

QUALITY PLAN

Sl. No	Stage of inspection	Method of Check	Quantum of check	Reference Document	Acceptance Standard	Format of record	Inspection By		Remarks
							PI	C	
1	Selection Of Raw Material	Chemical	3 Samples /Lot	NIL	Volumetric Analysis	Chemical Analysis Report	W	R	
2	Pattern	Dimensional & Visual	100%	Customer Drawing	IS 1513	Inspection Report	W	R	
3	Moulding	Dimensional	100%	Customer Drawing	Customer Drawing	Dimensional Report	W	R	
4	Melting	Chemical Composition	1 Sample/ Melt	IS-210 :1993 Gr: Fg220	IS-210 :1993 Gr: Fg220	Chemical Analysis Report	W	R	
5	Identification Of Test Bars	Stamping	2 Test bars/Melt	IS-210 :1993 Gr: Fg220	IS-210 :1993 Gr: Fg220	Identification mark	W	R	
6	Tensile testing of test bars	Tensile Test	1 Test bar/Melt	Customer Drawing	IS-210 :1993 Gr: Fg220	Mechanical Test Report	W	W	
7	Hardness Test	Poldi Hardness Test	3 readings on each job	IS-210 :1993 Gr: Fg220	IS-210 :1993 Gr: Fg220	Mechanical Test Report	W	W	
8	Final Inspection	Visual	100%	Customer Drawing	Customer Drawing	Inspection Report	W	W	
9	Final Inspection	Dimensional	100%	Customer Drawing	Customer Drawing	Dimensional Report	W	W	

Description: Grey Iron Castings

Material Specification: IS 210:1993 Grade FG 220.

R-Review

W-Witness

PI-Prathap Industries

C-Customer