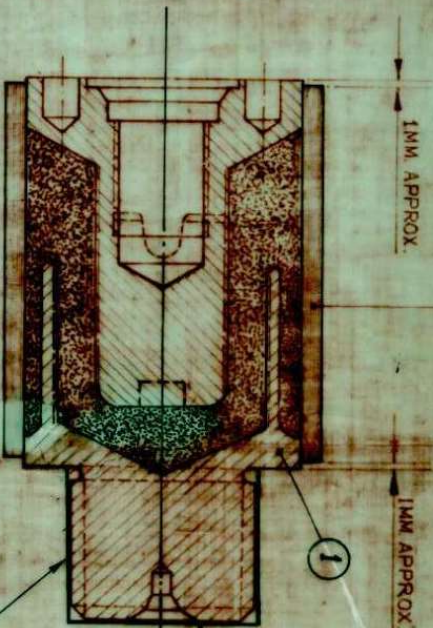


332563/2024/HEP-TXM20500



AUTHORITY	DESCRIPTION	INITIAL	DATE
1. DYCEE/TM	NOTE REVISED & NOS ADDED	N.R.	6.10.94
2. "	NOTE ALTERED.	N.R.	2.6.94
3. DYCEE/TMD	ZINC PLATED ADDED IN NOTE 3		25.02.94
4. DYCEE/TMD	NOTE 4 ADDED. REF. NOTE NO. ELI/M/2013. DATED: 26.02.99		28.02.99
5. DYCEE/TMD	NOTE 5 ADDED. REF. NO. ELI/M/2013 DTD 29.8.2002		04-9-02

NOTE:-

- DIMENSIONS OF SLEEVE - REF. 2, BEFORE ASSEMBLY -
O/D=63, I/D=54.5 ± 0.1 L=78.5 mm.
- HEAT THE SLEEVE TO 250° TO 280°C FOR SHRINKAGE.
OVER REF. 1, DRG. NO. 3.TWD.092.238.
- EXPOSED STEEL PARTS SHALL BE CADMIUM PLATED/ZINC PLATED.
- THE THREADED PORTIONS OF THE INSULATORS SHOULD BE COVERED BY A THREADED PLASTIC CAP.
- MANUFACTURER TO PROVIDE THEIR METAL PUNCH/EMBOSS IDENTIFICATION MARK AT THE LOCATION SHOWN.

Signature Not Verified

Digitally signed by Ravindra Kumar
Date: 2022.04.25 16:01:37
Reason: IRPS-CRIS Location - New Delhi

ALL DIMENSIONS ARE IN MM.

THREADED PLASTIC CAP (SEE NOTE - 4)

ACT 4

5474	760	2	—	TEFLON SLEEVE	4 NOS.	PTFE	
5474	725	1	3.TWD 092.238	MOULDED STUD ASSY (FINISHED)	4 NOS.		
5474	700	—	3.TWD 092.267	MOULDED STUD ASSLY (ROUGH)	4 NOS.		
CAD NO.	REF. DATE	PART DRG. NO.	DESCRIPTION	TERMINAL SUPPORT INSULATOR ASSEMBLY	QTY/TM	MATL. SPECN.	WT.
DBL				TRACTION MOTOR			
DRN				TAO 659 & HS 15250 A			
CHD	173.71			TERMINAL SUPPORT			
TRD	85.76			INSULATOR			
COMP				ASSEMBLY			
SCALE:- 1:1				CHITTARANJAN			
REF. TR. 6017.04 A				LOCOMOTIVE WORKS			
				WEST BENGAL, INDIA.			
				APPROVED:-			
				No 3.TWD.092.188			




BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY ASSURANCE PLAN FOR BRUSH HOLDER SUPPORT PIN & INSULATING ROD TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

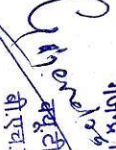
QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2024-25/ BRUSH HOLDER SUPPORT PIN & INSULATING ROD DTD 11.11.2024 REV 00
Reference Document- PO DRAWING/SPECIFICATION
Page : 1 of 1

SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENC E DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP/A					
1)	Raw Material (all items)	Test	TC Verification	100%	100%	As per drawing & Specification	As per drawing & Specification	MTC	BHEL/TP/A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL /Supplier to get the raw material correlated with material TC & Invoice
2)	Dimension	Dimension	TC Verification & Measurement	100%	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Supplier internal report for 100 % to be reviewed and 5 % to be Witness by TP/A
3)	Testing	Type test	TC Verification	100%	100%	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	Supplier internal report for 100 % to be reviewed and 5 % to be Witness by TP/A
		Routine test	TC Verification & testing	100%	5 %	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	Supplier internal report for 100 % to be reviewed and 1 % to be Witness by TP/A
4)	Zinc coating	Coating thickness	TC Verification & testing	100%	1 %	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	Supplier internal report for 100 % to be reviewed and 1 % to be Witness by TP/A
5)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness

Prepared By


गुणता नियंत्रण / VELMURGAN
सहायक अभियंता ग्रेड-II
गुणता नियंत्रण-क्यू टी.एम.विभाग
बी.एच.ई.एल., भोपाल

Approved By


गोवर्धन सिंह राजौर/ G.S. RATHORE
प्रबंधक/Manager
क्यू टी.एम. विभाग/QTM Division
बी.एच.ई.एल., भोपाल/ BHEL, Bhopal



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY ASSURANCE PLAN FOR BRUSH HOLDER SUPPORT PIN & INSULATING ROD TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2024-25/ BRUSH HOLDER SUPPORT PIN & INSULATING ROD DTD 11.11.2024 REV 00
Reference Document- PO DRAWING/SPECIFICATION
Page : 2 of 1

5)	Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification		BHEL/TP/A	Packing to be such that no damages should occur during transit
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Prepared By

Prepared By
VELMURGAN /VELMURGAN
सहायक अभियंता ग्रेड-II
गुणता नियंत्रण-क्यू.टी.एम. विभाग
बी.एच.ई.एल, भोपाल

Approved By

Approved By
गजेन्द्र सिंह राठौर/G.S. RATHORE
प्रबंधक/Manager
क्यू.टी.एम. विभाग/QTM Division
बी.एच.ई.एल, भोपाल/BHEL