



**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**  
**QUALITY ASSURANCE PLAN FOR TEMPERATURE SENSOR ASSEMBLY TO BHEL ORDERING**  
**SPECIFICATION/DRAWING AS PER PO**

QUALITY PLAN NO. – QAP/QT/M/VENDOR QAP/2021-22/ TEMPERATURE SENSOR ASSEMBLY DTD 27.09.2021 REV 00  
 Reference Document- PO DRAWING/SPECIFICATION

Page : 1 of 3

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 ( All Items mentioned in specification & drawing)	All tests	TC verification	100%	RR	TM10421	As per Specification	MTC	BHEL/TP/A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL as per drawing or specification /supplier to get the raw material TC correlated with material TC
2)	Dimension	Dimension	Measurement	100%	10% (W)	As per relevant drawing	As per relevant drawing	Supplier record	BHEL/TP/A	
3)	Testing	a) Resistance measurement at room temperature (RTD element)	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TP/A	
		b) Short time resistance in Oil	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	

Prepared By

Approved By

Prepared By  
 Mr. Sandeep Singh Rathour  
 Sr. Engineer (QAP)  
 Quality Control Cell  
 BHEL, BHOPAL

Approved By  
 Mr. F.A. TOPPO  
 Addl. General Manager  
 Quality Assurance / QTM  
 BHEL, BHOPAL



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				TP	TP/A					
		c) High voltage test at 1.5 KV, 50HZ for 1 min.(RTD Element)	Testing	100%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	
		d) Drop test	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	
		e) IR test (RTV element)	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TP/A	
		f) Lead pulling test	Testing	5%	RR	As per specification	As per specification	Supplier record	BHEL/TP/A	

Prepared By  
राजेश सिंह राठौर / Rajesh Singh Rathore  
रा.प्र.प.व.रा. / R.P.P.V.R.  
गर्. आ.प्र.प.व.रा. / G.R.A.P.P.V.R.  
गु.आ.प्र.प.व.रा. / G.U.A.P.P.V.R.  
गु.आ.प्र.प.व.रा. / BHEL, BHOPAL

**Approved By**

Approved By  
Dante  
8/3/2021  
F.A. TOPPO

अपर महाप्रबन्धक / **Q10**  
**व्य. टी. एम. / Q10**  
 जी.एच.ई.एल. भोपाल / **BHEL, BHOPAL**



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		g) IR test (On cable with connector)	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TP/A	
		h) Continuity test	Testing	100%	5% (W)	As per specification	As per specification	Supplier record	BHEL/TP/A	
4)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10% (W)	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	
5)	Packing to avoid transit damage	Visual	Visual	100%	20% (W)	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TP/A	Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box

RR: RECORD REVIEW, W: WITNESS, TPIA: THIRD PARTY INSPECTION AGENCY, TP: TASK PERFORMER

Prepared By

**Approved By**

गोविंद राव गोविंदराव सिंग राठौर  
भरि, अधिकारी (प्र.सं.सं.) / & Engineer (PFD)  
गुणवत् नियंत्रण विभाग (प्र.सं.) / Quality Control-CIM  
डी.एच.ई.एल., भीमल / BHEL, BHOPAL

एफ.ए.टी.एम. Add. General Manager  
अपर महाप्रबंधक (Add. General Manager)  
वस्तु, टी.एम. विभाग (QTM Division)  
बी.एम.ई.एल. भोपाल (B.M.E.L. Bhopal)