



**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**  
**QUALITY ASSURANCE PLAN FOR BRUSH HOLDER CLAMP TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO**

QUALITY PLAN NO. - QAP/QTM/VENDOR QAP/2020-21/BRUSH HOLDR CLAMP DTD 16.02.2021 REV 00  
 Reference Document- PO DRAWING/SPECIFICATION

Page : 1 of 1

Sl. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP/A					
1)	Raw material	All tests	TC verification	100%	100%	AA10108	As per drawing & Specification	MTC	BHEL/TP/A	TEST LAB NAME/EQUIVALENT ACCREDITED/SOURCE MILL/Supplier to get the raw material correlated with material TC
2)	Dimension	Dimension	TC verified & Measurement	100%	20%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
3)	Testing	Routine test	TC verified & testing	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
4)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
5)	Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification		BHEL/TP/A	Packing to be such that no damages should occur during transit

210375/2021/HEP-QTM380

Prepared By

*(Signature)*  
 Sr. Engineer / Quality Control-Clt  
 BHEL, BHOPAL

Approved By

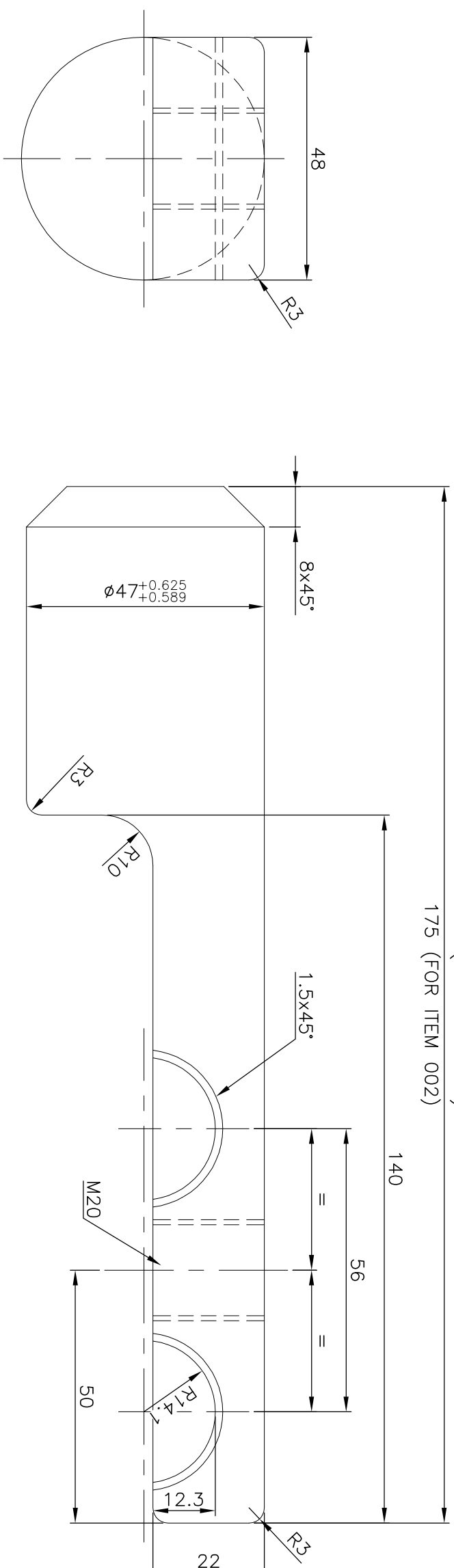
*(Signature)*  
 Sr. Engineer / Quality Control-Clt  
 BHEL, BHOPAL

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FIRST ANGLE PROJECTION

500 08 02 634 3.0N .DRD

(ALL DIMENSIONS ARE IN mm)



- NOTES:-**
1. MACHINE ALL OVER.
  2. ALL SHARP CORNERS AND EDGES MUST BE REMOVED.
  3. SLOT SHOULD HAVE SMOOTH FINISH AND PARALLEL WITH ONE END PERPENDICULAR TO THE OTHER AXIS WITHIN 0.2MM.
  4. DEPTH OF SLOTS TO BE MAINTAINED EQUAL WITHIN 0.2MM.

TOOL LIST		
IT.NO.	TOOL NO.	DESCRIPTION
	1574639	FORM MILLING CUTTER
	1574640	DRILL JIG FOR 1 HOLE

REV.	DATE	ALTERED	CHECKED	APPROVED	RBV	QTY	VAR 00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DIS	DRAWING NO.	IT.NO.	VAR.	MATL. CODE	MATL. SPCN.	UNIT WT.	QTY.	NO. OF	ZONE
59	64	65	75	78	79	25	27	29			CLAMP 50 SQ.x175					AA10108		1.5			
											CLAMP 50 SQ.x205	1				AA10108		2.0			

**ADDITIONAL INFORMATION**

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

TME-1, TXM-3,  
TNX-1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  
**TM4303BY, DY**  
**25 KV BG AC EMU & 1400 HP DEMU**



**BHARAT HEAVY ELECTRICALS LTD.**  
**BHOPAL**

DRN.	RBV	SIGN	DATE	NO. OF
		-sd-	03/02/01	VAR.
CHD.	DK	-sd-	03/02/01	
APPD.	NNN	-sd-	03/02/01	

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

REV.	DATE	ALTERED	CHECKED	APPROVED	RBV
03	16.12.14				DK
ZONE					NNN

REV.	DATE	ALTERED	CHECKED	APPROVED	RBV
02	06.08.01				DK
ZONE					NNN

DEPT. TIME	UNTOL. DIMS. GR.	SCALE	WEIGHT (K.G.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF
405		NTS		0 439 31 80 001	015,016	002
TITLE				DRAWING NO.		REV.
<b>BRUSH HOLDER CLAMP</b>				<b>3 439 20 80 005</b>		03
MODIFIED				SHT. NO.	01	NO. OF SHT.
						01