



Bharat Heavy Electricals Ltd
Electronics Divison
Bangalore

QUALITY PLAN FOR
SS Hoses

QP No.: TE/445/HOSE/QP
Rev: 01 Date: 14.11.16
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Project: AC Loco

Sl. No	Component & Operation	Characteristics	Class	Type of Check	Quantum of check		Ref Doc. & Acceptance STD	Format of record			REMARKS	REV
					M	B			M	B		
A	RAW MATERIAL											
	HOSE (SS 316/ SS 304)	PHY. & CHEM. PROPERTIES	MAJOR	PHY. & CHEM. PROPERTIES	100%	100%	SS 316/ SS 304	IR	V	V		
1.	WIRE BRAID (SINGLE) SS304	-DO -	MAJOR	-DO -	100%	100%	SS 304	IR	V	V		
2	STUB END (SCH-10) SS 304	CHEMICAL PROPERTIES	MAJOR	CHEMICAL PROPERTIES	100%	100%	SS 304	IR	V	V		
3.	NECKRING	CHEMICAL PROPERTIES	MAJOR	CHEMICAL PROPERTIES	100%	100%	SS 304	IR	V	V		
4.	FLANGE SA-182 F304L	CHEMICAL PROPERTIES	MAJOR	PHY. & CHEM. PROPERTIES	100%	100%	SA-182 F304	IR	V	V		
B	FINAL PRODUCT											
1	HOSE ASSEMBLY	OVER ALL LENGTH	CRITICAL	MEASURING TAPE	100%	20%	APP. DRG.	IR	P	W		
2	END CONNECTION	DIM. AS PER DRG.	CRITICAL	VERNIER	100%	20%	-DO -	IR	P	W		
3	ORIENTATION OF BRANCH HOSE	VISUAL	CRITICAL	VISUAL	100%	100%	APP DRG	IR	W	W		
C	ROUTINE TEST											
1	HYDRO TESTING / LEAK TEST	LEAKAGE	CRITICAL	APP. DRG.	100%	20%	APP. DRG.	IR	P	W		
D	ASSY. CONSTRUCTION											
1	VISUAL APPEARANCE	NO ABNORMALITY / HARMFUL DEFECT	CRITICAL	VISUAL	100%	20%	APP. DRG.	IR	P	P	The Hose shall be free from Welding Burrs and Split/loose Fibres of Braid	
2	MARKING # (IDENTIFICATION	IDENTIFICATION	MAJOR	-- PUNCHING	100%	20%	LEGIBLE	IR	P	W		

	M- Manufacturer/Sub-Vendor; B - BHEL / TPI P - Perform; W - Witness V - Verification; IR -Inspection Report, MTC -Material TC		
Signature of Manufacturer/Sub-Vendor			Name & Signature of BHEL approving authority