

5535 CO2			COMMUTATOR SEGMENT (SLITTED)	285 TOS	COM 2	JIS C 280176	555(RAW) 235±5(Finish)
CRD NO	WEI NO	PART DESIGN	DESCRIPTION	QTY TM	MATL CLASS	SPCN	WT gm. Piece
	NAME	SIGN	DATE	GILLI TARANJAN LOCOMOTIVE WORKS WEST BENGAL INDIA			
IGN			FRACTION MOTOR HS 15250 A				
FIN	B.K. Saha	<i>B.K. Saha</i>	07/10/03				
PRD							
CRD	B.K. Chatterjee	<i>B.K. Chatterjee</i>	07/10/03				
COM	B.K. Bhattacharya	<i>B.K. Bhattacharya</i>	07/10/03				
SCALE - N.T.S.				APPROVED <i>AK Rastogi</i>			
REF : 10S.813.323 A, ALT 9				NAME - AK RASTOGI			
				DATE - 02.02.2005			
				NO. 10S.813-323 A			
				AT LIBERATION			



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY ASSURANCE PLAN FOR COMMUTATOR BAR TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. – QAP/QTM/VENDORQAP/2021-22/ COMMUTATOR BAR HS15250 DTD 10.12.2021 REV 00
Reference Document- PO DRAWING/SPECIFICATION

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SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP1A					
1)	Raw material	a) All tests	TC verification	100 %	100%	JIS C2801 76	As per Specification	MTC	BHEL/TP1A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL /Supplier to get the raw material TC correlated with material TC.
2)	Testing	a) Mechanical tests b) Electrical tests c) Chemical tests	TC verification	100 %	100%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP1A	Testing to be done at NABL lab.
3)	Dimension & surface finish	Dimension & surface finish	Measurement & visual	100 %	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP1A	3 test sample per batch to be submitted to BHEL duly punched by TP1A
4)	Twisting and bend check	Twisting and bend check	Surface plate	100 %	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP1A	100 % RR & 5% Witness
5)	Identification vendor name, PO & job serial no.	Verification	Visual	100 %	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP1A	Embossing as per drawing

Prepared By
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Approved By

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