



PRODUCT STANDARD

SWITCHGEAR ENGINEERING DIVISION

SG15214
REV00

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QUALITY ASSURANCE PLAN FOR EPOXY INSULATOR FOR MEDIUM VOLTAGE SWITCHGEAR

Sl.No	MATERIAL / ASSEMBLY	CHARACTERISTICS	CLASS / CATEGORY	TYPE OF CHECK	QUANTITY OF CHECK	REF. DOCUMENT	RECORD FORMAT	AGENCY	REMARK / CUST. REQ.
1	Raw Material								
	Epoxy Resin	a) VISUAL	B	V	100% Lot-wise	BS3816/IS:9431	SUPPLIER'S TC	MFR	CHP
		b) Viscosity	B	T	100% Lot-wise	BS3816/IS:9431	SUPPLIER'S TC	MFR	CHP
		c) Epoxy Value	B	T	100% Lot-wise	BS3816/IS:9431	SUPPLIER'S TC	MFR	CHP
		d) Density	B	T	100% Lot-wise	BS3816/IS:9431	SUPPLIER'S TC	MFR	CHP
	Inserts(Brass/Steel)	a) VISUAL	B	V	100%	Manufacturer Drg	SUPPLIER'S TC	MFR	CHP
		b) Material Testing	B	T	SAMPLING	Manufacturer Drg	Test report	MFR	CHP
		c) Dimension Check	B	T	SAMPLING	Manufacturer Drg	SUPPLIER'S TC	MFR	CHP
2	Assembly								
	Insulator	a) VISUAL, marking of traceability details as per drg	C	M	100%	As Per BHEL DRG/SPEC	SUPPLIER'S TC	MFR	
		b) Dimension Check	A	T	100%	As Per BHEL DRG/SPEC	SUPPLIER'S TC	MFR	CHP
		c) Type Test (cantilever load & HV test)	A	T	SAMPLING	As Per BHEL DRG/SPEC	Test Lab reports	NABL accredited	CHP
		d) Acceptance Test (Flatness of parallel surfaces checking as per Drg)	A	T	SAMPLING	As Per BHEL DRG/SPEC	Test Lab report	MFR	CHP
KEY TO SYMBOLS:- A = CRITICAL B = MAJOR C = MINOR M = MEASUREMENT T = TEST V = VISUAL									
NOTE :									
1) TCS & INTERNAL INSPECTION REPORT SHALL BE PROVIDED TO BHEL ALONG WITH EACH SUPPLIED LOT.									

Revisions:

ALTD:
APPD:

Date:

PRINTS TO:- MM (SCR) -1, SWM (Plg) -1

Approved: H. R Patel

Prepared:
AD

Issued:
NM

Date:08.07.19

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PI Qty Calculation sheet (120930222)

PI ITEM NO.		1	2	3
ITEM DESCRIPTION :		SUPPORT INSULATOR (75 DIA) WITH BRASS INSERTS TO DRG. NO. 15211001515-014, REV.28.	SUPPORT INSULATOR (95 DIA) WITH BRASS INSERT TO DRG. NO. 15211001515-015, REV.28.	SUPPORT INSULATOR (100 DIA) WITH BRASS INSERT TO DRG. NO. 15211001515-016, REV.28.
MATERIAL CODE :		BP9069475138	BP9069475146	BP9069475154
NAME OF THE PROJECT / PRODUCTS / ASSEMBLY		Stock Item for All Indoor Projects		
QTY PLANNED for FY 23-24, 24-25 & 25-26 (For Rate Contract)	(A)	45370	6496	6935
QTY AVL IN SHOP	(B)	0	0	0
QTY AVL IN STORE	(C)	0	496	935
PENDING PI	(D)	0	0	0
PENDING PO QTY + CRX	(F)	9370	0	0
PENDING ENQUIRY QTY	(G)	0	0	0
TOTAL AVAILABILITY	(H) =(B+C+D+F+G)	9370	496	935
BALANCE REQUIRED	(A - H)	36000	6000	6000
QTY IN THIS PI		36000 Nos.	6000 Nos.	6000 Nos.