

MANUFACTURER'S NAME AND ADDRESS			QUALITY PLAN				TO BE FILLED BY BHEL  Page 1 of 2		TO BE FILLED BY BHEL						
BHEL	VENDOR'S NAME	ITEM	Copper Strip / Rod	QP NO.	QA/CF/QP/402										
		REV		02											
		DRG. NO.	AS PER PO												
		SPEC.	AA12001 Rev. 04 / AA12022 Rev. 05/ AA12023 Rev. 08, AA12007 Rev. 04, AA12008 Rev. 05												
SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS		CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS		FORMAT OF RECORDS		AGENCY			REMARKS
										M	B	N			
1	2	3		4	5	6	7	8		9	D	10			11

<b>1.0</b>	<b>Raw Material</b>													
1.1	Review of Raw material TCs	Chemical	Critical	Review & Physical verification of MTCs	100%	BHEL Spec	BHEL Spec	TC	√	P	V			
1.2	Melting(ETP grade)	Chemical	Critical	Chemical Analysis	Each Heat	BHEL Spec	BHEL Spec	TC	√	P	V			
<b>2.0</b>	<b>In process Stage</b>													
2.1	Drawing / Extrusion	Visual & dimension	Major	Physical	100%	Vendor's Internal Procedure/ Norms	Vendor's Internal Procedure/ Norms	Internal records	√	P	V			
2.2	Annealing	Time Temperature	Critical	Time –Temp. Control	100%	BHEL Spec	BHEL Spec	HT chart Record	√	P	V			
<b>3.0</b>	<b>Final inspection(Before starting final inspection, calibration of the measuring instruments to be checked)</b>													
3.1	Chemical properties	Grade, composition	Critical	Chemical Analysis	1 sample per size per melt per consignment of 3 tonnes	BHEL Spec	BHEL Spec	TC	√	P	W			
3.2	Mechanical testing	Tensile Strength,	Critical	Mechanical	1 sample per size per melt per consignment of 3 tonnes	BHEL Spec	BHEL Spec	TC	√	P	W			
		Elongation	Critical	Mechanical		BHEL Spec	BHEL Spec	TC	√	P	W			
		Hardness	Critical	Mechanical		BHEL Spec	BHEL Spec	TC	√	P	W			
		Bend Test	Critical	Mechanical		BHEL Spec	BHEL Spec	TC	√	P	W			

		<b>LEGEND:</b> ! RECORDS IDENTIFIED WITH 'TICK' SHALL BE ESSENTIALLY INCLUDED BY CONTRACTOR IN QA DOCUMENTATION. M: MANUFACTURER / SUBCONTRACTOR    B: BHEL / NOM. INSPECTION AGENCY N: CUSTOMER INDICATE 'P' PERFORM 'W' WITNESS AND 'V' VERIFICATION ALL 'W' INDICATED IN COLUMN 'N' SHALL BE 'CHP' OF CUSTOMER	FOR CUSTOMER USE	
MANUFACTURER/SUBCONTRACTOR				APPROVED BY

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		Edgewise Bending(if called in BHEL spec)	Critical	Mechanical		BHEL Spec	BHEL Spec	TC	√	P	W		
3.3	Electrical Testing	Electrical resistivity	Critical	Electrical	1 sample per size per melt per consignment of 3 tonnes	BHEL Spec	BHEL Spec	TC	√	P	W		
3.4	Visual & Dimension check	Visual & Dimensional including surface finish, straightness, Length/ Width/ Diameter, tolerance etc	Critical	Visual & Physical	100%	BHEL Spec	BHEL Spec	TC	√	P	W*		*random 10%
4.0	<b>Identification Marking</b>		Major	Visual & physical verification	100 %	BHEL Spec	BHEL Spec	TC	√	P	W*		*random 10%
4.1	<b>Packing</b>		Major	Visual & physical verification	100 %	BHEL Spec	BHEL Spec	TC	√	P	V		

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