



**BHARAT HEAVY ELECTRICALS LIMITED BHOPAL**

**QA PLAN FOR: FLOW INDICATOR**

**QA PLAN NO: QA/TCB/BO/82 REV 03**

**DATE:24/01/2026**

SL NO	COMPONENT/ ASSY/ OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		BHEL REF.DOCUMENT/ ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY		REMARKS
					M	C			M	C	
1	<b>MATERIAL INFORMATION:</b> Description:	Material:									Raw material Certificate of conformance shall be provided by Manufacturer.
	a) Body/ Base	Al./ AL. Alloy	B	T	-	-	BHEL Spec/ TR10050I/ Drg/ PO	TC or TR	P	V	
	b) Vane shaft	Brass	B	T	-	-		-do-	P	V	
	c) Vane	SS	B	T	-	-		-do-	P	V	
	d) Dial	Aluminium	B	T	-	-		-do-	P	V	
	e) Terminal Box	Aluminium	B	T	-	-		-do-	P	V	
	f) Lens	Toughened Glass	B	T	-	-		-do-	P	V	
2	<b>FINAL INSPECTION &amp; TESTING</b>	<b>1.ROUTINE TEST</b>  a) Full flow and alarm test  b) Static pressure test at 7 kg/cm2 for 2 minutes for Body only c) 2 KV test for one minute between live parts & earth d) Switch operation w.r.to dial marking & its contact test e) Insulation resistance at 500v for 1 Min <b>2.TYPE TEST</b> a) IP-55 degree of protection or terminal box									
				T	100%	1 sample/ lot 10%	BHEL Spec/ TR10050I/ Drg/ PO	TC or TR	P	W	CHP
				T	100%	-	-do-	-do-	P	W	CHP
				T	100%	-	-do-	-do-	P	V	
				T	100%	-	-do-	-do-	P	V	
				T	Once in 5 year	-	BHEL Spec/ TR10050I/ Drg/ PO	TC or TR	P	V	Type test to be conducted once in 5-year Report of type test conducted not more than 5 year ago in NABL accredited lab to be reviewed by BHEL/TPIA
3	<b>DIMENSION &amp; VISUAL CHECK</b>	a) Dial Marking  b) Mounting	B	M,T	100%	10%	BHEL Spec/TR.10050I/P O do-	TC or TR	P	W	CHP
			B	M	100%	10%		-do-	P	V	
4	<b>PAINT</b>	Painting of Flow indicator	B	V	100%		-do-	TC or TR	P	V	Colour/Paint shade of flow indicator shall be as per specification of individual PO.

**LEGEND**  
A = CRITICAL  
B = MAJOR  
C = MINOR  
V = VISUAL  
M = MEASUREMENT  
T = TEST

**AGENCY**  
M = MANUFACTURER/SUB-CONTRACTOR  
C = BHEL APPOINTED THIRD PARTY INSPECTION AGENCY (TPIA)

**SCOPE OF AGENCY**  
W = WITNESS  
V = VERIFICATION  
P = PERFORMER

Note: This QAP shall be read in conjunction with Customer approved QAP/RQP/MQP for specific work Order (As applicable).  
2) In Case of any discrepancy/difference in the Specification and acceptance Norms for Properties/Parameters then Customer QAP/Specification Shall Prevail.

**PREPARED BY**

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