NTPC	ITEM:(MATERIAL,CLASS,GRADE,RATING, SIZE ETC.) GALVANIZED CABLE TRAYS (Perforated & Ladder type) & ACCESSORIES	STANDARD QUALITY PLAN CONFORMING TO CODE :	QP NO. 0000-999-QOE-S-021 REV.: 1 DATE: 06.02.04 PAGE : 1 OF 1 VALID UPTO :05.02.07	REVIEWED BY A.K. Sharma Rana Vohra O.P. Niranjan	APPROVED BY ANIL GUPTA

SL. NO.	COMPONENT & OPERATIONS	CHARACTERSTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK M	QUANTUM OF CHECK C/N	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	D*	AGENCY M	AGENCY C	AGENCY N	REMARKS
1	2	3	4	5	6		7	8	9	**		10		11
	FINISHED CABLE TRAYS & ACCESSORIES	1 **In Black Condition**											-	A)The cable trays shall be galvanised at NTPC approved sources only.
		a) Weld Quality	Major	Visual	100%	Random	Manufacturer's Plant Std	Manufacturer's Plant Std	Inspection report		P		-	
		b) Burs	Major	Visual	Random		-	No Burs	-do-		P		-	B) The supplier to ensure procurement of steel from main producers like SAIL/TISCO,Rastriya Ispat/Ispat Ind. Jindal/Esser/Lloyds/IIS Co. and Zinc from Hindustan Zinc Ltd. C)Welding shall be done by qualified welders as per supplier system
		2 **After Galvanising**												
		2.1 General Physical inspection including Galvanising Quality/ Defects, Dicromating, White rusting etc.	Major	Visual	IS-4759 -1996	5 sample/lot	IS-2629-1985 IS-4759-1996	IS-2629-1985 IS-4759-1996	-do-		P	W	W	
		2.2 Dimensional check & Sheet Thickness	Major	Measur ement	-do-	-do-	NTPC/Main Supplier Approved Drawing	NTPC/Main Supplier Approved Drawing	-do-		P	W	W	D)Pre-tretment of fabricated cable trays shall be carried out in seven tank process as per IS 2629.All the process parameters e.g. Concentration, temperature, density etc. to be maintained and recorded by the Galvaniser
		2.3 Galvanising tests												
		a) Coating thickness measurement survey by Elcometer	Critical	Measure ment	-do-	-do-	IS-4759-1996 IS-3203-1982	IS-4759-1996 Table-I	-do-		P	W	W	
		b) Mass of zinc coating	Critical	Measur ment	-do-	1 coupon sample of each thickness	IS-6745-1972 IS-2633-1986	IS-4759-1996 Table - I	-do-		P	W	W	
		c) Uniformity of zinc coating/dip test	Critical	Measur ment	-do-	-do- -do-	IS-2629-1985 IS-2633-1986 IS-4759-1996	IS-4759-1996 cl. 9.3	-do-		P	W	W	E)The process of pretreatment shall be varified by NTPC on surveillance basis during Inspection of cable trays
		d) Adhesion test	Critical	Visual	-do-	-do-	IS-2629-1985	IS-2629-1985	-do-		P	W	W	*F* One piece each of 2.5 meter length size of cable tray of 300 mm & above shall be taken as sample from each offered lot for inspection. It shall be supported at both ends & loaded with uniformly distributed load of 76kg/ meter along the length of cable tray. The maximum deflection at mid span of each sample shall not exceed 7mm.
		2.4 Deflection Test	Critical	Measu rement	1 sample from each size type/ lot	1 sample from each size type/ lot	*F*	*F*	-do-		P	W	W	

LEGEND: RECORDS IDENTIFIED IDENTIFIED WITH "TICK" SHALL BE ESSENTIALLY INCLUDED BY THE CONTRACTOR IN QA DOCUMENTATION

** M: MANUFACTURER/SUB-SUPPLIER, C:CONTRACTOR/NOMINATED INSPECTION AGENCY. N: NTPC. INDICATE "P" PERFORM "W" WITNESS AND "V" VERIFICATION AS APPROPRIATE

"CHP" BY NTPC SHALL BE IDENTIFIED IN COLUMN "N" AS "W".