

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY CONTROL TRANSPORTATION
QUALITY ASSURANCE PLAN(QAP)


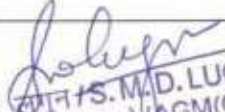
QA PLAN NO. : QTM/TXM/VENDOR/QAP/2017-18/TM/GEAR CASE ASSY. DT. 13.11.2017 REV 00
REFERENCE- DRAWING OF GEAR CASE ASSY. OF TRACTION MOTOR

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS		
				TP	TPIA					
1.0	DP Test	A	W	100%	10%	As per Drg./Part Drg.	SR	Report to be submitted		
2.0	Stress relieve, Shot blasting	A	VR	100%	100%	As per Drg./Part Drg.	SR	Report to be submitted		
3.0	Oil Leakage Test	A	W	100%	20%	As per Spec. TM93193	SR	Report to be submitted		
4.0	Critical dimensions	A	I	100%	100%	As per Drg.		SR	Report to be submitted * In the gearcase after fitment of TPU, the ID shall not exceed drawing dimensions at wheel side & gear side.	
							Wheel Side			Gear Side
						ID of TPU seal after fitment	As per drg. of gear case assy./top, bottom half gear case.			As per drg. of gear case assy./top, bottom half gear case.
						ID of half wiper TPU/felt seating Dia.	As per drg. of top & bottom half gear case.			As per drg. of top & bottom half gear case.
						ID of Half Wiper	As per drg. of top & bottom half gear case.			As per drg. of top & bottom half gear case.
	Boss support rib height	As per drg. of gear case boss assy.±2mm.								

352703/20002/EPFXM205600

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TPIA			
5.0	Other Dimensions	B	I	100%	10%	As per Drg.	SR	Report to be submitted
6.0	Locking of oil filler cover after tightening of wing nut.	B	VR	100%	10%	--	SR	Ensure proper locking of oil filler cover after tightening of wing nut.
7.0	Soaking of felt	B	VR	100%	100%	As per specification TM59098	SR	Impregnated felt seals along with TC of impregnation of felt seal as per spec. shall be submitted.
8.0	Painting	B	VR	100%	10%	As per Drg.	SR	--
9.0	Identification Vendor Name, PO No. & item serial no.	B	VR	100%	10%	PO/Drawing	SR	--
10.0	Checking on Fixture (as per specification TM20200).	A	VR	100%	100%	--	SR	TPU & felt shall sit uniformly all along the periphery of checking fixture.

352793/2002/BPFXM205600

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TPIA			
11.0	Packing & transit	B	VR	100%	20%	--	SR	Care should be taken so that during transit components should not damage.
PREPARED BY						APPROVED BY		
 <p>पंकज कुमार पैगवार / Pankaj Kumar Paigvar वरि. अभियंता / Sr. Engineer क्यू.टी.एम. विभाग / QTM Division बी.एच.ई.एल., भोपाल / BHEL, Bhopal</p>						 <p>एस. एम. डी. लुगुन / S.M.D. LUGUN अपर महाप्रबंधक (क्यू.टी.एम.) / AGM(QTM) गुणता नियंत्रण-टी.पी.टी.एम. / Quality Control-TPTN बी.एच.ई.एल., भोपाल / BHEL, Bhopal</p>		

Notes:

- 1) All TR, SR checked by TP, TPIA/QC (dully signed & sealed) as per above QAP requirement shall be submitted along with consignment.
- 2) Final acceptance will be based on checking at BHEL, Bhopal.
- 3) 10 nos. sample to be approved from BHEL before bulk supply.

Abbreviation: A - Critical, B- Major, VR – Verification, I-Instrument/ Gauges,

SR-Shop Record. W-Witness, T P – Task Performer

AGENCIES: TPIA –BHEL appointed third Party Inspecting Agency