



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 22.03.2022
Reference Document- PO DRAWING/SPECIFICATION

Page : 1 of 3

S L N O	COMPONENT	CHARACTERIS TICS	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 b) Oxygen content	TC verification	100%	100%	As per specification	As per specification	MTC	BHEL/TP/A	SOURCES MENTIONED IN SPECIFICATION. RAW MATERIAL TC to be co-related to finished material and to be verified by TP/A
2)	Dimension	Dimension	Measurement	20%	5 nos bar per lot (witness)	As per the drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	
3)	Visual check	Free from any piping, crow feet, indentations, foreign particles or inclusion, surface defect. Twists & entanglements	Visual	100%	5 nos bar per lot (witness)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	

Prepared By

गजेन्द्र सिंह राथोर / G.S. RATHORE
क्यूटीएम विभाग / Dy. Manager
QTM Division
बी.एस.ई.एल., भोपाल/B.H.E.L., BHOPAL

Approved By



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 22.03.2022
Reference Document- PO DRAWING/SPECIFICATION

Page : 2 of 3

4) Testing on finished bar	i. Chemical properties	Testing	one sample per lot	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 as per specification.
	ii. Mechanical properties a) Tensile strength b) proof strength c) Elongation	Testing	one sample per lot and additionally NABL lab TC is required if lot quantity is more than 500 bars.	Once per heat/heat treatment batch (witness)	As per specification	As per specification	Supplier record	BHEL/TPIA	*2 no. Test samples per batch/heat to be submitted to BHEL duly verified by TPIA as per specification.
	iii. Electrical properties a) Electrical Conductivity	Testing	100%	5 bars per lot (witness)	As per specification	As per specification	Supplier record	BHEL/TPIA	

Prepared By

गजेंद्र बिहारी / G.S. RATHORE
उप-प्रबंधक / Dy. Manager
वस्तु, टी.एम. विभाग / QTM Division
बी.एस.ई.एल., भोपाल / BHEL, BHOPAL

Approved By

गजेंद्र बिहारी / G.S. RATHORE
उप-प्रबंधक / Dy. Manager
वस्तु, टी.एम. विभाग / QTM Division
बी.एस.ई.एल., भोपाल / BHEL, BHOPAL



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 22.03.2022
Reference Document- PO DRAWING/SPECIFICATION

Page : 3 of 3

	iv. Grain Size	testing	Once per heat/heat treatment batch	RR	As per specification	As per specification	Supplier record	BHEL/TPIA	
5)	Visual	Visual	100%	2% witness	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TPIA	
6)	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TPIA	Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box

Abbreviations: W-Witness, RR-record review, TPIA-Third party inspection agency, TP=Task performer,

Prepared By

गजेंद्र सिंह राथोर / G.S. RATHORE
 प्रबंधक / Dy. Manager
 वस्तु, टी.एम. विभाग / QTM Division
 बी.एस.ई.एल., भोपाल / BHEL, BHOPAL

Approved By

अनिल टोप्पो
 प्रबंधक / Dy. Manager
 वस्तु, टी.एम. विभाग / QTM Division
 बी.एस.ई.एल., भोपाल / BHEL, BHOPAL