



**BHARAT HEAVY ELECTRICALS LTD, BHOPAL**

**QUALITY CONTROL-FYM**

Form No. QFD/FYM/21-22/01  
Issue Date : 15/03/2022  
Rev-00

Quality Plan & Quality Checklist for H-Compact Stator Frame  
(To be filled for each casting)

1.0 Inspection Details:

Sr No. (1)	Characteristics (2)	Type of Check (3)	Reference Document/Specification	Quantum of Check	Requirement	Activity		Reference of Test Report & Observed Value (4)	TPIA Remark (OK/Not Ok/Any other Information (5)	Documented To be enclosed
						M	T			

2.3 Checks for Casting Defects:

2.3.1	Blow Holes & Pin Holes	Visual	AA19702 Rev 07, Clause 8 & 9	100%	There shall be no Blow Holes & Pin Holes	W	W			VERIFICATION RECORDS
2.3.2	Cold shut, Shrinkage	Visual			There shall be no cold shut, Shrinkage.	W	W			
2.3.3	Sand Inclusion	Visual			There shall be no Sand Inclusions.	W	W			
2.3.4	Porosity & Cracks	Visual			There shall be no Porosity & Cracks	W	W			
2.3.5	Finishing of Ribs	Visual			To be checked Visually	W	W			

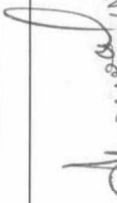
Note: M: Manufacturer, T: TP/A, P: Perform, V: Verification of Records, W: Witness

2.0 Identification of Casting:

Pattern No.	Drg No.	Casting No.
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3.0 Details of Rework Done (if any):

4.0 Final Remark by TP/A:

  
अनुराग मिश्रा / ANURAG MISHRA  
प्रबंधक / Manager  
आयुक्त / QFD Division  
भारत भारती भारती / B.H.E.L., BHOPAL

Date & Place of Inspection:

Signature & Seal of TP/A Representative



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**1.0 Process Checks:**

1.1	Metal Analysis	Chemical	AA19702 Rev 07	Each Heat	Following Chemical Compositions to be recorded and TC to provided required i) Carbon (%) ii) Silicon (%) iii) CE(%)	P	V			TC
1.2	Molten Metal Temperature	Measure	--	Each Heat	To be Recorded & reported	P	V			Record
1.3	Pouring Temperature	Measure	--	Each Casting	To be Recorded & reported	P	V			Record
1.4	Tensile Strength	Mechanical	AA19702 Rev 07, Clause 12.1	Each Heat (As per spec)	Required Value: 200 N/mm <sup>2</sup> Min.	P	W			TC

**2 Casting (product) checks:**

2.1	Hardness	Mechanical	AA19702 Rev 07, Clause 12.2	100%	Required Value:160 to 220 HB	P	W			TC
2.2	Dimensional Check	Measure	AA19702 Rev 07, Clause 5/ Drawing	100%	As per spec.	P	W			Report

*Anurag Jaishwal*  
प्रबंधक / Manager  
एफ. डी. डिभाग / QFD Division  
बी.एच.ई.एल., भोपाल / B.H.E.L., BHOPAL



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Pattern No.

Drg No.


Casting No.

**3.0 Details of Rework Done (if any):**

**4.0 Final Remark by TPIA:**

Date & Place of Inspection:

Signature & Seal of TPIA Representative



अनुराग जायसवाल / ANURAG JAISWAL  
प्रबंधक / Manager  
QFD Division  
दयू. एफ. डी. विभाग / QFD Division  
बी.एच.ई.एल., भोपाल / B.H.E.L., BHOPAL

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# BHARAT HEAVY ELECTRICALS LTD, BHOPAL

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ANURAG JAISWAL / Manager  
 DE (RR) / QFD Division  
 BHOPAL