



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY PLAN FOR NON-IMPREGNATED, DENSIFIED LAMINATED WOODEN RINGS PRODUCED FROM BEECH VENEER TO GRADE T2R & T4R OF IEC:61061-3-2
Q.A. PLAN No. : QA/TCB/BO/14/REV. : 00 DT. : 03/02/2018

Sl. No	Parameters/Characteristic	Type of check	Quantum of check	Reference document and Acceptance Norms	Format of Record	Inspection Scope		
						P	R	W
1	Thickness, Diameter, Visual for all sharp corners shall be rounded off and ring shall be in a single piece, i.e. without any joints	Dimensions/ Visual	100%	IEC 61061-2/ IEC:61061-3-2	Dimension Report	2	1	1
2	Flatness	Measurement	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
3	Apparent density	Physical and chemical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
4	Moisture content	Physical and chemical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
5	Oil absorption	Physical and chemical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
6	Flexural Strength perpendicular to lamination	Mechanical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
7	Modulus of Elasticity perpendicular to the laminations	Mechanical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
8	Compressibility perpendicular to the laminations	Mechanical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
9	Impact strength perpendicular to laminations	Mechanical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
10	Shearing strength test for glue line bond applicable for thicknesses equal to or greater than 20 mm.	Mechanical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
11	Electric strength and breakdown voltage	Electrical tests	Test specimens as per IEC 61061-2	IEC 61061-2/ IEC:61061-3-2	Test Report	2	1	1
12	Packing and identification	weather-proof packing and for foreign supplies sea-worthy/ moisture proof packing	---	-----	-----	2	1	1

Legends: 1. BHEL/TPIA 2. Manufacturer QC/ Lab or External Lab, R= Reviewed by, P = Performed by, W = Witnessed

Note: In case of Foreign Vendors, material shall be inspected at BHEL works. However, Test report shall be furnished along with each lot.

Prepared by

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(QA/TCB)

Approved by

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