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DIARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY PLAN FOR OFF-LOADED CRGO STEEL LAMINATION

QA PLAN NO: QC/TCB/QAP-BO/02 REV.00

DATE:10.11.2006

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SL	STAGE	CHARACTERISTICS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT & ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY	REMARKS
1	Material Verification & correlation	Verification that material is from BHEL approved vendor, and of specified grade.	V	100% Rolls	P.O./Relevant Drg. Spec.	TC/Challan Roll Identification slip	BHEL / TPIA	CHP (Physical verification of CRGO steel rolls with original manufacturer's identification slip)
2	TC Verification	Grade of steel. Electrical, Mechanical, Magnetic properties as per spec	TC verification		As per BHEL purchasing specification	TC	BHEL / TPIA	TC Verification (Record Review)
3	Sample Test	1) Dimensional checks 2) Electrical, Mechanical, Magnetic properties as per spec.	T	10% of total roll for dimensions and One Sample per lot for remaining tests	Relevant BHEL material purchase Spec.	TR	BHEL / TPIA	CHP (The test sample will drawn in the presence of BHEL/TPIA for conducting all test as per BHEL specification. Dispatch clearance for laminations will given after satisfactory passing of the sample at BHEL Laboratory)
4	In process check	<u>During Slitting</u> Width, Burr and edge bow. <u>Cropping of CRGO Roll:</u> Cropping Length and Angle, Piercing Hole dia, hole pitch. Mitring length, Burr and edge bow.	M	Surveillance check (Minimum twice every shift)	BHEL drg. & Std. TR10141 CR	TR	BHEL / TPIA	CHP

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5	Stacking	Stacking of Lamination as per drg.	V	100%	BHEL Drg Spec.	Vendor's record	Vendor	-
6	Packing and Dispatch	Proper packing of lamination to avoid damage and rusting in transit	V	100%	BHEL Drg./ Spec.	Vendor's record	Vendor	-

V - visual. M - measurement. T-test, TPIA-third party inspection agency appointed by BHEL., CHP-customer hold point (vendor can not proceed without getting clearance from BHEL.) TC-test certificate. TR-test report, .

NOTE: In case CRGO steel rolls have been supplied by BHEL, SI.No. 2 and 3 shall not be applicable. However, BHEL/ TPIA shall ensure that BHEL supplied rolls are kept separately and processed against relevant BHEL P.O.

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