

**QUALITY PLAN**  
**FOR TRANSFORMER/ SILICON OIL FILTRATION PLANT**  
**(CAP: 6000/1000 LPH)**

QPI-BOI-021

DATE:18/01/2007

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A.RAW MATERIAL AND BOUGHTOUT COMPONENTS					MATERIAL/INSPECTION / PROCESS / INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS				
Sr. No	Component	Characteristic	Type of check	Quantum of Check	Reference document	Acceptance norm	Format of record	Agency			Remark
1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
1	RAW MATERIAL										
1.1	M.S. Plate for shell Dished ends and flanges	Chemical and physical test	Chemical analysis measurement & visual	Samples	IS: 2062	IS: 2062	Lab Test Report Verification	3	3	1	
1.2	Pipe for Interconnecting Line for pipe work	Physical, chemical Test	----do----	Samples	IS: 1239	IS: 1239	---do---	3	3	1	
2.	BOUGHTOUT COMPONENTS										
2.1	Centrifugal Pump	Visual inspection, Finish	Visual	100%	Tender Spec.	No damage & meet tender Spec.	Internal Report	3	3	2	
		Leakage under air Pressure	Pneumatic test At 3Kg/cm2	100%	Relevant IS Std.	No leakage with soap solution	Internal report	2	2	2	
2.2	Vacuum pumps	Performance for Required vacuum	Verification of Mfg. T. C.	100%	Tender Spec.	Tender spec.	Mfg. T.C.	3	3	2	
2.3	Electric Motors	Visual	Verification of Mfg. T. C.	100%	IS: 325	IS: 325	Mfg. T.C.	3	3	2	

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A. RAW MATERIAL AND BOUGHTOUT COMPONENTS					MATERIAL/INSPECTION/ PROCESS/INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS				
Sr. No.	Component	Charecteristic	Type of Check	Quantum of Check	Reference document	Acceptance norm	Format Of record	Agency			Remark
1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
2.4	Gear pump	Visual inspection Finish comparison with spec. data Plate inspection for damage	Visual	100%	Tender Spec.	No damage & meet tender spec.	Internal Report	3	3	2	
		Leakage under air pressure	Pneumatic test at 3 Kg/cm2	100%	Relevant IS Std.	No leakage with soap solution	Internal report	2	2	2	
2.5	Vacuum Gauge	Calibration	Calibration check	100%	Mfg. Std..	Proper Functioning	Certificate From Mfg/Calibration report	3	3	2	
2.6	Thermostat	Calibration	Calibration check	100%	Mfg. Std	Cut in & Cut off test	Certificate from Mfg./Calibration report	3	3	2	
2.7	Dial Thermo meter	Calibration	Calibration check	100%	Mfg. Std	Proper Functioning	Certificate from Mfg./Calibration report	3	3	2	
2.8	Float switch	Visual & functional	Test on 2 working conditions	100%	Mfg. Std	Proper Functioning	Mfg. T.C./ Internal report	3	3	2	
2.9	Oil hoses	Dimensions & Leak test	Measurement, Visual Check & Pressure test	100%	Relevant IS Std.	No leakage	Internal report	3	3	2	

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B. FABRICATION OF COMPONENTS INTERCONNECTIG & PIPING					MATERIAL/ INSPECTION/ PROCESS/ INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS				
Sr. No	Component	Charecteristic	Type of check	Quantum of Check	Reference document	Acceptance norm	Format of record	Agency			Remark
1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
1.1	IN PROCESS Air Pressure	Leakage	Air Pressure 3 kg/cm2	100%	----	No leakage	Internal Report	2	2	2	
1.2	Control Panel Fabrication	Physical Verification	----	100%	Tender Spec.	Good finish & workmanship	Internal report	2	2	2	

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C.CONTROL PANEL - IN PROCESS INSPECTION					MATERIAL/ INSPECTION/ PROCESS/ INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS				
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1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
D.	Final inspection	Finish completeness, Thickness verification of panel, components rating, arrangement of holes as per drg.	Visual	100%	Relevant IS Std.	Relevant IS Std.	Internal Report	2	2	2	

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C. OIL PURIFICATION PLANT					MATERIAL/ INSPECTION/ PROCESS/ INSPECTION/ FINAL INSPECTION	SUB VENDORS/ VENDORS					
Sr. No.	Component	Charecteristic	Type of check	Quantu m of Check	Reference document	Acceptance norm	Format of record	Agency			Remark
1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
1	Assembled system										
1.1		Trouble free running Working of interlocks	2 hours actual running	100%	Relevant IS Std. Spec. Procedure	No undue Noise Satisfactory Functioning	Internal Inspection Report	2	1	1	H
1.2		Leakage of Oil	2 hours actual running	100%	Relevant IS Std. Spec.	No leakage	Internal Inspection report	2	1	1	H
2.	Performance test	Trouble free running	2 hours actual running	100%	Tech.Spec. Approved Data sheet/ Drawings & Relevant IS Std.Spec	Trouble free Running	Internal test Report	2	1	1	H
		Leakage under normal Running				No leakage	Internal test report	2	1	1	H

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D.OIL PURIFICATION PLANT FINAL INSPECTION					MATERIAL/ INSPECTION/ PROCESS/ INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS				
Sr. No	Compo nent	Charecteristic	Type of check	Quant um of Check	Reference document	Acceptance norm	Format of record	Agency			Remark
1.	2.	3.	4.	5.	6.	7.	8.	9.			10.
								P	W	V	
1		Vacuum	Measurement	100%	Tech. Spec.	Tenderspec./ Mfg.TC	Internal test report	2	1	1	Hold point
2.		Discharge flow Rate	Performance test	100%	Tech. Spec	Tender spec.	Internal test report	2	1	1	
3.		Suspended particle Size	Performance test	100%	Tech. Spec	Tender spec.	Internal test report	2	1	1	
4.		B.D.V	Performance test	100%	Tech. Spec	Tender spec.	Internal test report	2	1	1	
5.		PPM	Performance test	100%	Tech. Spec	Tender spec.	Internal test report	2	1	1	
6.		Gas Content	Performance test	100%	Tech. Spec	Tender spec.	Internal test report	2	1	1	
2.	Comple te Plant	Overall Dimensions Orientation, Workmanship & Finish Completeness	Measurement & visual inspection	100%	Relevant IS Std.	Relevant IS Std.	Internal Inspection Report	2	1	1	Hold Point
		Verification of records	Verification	100%	Approved Drawings & Spec		Internal Inspection Report	2	1	1	Hold Point

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