



MANUFACTURER'S NAME AND ADDRESS
Component Fabrication Plant(CFP)
RUDRAPUR

MANUFACTURING QUALITY PLAN

Item: AC Cable
Sub-System:
QP No: QP/AC Cable /MAITREE-01
Rev No: 05
Date: 19.11.2020
Page: 01 Of 08

Customer : BANGALADESH INDIA
FRIENDSHIP COMPANY PVT LTD, BANGALADESH
Project : 2x660 MW MAITREE STPP
Contract No : 16-013-X-2
Main - Supplier : BHEL RUDRAPUR

SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	Quantum of Check		REFERENCE DOCUMENT	ACCEPTANCE NORMS/ STANDARD	FORMAT OF RECORDS	AGENCY			REMARKS	
					M	C/B				M	C	B		
1	2	3	4	5	6		7	8	9	10			11	
Instructions: 1) Cable Manufacturer to maintain records to show co-relation of raw materials to finished cables i.e raw material batch/ lot no. should be traceable to the cable drum 2) Cable Manufacturer to maintain all quality control records identified as per all QP stage enumerated below whether it is identified for BHEL verification or witness or not														
1.0 Raw Material/Bought out Item Checks-														
1.01	Aluminum/ Copper	1	Make	MA	Verify	100%	--	Manufacturer Approved sources IS5082	Manufacturer Approved sources IS5082	QCR	V	--	--	
		2	Resistivity	MA	Elect	As per Cable Mnfr Strd	--			--do--	P	--	--	
1.02	PVC / XLPE compound for Insulation	1	Make	MA	Verify	--do--	100%	Manufacturer Approved sources	Manufacturer Approved sources	--do--	V	V	--	
		2	Type/ Cable	MA	Verify	100%	100%	BIFPCL ADS	BIFPCL ADS	--do--	V	V	V	
		3	All acceptance test as per manufacturer norms including thermal stability test for PVC insulation	MA	Verify	As per Manufacturer norms	As per Manufacturer norms	BIFPCL ADS	BIFPCL ADS	--do--	V	V	V	Refer Note 1
1.03	PVC Compound for Inner sheath	1	Make	MA	Verify	--do--	--do--	Manufacturer Approved sources	Manufacturer Approved sources	do	V	V	V	
		2	Type/ Grade	MA	Verify	--do--	--do--	BIFPCL ADS	BIFPCL ADS	--do--	V	V	V	
1.04	Steel wire / Formed Wire (As per applicable)	1	Make	MA	Verify	--do--	--do--	Manufacturer Approved sources	Manufacturer Approved sources	--do--	V	V	V	
		2	Demension	MA	Meas	1 Sample from each size / lot	--	BIFPCL Approved data sheet IS3975	BIFPCL Approved data sheet IS3975	--do--	P	--	--	
		3	All acceptance tests as per IS 3975	MA	Verify	As per IS 3975	--	IS 3975	IS 3975	Supplier TC	V	V	--	
1.05	PVC compound for Sheath	1	Make	MA	Verify	As per Manufacturer norms	100%	Manufacturer Approved sources	Manufacturer Approved sources	QCR	V	V	--	
		2	Type/ Grade	MA	Verify	100%	100%	BIFPCL ADS	BIFPCL ADS	QCR	V	V	V	
		3	All acceptance test as per manufacturer norms	MA	Verify	As per Manufacturer norms	As per Manufacturer norms	BIFPCL ADS	BIFPCL ADS	QCR	V	V	V	Refer Note 1



