
		ITEM: (MATERIAL, CLASS, GRADE, RATING, SIZE ETC.) GALVANISED FLEXIBLE CABLE TRAYS SUPPORT SYSTEM		STANDARD QUALITY PLAN		QP NO. 0000-999-QOE-S-38 REV:00 DATE : 01.09.04 PAGE 1 OF 2 VALID UPTO:31.08.07		REVIEWED BY S.D.SINGH O.P.NIRANJAN I.J.SINGH		APPROVED BY ANIL KUMAR				
				CONFORMING TO CODE: Design as per NTPC Specification										
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.	Flexible cable trays Support Structure	1. In Black Condition a) Weld Quality	Major	Visual	100%	Random	Manufacturer's Plant Std	Manufacturer's Plant Std	Inspection Report	D*	**	10	N	11
		b) Burs	Major	Visual	Random	-	No Burs	No Burs	-do-		P	V	V	
2.	Finished Galvanized	2. After Galvanising												
		2.1 General physical inspection including Galvanizing Quality/Defects, Dicromating, White Rusting etc.	Major	Visual	100%	5 Sample/Lot	IS-2629-1985 IS-4759-1996	IS-2629-1985 IS-4759-1996	-do-		P	W	W	
		2.2 Dimensional Check & Thickness Check	Major	Measurement	-do-	-do-	NTPC/Main Supplier Approved Drg.	NTPC/Main Supplier Approved Drg.	-do-		P	W	W	
		2.3 Galvanizing Tests												
		a) Coating thickness measurement survey by Elcometer	Critical	Measurement	IS-4759-1996	-do-	IS-4759-1996 IS-3203-1982	IS-4759-1996 IS-3203-1982	-do-		P	W	W	
		b) Mass of zinc coating	Critical	Measurement	-do-	1 coupon sample of each thickness	IS-6745-1972 IS-4759-1996	IS-6745-1972 IS-4759-1996	-do-		P	W	W	
		c) Uniformity of zinc coating/dip test	Critical	Measurement	-do-	-do-	IS-2633-1986 IS-4759-1996	IS-2633-1986 IS-4759-1996	-do-		P	W	W	
		d) Adhesion Test	Critical	Visual	-do-	-do-	IS-2629-1985	IS-2629-1985	-do-		P	W	W	

LEGEND: RECORDS IDENTIFIED WITH "TICK" SHALL BE ESSENTIALLY INCLUDED BY THE CONTRACTOR IN QA DOCUMENTATION
****M: MANUFACTURER/SUB-SUPPLIER, C: Main Supplier: NTPC, N: NTPC. INDICATE "P" PERFORM "W" WITNESS AND "V" VERIFICATION AS APPROPRIATE**
"CHP" BY NTPC SHALL BE IDENTIFIED IN COLUMN "N" AS "W"

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		ITEM: (MATERIAL, CLASS, GRADE, RATING, SIZE ETC.)		STANDARD QUALITY PLAN		QP NO. 0000-999-QOE-S-38 REV.:00 DATE : 01.09.04 PAGE 2 OF 2 VALID UPTO: 31.08.07		REVIEWED BY S.D.SINGH O.P.NIRANJAN I.J.SINGH		APPROVED BY ANIL GUPTA			
				CONFORMING TO CODE: Design as per NTPC Specification									
SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			
1.	2.	3.	4.	5.	M	C/N	7.	8.	9.	D*	M	C	N
		Proof Load Test as per note 6 Followed by Die Penetration Test (For 600 mm and above cable tray support system)	A	Meas/Visual	One Sample from each offered lot	One Sample from each offered lot	NTPC Technical Specification/ No visible cracks should develop on the weld part	NTPC Technical Specification/ No visible cracks should develop on the weld part	Inspection Report		P	W	W
Note : <ol style="list-style-type: none"> The supplier to ensure procurement of steel from main producers like SAIL/TISCO, Rastriya Ispat/Ispat Ind. Jindal/Essex/Lloyds/IIS Co. and Zinc from Hindustan Zinc Ltd. Welding shall be done by qualified welders as per supplier system. Material shall be galvanized at NTPC approved sources only. Pre-treatment of cable trays support system shall be carried out in seven tank process as per IS-2629. All the process parameters e.g. Concentration, temperature, density etc. to be maintained and recorded by the galvaniser. The process of pre-treatment shall be verified by NTPC on surveillance basis during inspection of Galvanised Flexible Cable Trays support system. <ol style="list-style-type: none"> Test on Main support Channel shall be done if only CI channel are in scope of supply and cantilever arms shall be fitted on one side. This test shall be same as test 4 of type test as per tech. Spec. Test on Main Support Channel shall be done with C2 Channel and cantilever arms fitted on both sides, if C2 channels are in scope of supply. This test shall be same as test 2 A of type tests. Then test at (i) above shall not be repeated. Nut slip characteristic test (It shall support minimum load of 350 Kg. Before Nut Slips with bolt torque of 65 NM). This test shall be same as test 5 B of type tests. The procedure for carrying out above test shall be as per details given in Type Tests Specification. 													
LEGEND: RECORDS IDENTIFIED WITH "TICK" SHALL BE ESSENTIALLY INCLUDED BY THE CONTRACTOR IN QA DOCUMENTATION **M: MANUFACTURER/SUB-SUPPLIER, C: Main Supplier, N: NTPC. INDICATE "P" PERFORM "W" WITNESS AND "V" VERIFICATION AS APPROPRIATE "CHP" BY NTPC SHALL BE IDENTIFIED IN COLUMN "N" AS "W" FORMAT NO. QS-01-QAI-P-10/F3-R0													