Check	Quality record	TYPE OF CHECK	REMARKS
Bought Out Raw Material		Steels	1 Sample / Size	Chemical & Mech.	TC & INV.	CHP	
Bought Out Components		Bearings	100%	Visual	Inv	CHP	
		Electric Motors	100%	Review of TC	TC & INV	V	
		Hydraulic Pumps & Elements	100%	Review of TC	TC & INV	V	
		Rubber Seals, O Rings & Seals	100%	Visual	TC & INV	V	
		Controllers	100%	Review of TC	TC & INV	V	
		Ball Screw	100%	Visual	IIR	V	
Bought out sub assemblies		Weld joints					
		Load Bearings	100 %	RT	IR	CHP	
		Others	5 %	DPT	IIR	V	
		Hardness and	100%	Hardness	IIR	V	
In process Inspection stage							
		Heat Treatment	100%	Review of Inv.	IIR	V	
		Castings	100%	Visual	IIR	V	
		Spindles	100%		IIR	V	
		surface finish of components	Random	Surface	IIR	V	
		Noise level	100 %	Sound	IIR	CHP	
		Temperature rise	100 %	Measurement	IIR	V	
		Structures, Geometry alignment, Guideways	100%	Relevant ISO/DIN/IS/JIS standard	IR	CHP	

INV - Invoice

TC - Test Certificate

V - Verification

CHP - Customer Hold Point

IIR - Internal Inspection Report

IR - Inspection Report

Signature Not Verified

Digitally signed by
BAPAN PRAMANIK
Date: 2023.06.16
15:54:19 +05'30'Reason: IIR PS-CRIS
Location: New Delhi