



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY ASSURANCE PLAN FOR ROTOR BAR TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. - QAP/QTM/VENDOR QAP/2021-22/ ROTOR BAR DTD 07.09.2021 REV 01 DTD 12/03/2022
 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	a) Chemical properties b) Specific gravity c) Temper condition d) Oxygen content	TC verification	100% (VR)	100% (VR)	As per specification	As per specification	MTC	BHEL/TP/A	SOURCES MENTIONED IN SPECIFICATION RAW MATERIAL TC to be co-related to finished material and to be verified by TP/A
2)	Dimension	Dimension	Measurement	100%	20% (W)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	100 % TC verified by TP/A and 20 % TC Witnessed by TP/A to be submitted
3)	Visual check	Free from any pores, cracks, pits, indentations, foreign particles or inclusion, surface defect, twists & entanglements	Visual	100%	5% (W)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	

Prepared By

Approved By



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	Chemical properties a) Cu + Ag b) Zn c) oxygen content	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL
	Mechanical properties a) Tensile strength b) Yield strength c) Elongation d) Hardness	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPA	
	Electrical properties a) Electrical Conductivity	Testing	One sample per lot at NABL LAB & 100 % by supplier	RR & 1% witness	As per specification	As per specification	Supplier record	BHEL/TPA	
4)	Testing on finished bar	Testing	10 % per lot at NABL lab OR government approved LEVEL II operator at VENDOR WORKS	1% witness	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL

Prepared By

G. V. S. S.

Approved By

[Signature]

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4)	Identification Vendor name, PO & job serial no., Hardware fitment	Visual	Visual	100%	10% witness	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TPA	Witness
5)	Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TPA	Witness Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box

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