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Page: 02 Of 08

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SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	Quantum of Check		REFERENCE DOCUMENT	ACCEPTANCE NORMS/ STANDARD	FORMAT OF RECORDS		AGENCY			REMARKS
					M	C/B			M	C	B			
1	2	3	4	5	6		7	8	9	10	** 10			11
		4 Thermal Stability	MA	Chem	One Sample / Batch	--	BIFPCL ADS	BIFPCL ADS	QCR		P	--	--	
		5 Oxygen Index	MA	Chem	--do--	--	BIFPCL ADS/ IS 10810 PART 58	BIFPCL ADS/ IS 10810 PART 58	--do--		P	--	--	
		6 Acid Gas Emission	MA	Chem	One Sample / Batch	--	BIFPCL ADS /IEC60754	BIFPCL ADS /IEC60754	QCR		P	--	--	
1.06	Wooden Drum	1 Dimension	MI	Meas	Manf. Std	--	IS 10418	IS 10418	--do--		P	--	--	
		2 Anti termite treatment	MI	Chem	Cable Manf std.	--	CABLE MANUF STD	CABLE MANUF STD	COC		V	V	--	COC from drum manuf
1.07	Steel Drum	1 Dimension	MI	Meas	--do--	--	--do--	--do--	QCR		P	--	--	
		2 Surface finish	MI	Meas	--do--	--	--do--	--do--	--do--		P	--	--	
B Process & Stage Inspection														
2.01	Wire Drawing	1 Surface finish	MA	Visual	One Sample/Settng of each Size	--	SHOULD BE SMOOTH & FREE FROM SCRATCHES	SHOULD BE SMOOTH & FREE FROM SCRATCHES	QCR		P	--	--	
		2 Wire Diameter	MA	Meas	--do--	--	BIFPCL ADS	BIFPCL ADS	--do--		P	--	--	
		3 Tensile test	CR	Mech	--do--	--do--	--do--	--do--	--do--		P	V	--	Refer Sl. No.3.03(III)
		4 Wrapping test	CR	Mech	--do--	--do--	--do--	--do--	--do--		P	V	--	--do--
2.02	Bunching / Stranding	1 No. of wires	MA	Meas	--do--	--	BIFPCL ADS	BIFPCL ADS	--do--		P	--	--	
		2 Dia of wire	MA	Meas	--do--	--	--do--	--do--	--do--		P	--	--	
		3 Dimension of Conductor	MA	Meas	--do--	--	--do--	--do--	--do--		P	--	--	
		4 Direction of Lay	MA	Visual	--do--	--	--do--	--do--	--do--		P	--	--	
		5 Record of Strands / Welding during conductor stranding	MA	Verify	--do--	--	IS 8130	IS 8130	--do--		P	--	--	
		6 Surface finish	MA	Visual	--do--	--	--do--	--do--	--do--		P	--	--	
		7 DC Resistance	CR	Meas	--do--	--	IS8130/BIFPCL ADS	IS8130/BIFPCL ADS	--do--		P	--	--	
2.03	Insulation extrusion	1 Surface finish	MA	Visual	One Sample/Settng of each Size	--	BIFPCL SPEC	SHOULD BE SMOOTH. NO POROSITY IS PERMITTED.	QCR		P	--	--	XLPE/PVC compound shall be preferably loaded in to extruder by suction method.



