



# **BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL** **QUALITY ASSURANCE PLAN FOR ROTOR BAR TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO**

**QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2022-23/ROTOR BAR DTD REV 00 DTD 20.12.2022**

**Reference Document- PO DRAWING/SPECIFICATION**

Page : 1 of 2


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	a) Chemical properties c) Mechanical properties c) oxygen content d) Temper condition (H02)	TC verification	100% (VR)	100% (VR)	As per specification	As per specification	MTC	BHEL/TP/A	RAW MATERIAL TC to be co-related to finished material and to be verified by TP/A
2)	Dimension	Dimension	Measurement	20%	5% (w)	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % TC verified by TP/A and 5 % TC Witnessed by TP/A to be submitted
3)	Visual check	Free from any piping, crow feet, indentations, foreign particles or inclusion, surface defect, Twists & entanglements	Visual	100%	5% (w)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	

**Prepared By**

*Signature*  
 Sr. Engineer, QCC  
 Quality Control Dept.  
 BHEL, Bhopal

**Approved By**

*Signature*  
 Sr. Manager  
 Quality Control Division  
 BHEL, Bhopal

	<b>BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL</b> <b>QUALITY ASSURANCE PLAN FOR ROTOR BAR TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO</b>									
	<b>QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2022-23/ROTOR BAR DTD REV 00 DTD 20.12.2022</b> <b>Reference Document- PO DRAWING/SPECIFICATION</b>									
	Page : 2 of 2									

4)	Testing on finished bar	Chemical properties	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL. If Testing not done at NABL lab then same shall be witnessed by TPIA at vendor works.
		Mechanical properties	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPIA	
		Electrical properties	Testing	One sample per lot at NABL LAB & 100 % by supplier	100 % RR & 1% witness	As per specification	As per specification	Supplier record	BHEL/TPIA	
		NDT testing: 2) Ultrasonic testing/Eddy current testing (only if mentioned in drawing/specification.)	Testing	1 % per lot at NABL lab OR government approved LEVEL II operator at vendor works	1% witness	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL

Prepared By  Rajendra Singh Rathour Sr. Engineer (QAP) Quality Control	Approved By  RAHUL TOPPO Sr. Engineer / Manager QA/QC / QTM Division BHEL, Bhopal
---	---



5)	Identification vendor name, PO & job serial no.,	Visual	Visual	100%	10% witness	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
6)	Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TP/A	Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box

**Prepared By**

**Q.21**  
Gajendra Singh Rathour  
Sr. Engineer (C)  
Quality Control  
BHEL, Bhopal

**Approved By**

**RAHUL TIPS**  
प्रबंधक / Manager  
राष्ट्रीय निर्माण / OTM Division  
व्यापारिक प्रभाग / BHEL, Anapodi  
बि. एच. ई. एस.