



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI-620014

STANDARD QUALITY PLAN FOR
AIR FILTER REGULATOR


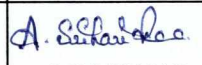
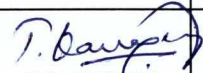

QA:CI:STD:QP:07

Rev: 04

Page: 1 of 3

CONTROLS & INSTRUMENTATION/QA/FB

STANDARD QUALITY PLAN FOR
AIR FILTER REGULATOR

REV	DATE	PREPARED	REVIEWED		APPROVED	REVISION HISTORY
00	03.11.1992	Sd/-	Sd/-	Sd/-	Sd/-	Initial release
01	16.06.1997	Sd/-	Sd/-	Sd/-	Sd/-	Format revised
02	21.03.2002	Sd/-	Sd/-	Sd/-	Sd/-	Department name changed, CTQ requirement added & general revision
03	08.01.2004	Sd/-	Sd/-	Sd/-	Sd/-	Revision to include the comments/ feedback OF internal discussion.
04	20.02.2018	 V AVINASH	 A SRIHARI RAO	 T KANAGARAJ	 R M VAIRAVAN	Format Changed. Included Type test and standards updated.

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S.No	Component & Operation	Characteristics	Class	Type of Check	Quantum of check		Ref Doc. & Acceptance STD	Format of Record	Agency			Remarks
					M	B/C			M	B	C	
A	Finished product inspection											
1	Routine Tests	a) Model Number	Major	VISU	100%	10%	BHEL approved vendor data sheet/drawing	IR	P	W	-	
		b) Port size & Filter size	Major	VISU	100%	10%		IR	P	W	-	
		c) Output Gauge & dimension verification	Major	MEAS	100%	10%		IR	P	W	-	
		d) Air leak test (By using soap water)	Major	MECH	100%	10%	At 10 Kg/cm ² for 1 Min.	IR	P	W	-	There shall be no leak.
		e) Calibration Test: i) Outlet pressure variation with inlet pressure constant ii) inlet pressure variation with outlet pressure constant	Major	MECH	100%	10%	Manufacturer standard / ISO 6953	IR	P	W	-	
2	Type Tests	Enclosure protection Test	Critical	ENVI	One of design		Purchase order specification & IEC- 60529	TC	V	V	-	

M- MANUFACTURER/ SUB-VENDOR; B - BHEL / TPI ; C - CUSTOMER / TPI
P - PERFORM ; W - WITNESS V - VERIFICATION OF DOCUMENTS ;



B.NOTES:

1.LEGENDS:

VISU : Visual **IR** : Inspection Report
MEAS : Measurement **TC** : Test certificate
ENVI : Environmental

- 2) Vendor shall arrange all the required facilities for routine tests at their works .
Type tests for which facilities are not available are to be carried out at recognized National Test Houses like ETDC/CIL/NPL/ERTL etc., at vendor cost.
- 3) Through Log Book / any other documents available at the vendor's works, it shall be possible to correlate the finished product with inspection carried out.
- 4) All Measuring and Testing Instruments shall be periodically calibrated from recognized test houses & certificates made available during inspection for verification.

- 5) Type test certificate shall not be earlier than 5 years from the date of Purchase enquiry.
- 6) Vendor to give tentative inspection program in advance and confirm exact date two weeks in advance for arranging BHEL's inspection.
- 7) Packing shall be as per "PACKING PROCEDURE "indicated in the specification.
- 8) If non-conformity is observed even in one number of the sample lot in any characteristic, inspection shall be carried out on 100% of the offered lot.

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