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 Page: 03 Of 08

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					M	C/B			M	C	B			
1	2	3	4	5	6		7	8	9	10	11			
		Colour of cores	MA	Visual	One Sample/Setting of each Size	-	BIFPCL ADS	BIFPCL ADS	QCR	P	--	--		
		2 Thickness	CR	Meas	--do--	--	BIFPCL ADS	BIFPCL ADS	--do--	P	--	--		
		3 Spark Test	CR	Elect	100%	100%	CABLE MANUF.STD	NO FAILURE	--do--	P	V	--	1. Spark test failure record is to be verified. 2. Core repairing not permitted	
		4 Hot Set	CR	Mech	One Sample/Setting of each Size	--	IS7098-Part1	IS7098-Part2	--do--	P	--	--	Sample is to be taken both top & batten end	
2.04	Laying up	1 Core sequence	MA	Visual	--do--	--	IS 1554 (Part 1) & 7098- Part 1	IS 1554 (Part 1) & 7098- Part 1	--do--	P	--	--		
		2 Direction of lay	MA	Visual	--do--	--	--do--	--do--	--do--	P	--	--		
		3 Dia. Over laid up core	MA	Meas	--do--	--	BIFPCL ADS	BIFPCL ADS	--do--	P	--	--		
2.05	Inner Sheath	1 Colour	MA	Visual	--do--	--	--do--	--do--	--do--	P	--	--		
		2 Surface Finish	MA	Visual	100%	--	BHEL SPECIFICATION	FISH EYE, BLUE HOLE NOT PERMITTED	--do--	P	--	--		
		3 Thickness	MA	Meas	One Sample/Setting of each Size	--	BIFPCL ADS	BIFPCL ADS	--do--	P	--	--		
		4 Dia over inner sheath	MI	Meas	--do--	--	--do--	--do--	--do--	P	--	--		
2.06	Armouring As Applicable	1 Diamention	MA	Meas	--do--	--	--do--	--do--	--do--	P	--	--		
		2 No. of wires/strip	MA	Meas	--do--	--	--do--	--do--	--do--	P	--	--		
		3 Direction of lay	MA	Visual	--do--	--	IS 1554 (Part 1) & 7098- Part 1	IS 1554 (Part 1) & 7098- Part 1	QCR	P	--	--		



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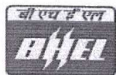
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Date: 19.11.2020
Page: 04 Of 08

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					M	C/B			M	C	B			
1	2	3	4	5	6		7	8	9	10	11			
		Coverage & Quality of armouring	MA	Meas	100%	--		Min area of coverage of armouring shall be 90% The gap between amour wires / formed wires shall not exceed one amour wire formed wire space & there shall be no cross over / over riding of amour wire / formed wire Zn rich paint shall be applied on amour joint surface of G.S. Wire / formed wire. The breaking load of amour wire joint shall not be less than 95% of that amour wire / formed wire(As per BHEL Specification)	QCR		P	--	--	
		Dia over armouring	MA	Meas	One sample/Setting of each size	--	BIFPCL ADS		--do--		P	--	--	--
2.07	Outer Sheath	Surface finish	MA	Visual	100%	--	Pimple finish Eye, Burnt Particles, Blow Hole not permitted, Repairing on outer sheath not permitted (As. Per BHEL specification)		--do--		P	--	--	PVC FRLS compound shall be preferably loaded in to extruder by suction method
		Colour of Sheath	MA	Visual	One sample/Setting of each size	--	BIFPCL ADS	BIFPCL ADS	--do--		P	--	--	
		Dia over outer sheath	MA	Meas	--do--	--	BIFPCL ADS	BIFPCL ADS	--do--		P	--	--	
		Thickness of outer sheath	CR	Meas	--do--	-	--do--	--do--	--do--		P	--	--	
		Embossing quality	MA	Visual	100%	-	Drum no., IS1554-1 / IS7098-1, Cable size, Voltage grade & Words "FRLS" at every 5 Meter is to be embossed. Embossing shall be automatic, in line & marking shall be legible & indelible . (As Per BHEL specification)		--do--		P	--	--	Drum no. on cable may be embossed /printed
		Sequential marking	MA	Visual	Full length	--	Sequential marking of length of Cable in meter at every one meter is to be embossed / printed Embossing/ Printing shall be progressive, automatic, in line & marking shall be legible & indelible (As Per BHEL specification)		--do--		P	--	--	
C	Finished Cable													
3.01	Type test report clearance from BIFPCL engineering	All type test as per BIFPCL specification	CR	DOC.	100%	100%	BIFPCL specification / BIFPCL ADS / IS 1554 (Part 1) & IS 7098-Part 1	BIFPCL specification / BIFPCL ADS / IS 1554 (Part 1) & IS 7098-Part 1	--do--		V	P	V	--



