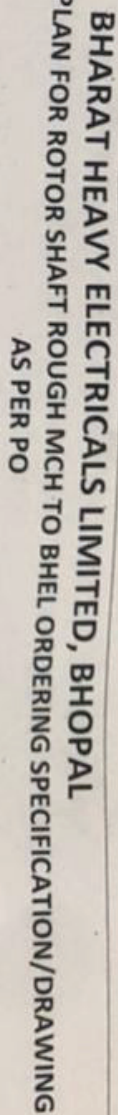


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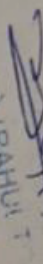
SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	REMARKS
				TP	TP/A				
1)	Raw Material test a) Mechanical properties b) Chemical composition	All tests	TC verification	One sample/heat treatment batch/heat/lot	100%	As per drawing & specification	As per Specification	MTC -	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL NOTE :Extra length to be furnished in one shaft as per specification
2)	Heat Treatment	Soaking temperature/soaking time	TC verification	100%	100%	As per drawing & specification	As per drawing & Specification	TC	Heat treatment graph to be provided to BHEL
3)	Hardness test	Routine test	TC verification & testing witness	100% shaft	100% & 10%	As per drawing & specification	As per drawing & Specification	TC	Witness by portable hardness tester
4)	Reduction ratio	Reduction ratio from ingot to bloom & bloom to blank	TC verification	100%	100%	As per drawing & specification	As per drawing & Specification	TC	Stage wise reduction & its measurement on actual job

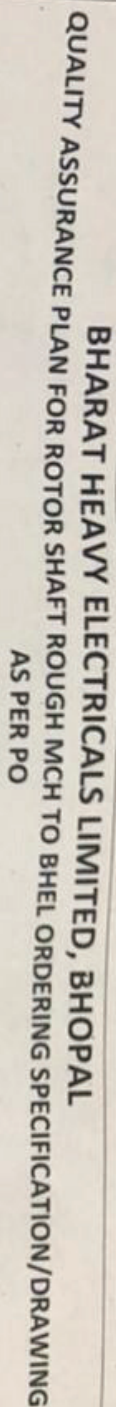
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TP- Task Performer, TC-Test Certificate, TPIA- Third party inspection Agency,

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