BrahMos Aerospace Thiruvananthapuram Ltd. (BATL)

Thiruvananthapuram- 695007. Phone: 0471-2501325, Fax: 2500702

Dimension Inspection Report (Sub Contracted Items)

Sl. No.QR-01 ……..

Date :……..

(To be filled by Supplier)

Supplier : ……

Part Name : ……

Drg. No. & Rev. No : ……. ……

Job. Idfn. Nos. : ……Qty……

.Supplier Ref. No. : ……

BATL.Purch. Ord.NO. : ……

Other ref. (if any) : ……

(To be filled by BATL only)

W. O / J.C No. : ……...

Part Name : ……...

Drg. No. & Rev. No : …….....

Job. Idfn. Nos : …… Qty…….

Stage / Final : ……..... Opn. No…….

Cust. Ord. No. : ……...

Customer : ……...

Sl. No.	Specification	Observation	Instrument Idn. / Remarks
	Material		
	RMC No.		
	Comp. Idfn. No.		

Inspected by :
Supplier **(QC)** :

Inspected by :
BATL **(QC)** :

Supplier NCR No :
BATL NCR No :

Qty. Accepted
Qty. For Concession
Qty. Rejected

VERIFIED BY :
(Supplier -QC) :
Sign & Date :
Name :
Designation :

VERIFIED BY :
(BATL -QC) :
Sign & Date :
Name :
Designation :

AUDITED BY :
(BATL -QA) :
Sign & Date :
Name :
Designation :

CUSTOMER SURVEYOR
Sign & Date :
Name :
Designation :

Dimension Inspection Report (Sub Contracted Items)

Continuation of Inspn. Report No. QR-01…… ……Part Name : ……J/C NO……

Supplier Purchase Order No: ……BATL Customer Order No:…… ……

Sl. No.	Specification	Observation	Instrument Idn. / Remarks
	Comp. Idfn. No.		

Inspected by Supplier **(QC)**:

Inspected by BATL **(QC)**:

Customer Surveyor

Verified by Supplier **(QC)** :

Verified by BATL **(QC)**:

Continuation of F10.00

Sheet No. of……

BRAHMOS AEROSPACE THIRUVANANTHAPURAM LIMITED (BATL)

GENERAL QUALITY REQUIREMENTS-TO ALL CONCERNED (Suppliers)

I. TRACEABILITY OF MATERIAL AND CO-RELATION OF COMPONENT IDENTIFICATION NUMBER

a) Traceability of material and corresponding component (Raw Material Code No. (RMC No.) and job identification no.) is an important mandatory requirement.,

b) Traceability of each component at any stage (raw material / semi finished / finished/after surface treatment. etc.,) must be retained and ensured by proper recording. If the RMC No. of material with corresponding component is not traceable, BrahMos/BrahMos's Customer can reject or short close the order without any information.

c) For maintaining traceability of RMC No. and corresponding component's Idn. No.**for each job;**

   i. Put Identification label (Tag / Slip) on the job. Strictly **AVOID STICKER** to prevent adhesive contamination of the job.

   ii. ENGRAVING **NOT PERMITTED** - unless otherwise clearly specified in the contract order.

   iii. Write the RMC No. and corresponding component Idn. No. in the inspection reports.

d) In case of any clarification please contact – ***Sub Contract Department (SCD)***, BrahMos(BATL)

II. DURING PRODUCTION –

Before machining, verify CNC Programme,Dry run, Simulation., etc.,(if applicable)

a) Before starting batch production, Firstoff job's clearance must be obtained from BATL

b) Control all dimensions and geometrical parameters within limit, avoid chattering marks, sharp tool marks, thread folding and should maintain good appearance.

c) Provide sharp corner(s) if it is specified in the drawing and deburr properly. In all other areas maintain suitable chamfer or radius as per drawing specification

d) Inspect the job using instruments, templates, gauges etc. with valid calibration. – Note the Code No. of Instrument in appropriate records/logbooks/reports

e) To avoid corrosion, apply permitted preservatives in all stages of the products and keep safely.

III. PREPARATION OF INSPECTION REPORT – *Prepare the Report in Brahmos (BATL) format only.*

a). In the drawing, put serial number systematically in all dimensions and notes and prepare legible inspection reports for each components for all specified dimensions including geometrical parameters, surface finish, other notes, etc., with reference to the supplied drawing

b). 1.First off Inspection.

This has to be done at supplier end in format No. BATL.QC.F9.00 ONLY. The space provided for the supplier shall be filled and duly signed, without which the report shall not be accepted by QC BATL.

2. Batch Inspection report.

Based on First off clearance or else, the supplier shall manufacture and inspect. The dimensions shall be recorded in **vertical** format (BATL.QC.F11.00) for quantity less than or equal to 6 numbers. In case of quantity more than six numbers **horizontal** format (BATL QC.F10.00) shall be used. All the hard copy of inspection reports to be signed by supplier in space provided.

3. Job Idn. No. mentioned in the report shall be as per the BATL's requirements and it will be filled up by the supplier and any correction to the same will be done by supplier only.

c) In the inspection report, the RMC No. & Job Idn. No. Correlation (if applicable) must be incorporated by the supplier.

d) Write the identification no. of the measuring instrument, template, gauge etc., in the prescribed area of the report by the supplier.

e) If any dimensional & geometrical deviation or visual defects are observed,- either highlight the same in the inspection report itself or provide separate deviation report as per BATL requirement.

f) Specification **"Visual /FOD"** (Foreign Object Detection) remark is to be added in the inspection report and its observation is to be recorded by the supplier.