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 Page: 05 Of 08

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					M	C/B			M	C	B			
1	2	3	4	5	6		7	8	9	10	** 10			11
3.02	Routin Tests	1 high Voltage test at room temperature	CR	Elect	100%	100%	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	Test Certificate	V	P	W	V	Refer Note 2
		2 Conductor Resistance	CR	Elect	100%	100%	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	Test Certificate	V	P	W	V	Refer Note 2
3.03	Acceptance Test													
3.03 (i)	Construction of finished Cable	1 OD of Cable	MA	Meas	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		BIFPCL ADS	BIFPCL ADS	--do--	V	P	W	V	
		2 Laying of Core	CR	Visual	--do--		BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	--do--	V	P	W	V	
		3 Core Identification	CR	Visual	--do--		--do--	--do--	--do--	V	P	W	V	
		4 Colour of outer sheath	MA	Visual	--do--		BIFPCL ADS	BIFPCL ADS	--do--	V	P	W	V	
		5 Inner Sheath Thickness	CR	Meas	--do--		--do--	do	--do--	V	P	W	V	
		6 Inner Sheath colour	MA	Visual	--do--		--do--	--do--	--do--	V	P	W	V	
3.03 (ii)	Armour wires/ formed Wires (if Applicable)	1 Dimensions	CR	Meas	--do--		BIFPCL ADS /IS1554 (Part 1) & IS 3975	BIFPCL ADS /IS1554 (Part 1) & IS 3975	--do--	V	P	W	V	
		2 No. of wires/formed wire	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	
		3 tensile Test	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	
		4 Elongation Test	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	
		5 Torsion Test (for round wires only)	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	
		6 Wrapping Test	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	
		7 Resistance Test	CR	Mech	--do--		--do--	--do--	--do--	V	P	W	V	



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Page: 06 Of 08

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					M	C/B			o	h	M	C	B	
1	2	3	4	5	6		7	8	o	h	** 10			11
		8 Mass of Zinc Coating	CR	Meas	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		BIFPCL ADS /IS1554(part I)/IS 3975	BIFPCL ADS /IS1554(part I)/IS 3975	Test Certificate	v	P	W	V	
		9 Uniformity of Zinc Coating	CR	Chem	--do--		--do--	--do--	--do--	v	P	W	V	
		10 Adhesion Test	CR	Mech	--do--		--do--	--do--	--do--	v	P	W	V	
		11 Freedom From defects	CR	Visual	--do--		--do--	--do--	--do--	v	P	W	V	
3.03(iii)	Conductor													
		1 Resistance Test	CR	Elect	--do--		--do--	--do--	--do--	v	P	W	V	
		2 Tensile test (for aluminum Conductor only)	CR	Mech	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		BIFPCL ADS/ IS 8130	BIFPCL ADS/ IS 8130	--do--	v	P	W	V	Test Report of Manufacturer to be reviewed as per Sl. No. 2.01 for Tensile test & wrapping test (for Aluminum) in case this test is not applicable for cable under inspection as per IS 8130 cl.6.2
		3 Wrapping Test (for aluminum Conductor only)	CR	Mech	--do--		--do--	--do--	--do--	v	P	W	V	--do--



