



BHARAT HEAVY ELECTRICALS LIMITED : BHOPAL
QA PLAN FOR : SILICA GEL BREATHER WITH OR WITHOUT GANGING ARRANGEMENT
QA PLAN NO.: QA/CB/BO/78 REV.02 DATE 16.12.2016

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	MATERIAL	1. Polycarbonate tube	B	T			BHEL spec./drg.	TC/TR	P	V	Breather shall be pressure tested with air at pressure 0.35kg per cm square for 30 minutes & there should be no leakage. A metallic label indicating manufacturer name, sl. No., gel capacity etc. shall be provided at suitable place.
2	TEST	Pressure test	B	T	100%	10%	BHEL spec./drg.	TC/TR	P	W	
3	DIMENSION & VISUAL CHECK	1. Mounting dimension & visual check 2. Assembly dimension & visual check	B B R	M M M	100% 100% 100%	10% 10% 10%	BHEL spec./drg. BHEL spec./drg. BHEL spec./drg.	TC/TR TC/TR TC/TR	P P P	W W W	

LEGEND

TYPE OF CHECK
A = CRITICAL
B = MAJOR
C = MINOR

V = VISUAL
M = MEASUREMENT
T = TEST

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

SCOPE OF AGENCY
W = WITNESS
V = VERIFICATION

P = PERFORMER

PREPARED BY:-

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