



QGX-9

QA PLAN FOR KEYS (FOR POLE, RIM, STATOR SOLE PLATE AND SHAFT TO SPIDER COUPLING)

QA PLAN FOR: KEYS (FOR POLE, RIM, STATOR SOLE PLATE AND SHAFT TO SPIDER COUPLING)

SHEET 1 of 1

QA PLAN NO: QA/HG/570

SL. NO.	COMPONENT/ASSY/ OPERATION	CHARACTERISTICS	CLASS	TYPE	QUANTUM OF CHECK	REF. DOC.	RECORD FORMAT	AGENCY		REMARKS
								SUPPLIER	QIX/TPIA	
1.0	Raw Material	a) Material certification (Chemical analysis & Mechanical properties)	Maj	Chem + Mech	Sample	Drg./Spec	TC	P	V	
		b) Material Identification.	Maj	Review	100%	Drg./Spec	QCR	P	V	
1.1	Keys	a) Visual dimensional checks and check for concavity/convexity of individual keys	Cri	Vis & M	100%	Drg.	QCR	P	V,W	20% qty to be witnessed by QIX/TPIA.
		b) Dimensional checks of keys in pair	Cri	M	100%	Drg.	QCR	P	V,W	20% qty to be witnessed by QIX/TPIA.
		c) Surface finish	Cri	M	100%	Drg.	QCR	P	V,W	20% qty to be witnessed by QIX/TPIA.
		d) Application of TRP on machined surfaces	Maj	Vis	100%	Drg./Spec	QCR	P	V,W	20% qty to be witnessed by QIX/TPIA.
		e) Packing & dispatch of taper keys in pair	Maj	Vis	100%	Drg./Spec	QCR	P	V	

Notes:

- Each key to be manufactured and checked as per the TR mentioned in drawing.
- Key shall be coated with rust preventive compound as per drawing before dispatch.
- All taper keys to be dispatched in pairs only.

Certification: Supplier shall submit 3 copies of test certificates duly countersigned by QIX/TPIA incorporating the following:-

- Raw material test certificates of original manufacturer from NABL approved lab / material test certificate from NABL approved lab.
- Test certificates/inspection records of test conducted on keys as per drawing/specification.

Abbreviations: Chem - Chemical, Cri - Critical, D - Dimension, Elect - Electrical, Maj - Major, M - Measurement, Mech - Mechanical,
P - Perform, QIX - Quality Control Ancillary, QCR - Quality Control Record, R - Review, T - Test, TC - Test Certificate,
TPIA - Third Party Inspection Agency, V - Verify, Vis - Visual, W - Witness.

[Signature]
HGE Nishant
shah
RITESH KATBHARE (Dy. Mgr/HGE)
DGM (HGE)

[Signature]
HGM
(Nishant Shah, HGM)

[Signature]
QHG
(NAKENDRA KUMAR)
SR LMR, BEH

[Signature]
20/4/19
QI (Hydro)
ADHAR SHARMA
S. Engineer (QNT)
आधार शर्मा
वरि अभियंता (विद्युत प्रणाली) / Quality Control
गुणता नियंत्रण-जल प्रणाली / BEH, BIL
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