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1	2	3	4	5	6		7	8	9	10	** 10			11
3.03 (iv)	PVC/XLPE/Insulation & PVC Sheath	1 Thickness of insulation & PVC sheath	CR	Meas	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	Test Certificate	V	P	W	V	
		2 Tensile strength & Elongation at break of insulation & Outer sheath (before Ageing)	CR	Mech	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	BIFPCL ADS /IS1554 (Part 1) & IS 7098-Part 1	Test Certificate	V	P	W	V	Refer Note 3 Also
		3 Tensile strength & Elongation at break of insulation & Outer sheath (after Ageing)	CR	Mech	Refer note 3		--do--	--do--	--do--	V	P	W	V	Refer Note 3 ath)
		4 Insulation resistance (Volume resistivity method)	CR	Elect	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		--do--	--do--	--do--	V	P	W	V	
		5 High voltage test at room temperature	CR	Elect	Each Type & size of Cable as per sampling plan of IS 1554 (Part1) & IS 7098-Part 1		--do--	--do--	--do--	V	P	W	V	
		6 Hot Set test (for XLPE Insulation only)	CR	Phy	--do--		--do--	--do--	--do--	V	P	W	V	
		7 Thermal stability on PVC Insulation and outer sheath	CR	Chem	One sample of each offered lot of all offered sizes		--do--	--do--	--do--	V	P	W	V	
		8 Oxygen Index Test on outer sheath	CR	Chem	One sample of each offered lot of all offered sizes		BIFPCL ADS / IS 10810 Part 58	BIFPCL ADS	--do--	V	P	W	V	
		9 Smoke Density rating test on outer sheath	CR	Chem	One sample of each offered lot of all offered sizes		BIFPCL ADS & ASTM D2843	BIFPCL ADS	--do--	V	P	W	V	
		10 Acid gas generation test on outer sheath	CR	Chem	One sample of each offered lot of all offered sizes		BIFPCL ADS & IEC 60754-1	BIFPCL ADS	Test Certificate	V	P	W	V	
		11 Flammability test on completed cable	CR	Chem	Refer Note 4	Refer Note 4	BIFPCL ADS & IEC 60332 Part-3 (Category-B)	BIFPCL ADS	--do--	V	P	W	V	



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 Page: 08 Of 08

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					M	C/B			M	C	B			
1	2	3	4	5	6		7	8	9	10	11			
		12 surface finish & length measurement	CR	Visual & Meas	One length of each size	One length of each size	(1) Drum no. (2) IS1554-1 /IS7098-1,Cable size, Voltage grade & Words " FRL,S" at every 5 meter is to be embossed. Embossing shall be automatic, in line & marking shall be indelible (3) Sequential marking of length of cable in meter at every one meter is to be embossed / printed. Embossing / printed shall be progressive, automatic, in line & marking shall be length & indelible	--do--	V	P	W	V	Pimple, fish Eye, Burnt particals, Blow Hole etc. not permitted. Repairing on outer sheath not permitted	
		13 Sequence of cores armour coverage, gap between two consecutive armour / formed wire	CR	Visual & Meas	One length of each size	One length of each size	Min. area of coverage of armouring shall be 90%. The gap between armour wires / formed wires shall not exceed one armour wire/ formed wire space & there shall be no cross over/ over riding of armour wire / formed wire Zn rich paint shall be applied on armour joint surface of G.S Wire / formed wire	--do--	V	P	W	--		
4	Packing	1 Sealing	MA	Visual	100%	100%	(I)IS1554(Part-1) & IS 7098:Part 1 (2) The surface of the drum and the outer most cable layer shall be covered with water proof cover (3) Both the ends of cables shall be properly sealed with heat shrinkable PVC/ rubber caps secured by "U" nails.	QCR	V	P	W	--		
4.01	Identification	Supplier/Manufacturer Sealing	MA	Visual	100%	100%	Sealing shall be visible	QCR	V	P	W	--		

Note: Makes shall be as per vendor list in approved Inspection Categorisation Plan: MAITREE-00-BAA-DA-500027-RDP. After finalization of vendor, vendor's MQP will be submitted to the customer.

Manufacturer/ Sub-Supplier Signature		Main-Supplier	Legend: * RECORDS, IDENTIFIED WITH "TICK" SHALL BE ESSENTIALLY BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER C: MAIN SUPPLIER, B: BIFPCL P: PERFORM W: WITNESS AND V: VERIFICATION. AS APPROPRIATE, CHP: BIFPCL SHALL IDENTIFY IN COLUMN "B" AS "W" IR: Inspection Report TC: Test Certificate, TDS: Technical Data Sheet	For BIFPCL Use	Doc. No:	Rev:-----CAT
					Reviewed By	Approved By