


		<b>SUPPLIER'S NAME AND ADDRESS:</b> BHEL, CFP RUDRAPUR		<b>FIELD QUALITY PLAN</b>				<b>PROJECT</b> : VINDHYACHAL STPP STAGE-V (1X500 MW)			
				<b>ITEM : SEGREGATED PHASE BUSDUCT</b>		<b>QP NO.:</b> BHE/RU/QP/SP/NTPC/VSTPP <b>REV. NO.:</b> 00 <b>DATE:</b> 14.05.2014 <b>PAGE:</b> 1 of 2		<b>PACKAGE</b> : BUSDUCT <b>CONTRACT NO.</b> : CS-2260-207-2-FC-COA-5910 DT 26.04.2013 <b>MAIN-SUPPLIER</b> : BHEL			
SL. NO	ACTIVITY AND OPERATION	CHARACTERISTICS / INSTRUMENTS	CLASS OF CHECK #	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		REMARKS
					BHEL	CUSTOMER					
1.	2.	3.	4.	5.	6.		7.	8.	9.	D*	10.
1	CHECKS ON ARRIVAL AT SITE	Unloading with use of strap belt	C	V	100%	---	Erection Manual	---	---		Approved Drawings and Approved data sheet will be available with site to kick start erection activities.
2		Check for damages (puncture, bend, scratch etc)	C	V	100%	---		---	Site register / Site MDR		
3		CHECKS DURING STORAGE	Ensure that busduct should not be laid directly on ground	C	V	100%		---	---	---	
4	Ensure that BOIs, hardware, copper, electrical items etc are stored in concealed areas		C	V	100%	---		---	---		
5	CHECKS DURING ERECTION & COMMISSIONING (contd...)	Dimensional checking of foundation (Tape)	B	M	100%	---	Drawing	Drawing	Handing over protocols from Civil		Before erection of the structure
6		Layout of Bus Ducts (Tape)	B	M	100%	---	Drawing	Drawing			
7		Check the equipment for their physical condition and cleanliness	C	V	100%	---	---	---			
8		Verticality of structure (plumb bob)	A	M	100%	Random	Drawing	Drawing			
9		Ensure enclosures are properly aligned.	A	V	During erection	During erection	Drawing	Drawing	IR & erection protocols		
10		Check physically insulators after fixing busbars in the Adopter box.	B	V	100%	5%	Crack free clear insulator surface	IS 9431			
11		Clearance between phase conductor and enclosure after connection of disconnecting link	B	M	100%	5%	Drawing	Drawing		% age of joints for each run of IPBD	
12		Tightening of bus bar bolted joints to specified torque (Torque wrench)	B	M	100%	5%	Erection manual	Erection manual	erection protocol		
13		Positioning of rubber bellows	C	V	100%	---	Drawing	Drawing			

		<b>LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION.</b> <b>LEGEND TO BE USED: CLASS # : A = CRITICAL, B=MAJOR, C=MINOR;</b> <b>'A' SHALL BE WITNESSED BY NTPC FQA, 'B' SHALL BE WITNESSED BY NTPC ERECTION / CONSTRUCTION DEPTT. AND 'C' SHALL BE WITNESSED BY MAIN SUPPLIER (A &amp; B CHECK SHALL BE NTPC CHP STAGE)</b> <b>V=VISUAL, M=MEASUREMENT, T=TESTING.</b>	<b>DOC. NO.:</b>		<b>REV: 00</b>	
<b>MANUFACTURER/ SUB-SUPPLIER</b>	<b>MAIN-SUPPLIER</b>					
<b>SIGNATURE</b>		<b>FOR NTPC USE</b>	<b>REVIEWED BY</b>	<b>APPROVED BY</b>	<b>APPROVAL SEAL</b>	

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		<b>SUB-SYSTEM:</b>						<b>MAIN-SUPPLIER</b> : BHEL			
14		Checks that all wiring is done as per wiring diagram	B	V	100%	Once	Wiring diag.	Wiring diag.			
15	CHECKS DURING ERECTION & COMMISSIONING	IR value of each bus conductor before erection (2.5 KV Insulation Tester)	A	T	100%	10%	IS 8084	IS 8084		✓	
16		Specified size of Gaskets being used	C	V	Once	---	Drawing	Drawing			✓
17		Setting of thermostats	Ⓜ	M	100%	---	Erection manual	Erection manual		✓	
18		High Voltage testing of Busduct at specified voltage for each route (HV Test kit)	A	T	Once	Once	Erection manual	IS 8084	Testing Protocol	✓	Once for each route after erection

All Checks

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SIGNATURE				FOR NTPC USE	REVIEWED BY	APPROVED BY	APPROVAL SEAL