

		Condenser and Heat Exchanger Engineering BHEL Bhopal		QUALITY ASSURANCE PLAN				Doc. No.		CDE-20-3483	
				ITEM				Revision		01	
				Aluminum tube				Date		29.09.2020	
								Page		1 of 1	
S.No.	Components & Operations	Characteristics	Class	Type of Check	Quantum of check	Reference Document	Acceptance Norms	Forma t of Record s	Agency	Remarks	
								1	2	3	
1	2	3	4	5	6	7	8	9	10	11	
FINISHED PRODUCT INSPECTION											
1.1	Mechanical and chemical properties	Chemical composition (Ladle Analysis)	Major	Visual +I	1 no. per lot	IS-1285- (2002) Gr.- 63400, T4	IS-1285 (2002) Gr.- 63400, T4	MTC & TCR	P	R	R
1.2	Dimensional check	Mechanical Properties	Major	Visual +I	1 no. per lot	IS-1285 (2002) Gr.- 63400, T4	IS-1285 (2002) Gr.- 63400, T4	MTC & TCR	P	R	R
1.3	Packing & Dispatch	Dimensions as per indent (OD x Thickness, Length)	Major	Visual +I	100%	As per indent	As per indent	IR	P	W	-
		To be packed in sturdy wooden box to avoid damage during transit and storage.	---	Visual	100%	--	--	IR	P	-	-
LEGEND : 1: Tube Supplier, 2: Inspection Agency, 3: Customer / Customer's IA; P-Perform, W-Witness, R-Review MTC: Mill test Certificates, TCR: Test Certificate Report, IR: Inspection report, IA: Inspection Agency, I: Instrument to be used for check, HP: Hold point.											
Note: 1. All mechanical & chemical testing to be done in-house by NABL calibrated instrument or by NABL approved lab.											
Approval does not relieve supplier from meeting contract requirements as per the drawing / Tech. specification.											
				Prepared by :		Reviewed by :		Approved by :			
				 Arun Kumar Singh (Dy. Mgr.- CDE)		Lalit Asnani (DGM - CDE)		 S.P. Vatsa (AGM-CDE)			