



# QUALITY ASSURANCE DEPARTMENT

QA PLAN FOR -DGL POLYESTERIMIDE VARNISH BONDED RECTANGULAR COPPER CONDUCTOR TO AA28113

SH. 01 OF 01

QA PLAN NO. - QA/HG/552 dt. 11.07.2018 , REV-00

S. NO.	COMPONENT /OPERATION	CHARACTERISTICS	CLASS	TYPE	QUANTUM OF CHECK	REF. DOC.	RECORD FORMAT	AGENCY		REMARKS
								PERFORM	WITNESS	
1	Source of Raw material	ETP grade copper to AA12024	Major	Review	100%	As per AA 28113	TC	-	-	Record review by BHEL / TPI
2	Chemical composition	composition of copper	Major	Review	100%	As per AA 28113	TC	-	-	Record review by BHEL / TPI
3	Bare Conductor	Witnessing of test for :								
		i) Visual, Dimension and Tolerance	Major	Physical	sample	As per AA 28113	TC	Supplier	BHEL /TPI	There should be no sharp, rough and projected edges.
		ii) Radius on corners	Major	Physical	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		iii) Tensile Strength & Elongation	Major	Mechanical	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		iv) Hardness (Vickers)	Major	Mechanical	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		v) Electrical resistivity	Major	Electrical	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
4	Glass Covering	Visual	Major	Check	Random	As per AA 28113	TC	Supplier	BHEL /TPI	There should be no tackiness, resin lumps on the conductor. Glass lapping should be smooth, uniform with no visibility of copper.
5	Glass covered varnish bonded conductor	i) Flexibility test (as received condition)	Major	-	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		ii) Flexibility after heat ageing	Major	-	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		iii) Adherence test	Major	-	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		iv) Cure test	Major	-	sample	As per AA 28113	TC	Supplier	BHEL /TPI	
		v) Breakdown voltage test	Major	-	sample	As per AA 28113	TC	Supplier	BHEL /TPI	

Certification : Supplier shall furnish 5 copies of Test certificates only countersigned by BHEL / TPI for the above tests.

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11/7/18  
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