

 CFP/Q&BE		BHARAT HEAVY ELECTRICALS LIMITED, RUDRAPUR											
Quality Assurance Plan for Electro plating of Tin on Copper/ Al. & its Alloys.							FINAL INSPECTION		VENDOR's WORK/ BHEL		Doc No.: QP/BD/EP-01, REV.No.: 00 DATE: 23.11.2020 Page 1 of 1		
Sl. No.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS
					M	C/N				M	C	N	
1.	Inspection of Electroplated Surface	a) Surface Finish. b) Thickness of Plating. c) Adhesion. - Burnishing Test.	B B B	V I T	100% 100% Sample	10% *Sample *Sample	BHEL Drg./ IS 1771 (General)/ IS 3203 (Thickness Measurement) SG 15605 (for Al.)/ AA 0673602 (for Cu.)	Same as Reference document	TC/OS	P P P	W W W	- - -	CHP (Insp. By BHEL/ TPIA at vendor's work) *No. of Samples taken for witness is at the discretion of BHEL/IS

Important Note:

- 1) Vendor to strictly follow the process requirement stages as per Product Standard & reference documents as mentioned in above table).
- 2) Surveillance Process Inspection can be done by BHEL for any plating job in progress.
- 3) Cleaning/ Surface preparation/ Buffing to be done effectively prior to plating as per Product Standard.
- 4) Packing of electroplated jobs shall be inspected at vendor's work Or at the time of receiving at BHEL works. Vendor to ensure packing protection during transit.
- 5) Packing of electroplated jobs shall be in line with latest packing scheme provided by BHEL.
- 6) QAP prepared on the basis of inputs received from Engineering Deptt. email dated 28th Aug'2020. Also, the acceptance of QAP Tests is given by Engineering vide Email dt 23rd Nov' 2020.

LEGEND: -

CLASS
A: CRITICAL
B: MAJOR

TYPE OF CHECK
V: VISUAL
I: MEASUREMENT
T: TEST

AGENCY
M: VENDOR / SUB CONTRACTOR
C: BHEL / BHEL NOMINATED INSPECTION AGENCY
N: CUSTOMER

SCOPE
P: PERFORMER
V: VERIFICATION
W: WITNESS
CHP: CUSTOMER HOLD POINT

FORMAT OF RECORD
TC: TEST CERTIFICATE
OS: OBSERVATION SHEET
Drg.: DRAWING

Prepared & Checked by

बुद्धिराजा
 उप प्रबंधक (गुणता)
 बी.एच.ई.एल., रुद्रपुर
 उत्तराखण्ड - 263153

BUDHIRAJA
 Dy. Manager (Quality)
 B.H.E.L., Rudrapur
 Uttarakhand - 263153

कपिल कुमार भारती
 वरिष्ठ प्रबंधक (गुणता)
 बी.एच.ई.एल., रुद्रपुर
 उत्तराखण्ड - 263153

Kapil Kumar Bharti
 Sr. Manager (Quality)
 B.H.E.L., Rudrapur
 Uttarakhand-263153