



**QUALITY ASSURANCE PLAN FOR TEMPERATURE SENSOR ASSEMBLY TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO**

QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2022-23/ TEMPERATURE SENSOR ASSEMBLY DTD 09.08.2021 REV 00  
Reference Document- PO DRAWING/SPECIFICATION

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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 items mentioned in specification & drawing)	All tests	TC verification	100%	RR	As per Specification	As per Specification	MTC	BHEL/TP/A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL as per drawing or specification /Supplier to get the raw material TC correlated with material TC
2)	Dimension	Dimension	Measurement	100%	10% (W)	As per relevant drawing	As per relevant drawing	Supplier record	BHEL/TP/A	
3)	Testing	a) Resistance measurement at room temperature (RTD element)	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TP/A	
		b) Short time resistance in Oil	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	

Prepared By

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**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**  
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				TP	TP/A					
		c) High voltage test at 1.5 KV, 50HZ for 1 min.(RTD Element)	Testing	100%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	
		d) Drop test	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	
		e) IR test (RTV element)	Testing	100%	5% (W)	As per specification		Supplier record	BHEL/TP/A	
		f) Lead pulling test	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	

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				TP	TPIA					
		g) IR test (On cable with connector)	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TPIA	
		h) Continuity test	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TPIA	
4)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10% (W)	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TPIA	
5)	Packing to avoid transit damage	Visual	Visual	100%	20% (W)	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

RR: RECORD REVIEW X, W: WITNESS, TP: THIRD PARTY INSPECTION AGENCY, TP: TASK PERFORMER

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