4. **PACKING AND FORWARDING**

a) Apply permitted preservatives (oil / grease, etc) to corrosive materials and avoid metal to metal contact by proper packing

b) Threaded parts, high finish surfaces and slender parts must be packed very carefully to avoid damages, scratches, bulging, distortion etc.

c) Pack each batch of jobs by water proof sheet and provide identification label (Tag / Slip) with the following details.:-Customer.., Supplier..., Contr. Order No..., Part Name..., Drg. No...,Material..., RMC No.., Job Idfn. No.., Quantity.., Inspn. report No.., Inspected by (Sign).., Date.., Name.., etc.,

Chakravarthy. R	**Jose Aloysius**	**Dr. Aniyan. S**
Asst. Engineer (QC)	**D.M. (QC)**	**DGM (Q)**

BrahMos Aerospace Thiruvananthapuram Ltd. (BATL)

Thiruvananthapuram- 695007. Phone: 0471-2501325, Fax: 2500702

Dimension Inspection Report (Sub Contracted Items)

Sl. No.QR-01 ……

Date :……

(To be filled by Supplier)

Supplier : ……

Part Name : ……

Drg. No. & Rev. No : …….…… ……

Job. Idfn. Nos. : ……Qty……

.Supplier Ref. No. : ……

BATL.Purch. Ord.NO. : ……

Other ref. (if any) : ……

(To be filled by BATL only)

W. O / J.C No. : ……

Part Name : ……

Drg. No. & Rev. No : ……..

Job. Idfn. Nos : ……Qty……

Stage / Final : …….. Opn. No…….

Cust. Ord. No. : ……

Customer : ……

Sl. No.	Specification	Observation	Instrument Idn./ Remarks
	Material		
	RMC No.		
	Comp. Idfn. No.		

Inspected by :
(Supplier -**QC**) :

Inspected by :
(BATL-**QC**) :

Supplier NCR No :
BATL NCR No :

Qty. Accepted
Qty. For Concession
Qty. Rejected

VERIFIED BY :
(Supplier- QC) :

Sign & Date :

Name:

Designation :

VERIFIED BY :
(BATL- QC) :

Sign & Date :

Name :

Designation :

AUDITED BY
(BATL- QA)

Sign & Date:

Name :

Designation:

CUSTOMER SURVEYOR

Sign & Date:

Name:

Designation:

BATL.QC. F11.00

Sheet No 1.of…….

Dimension Inspection Report (Sub Contracted Items)

Contin. of Inspn. Report No. QR-01…….....Part Name : ……J/C. NO……..

Supplier Purchase Order No: ……BATL Customer Order No:……

Sl. No.	Specification	Observation	
	Comp. Idfn. No.		**Instrument Idn./ Remarks**

Inspected by(Supplier-QC) Inspected by(BATL-QC) **Customer Surveyor**

Verified by (Supplier-QC) Verified by(BATL-QC)

Contin. of F11.00. Sheet No….of…..

BrahMos Aerospace Thiruvananthapuram Ltd. (BATL)

Thiruvananthapuram- 695007. Phone: 0471-2501325, Fax: 2500702

First Off Dimension Inspection Report (Sub Contracted Items)

Sl. No.QR-01 ……

Date :……

(To be filled by Supplier)			**(To be filled by BATL only)**		
Supplier	:	……	W. O / J.C No.	:	……
Part Name	:	……	Part Name	:	……
Drg. No. & Rev. No	:	…….…… ……	Drg. No. & Rev. No	:	……..
Job. Idfn. Nos.	:	……Qty……	Job. Idfn. Nos	:	……Qty……
.Supplier Ref. No.	:	……	Stage / Final	:	…….. Opn. No…….
BATL.Purch. Ord.NO.	:	……	Cust. Ord. No.	:	……
Other ref. (if any)	:	……	Customer	:	……

Sl. No.	**Specification**	**Observation (By Supplier)**		**(By BATL QC)**	
	Material				
	RMC No.				
	Comp. Idfn. No.		**Instrument Idn./ Remarks**		**Instrument Idn./ Remarks**

Inspected by : (Supplier -**QC**) :

Inspected by : (BATL-**QC**) :

Supplier NCR No :
BATL NCR No :

Qty. Accepted
Qty. For Concession
Qty. Rejected

VERIFIED BY : **(Supplier- QC) :**
Sign & Date :
Name:
Designation :

VERIFIED BY : **(BATL- QC) :**
Sign & Date :
Name :
Designation :

AUDITED & CLEARED BY **(BATL- QA)**
Sign & Date:
Name :
Designation:

BATL.QC. F9.00

Sheet No 1.of…….

First off Dimension Inspection Report (Sub Contracted Items)

Contin. of Inspn. Report No. QR-01…….....Part Name : ……J/C. NO……..

Supplier Purchase Order No: ……BATL Customer Order No:……

Sl. No.	Specification	Observation (By Supplier)		Observation (By BATL QC)	
	Comp. Idfn. No.		**Instrument Idn./ Remarks**		**Instrument Idn./ Remarks**

Inspected by(Supplier-QC) Inspected by(BATL-QC)

Verified by (Supplier-QC) Verified by(BATL-QC)

Contin. of F9.00. Sheet No….of…..