



QUALITY ASSURANCE DEPARTMENT

QA PLAN FOR: STATOR PRESSING PLATE ASSY

QA PLAN NO: QA/TIG/499

SHEET 1 OF 2
REVISION: 02
DATE: 23/06/2017

SL. NO.	COMPONENT/ASSY/ OPERATION	CHARACTERISTICS	CLASS	TYPE	QUANTUM OF CHECK	REF. DOC.	RECORD FORMAT	AGENCY		REMARKS
								SUPPLIER	QIX/TPIA	
1.0	Raw Material (Pressing Plate, Finger & Baffle)	a) Material certification (Chemical analysis & Mechanical properties)	Maj	Chem + Mech	Sample	Drg./Spec	TC	P	V	
		b) UT of pressing plates	Maj	UT	100%	Drg./Spec	QCR	P	V, W	10 % to be witness by QIX/TPIA
1.1	In process inspection	a) Flatness of pressing plate before machining & Parallelity of finger before welding to be checked as per drawing requirement.	Cri	Vis + M	100%	Drg./Spec	QCR	P	V	
1.2	Stator Pressing Plate Assy.	a) DP on all welds	Cri	DP	100%	Drg./Spec	QCR	P	V, W	
		b) For each Pressing plate assy, level difference between individual finger after welding and after machining	Cri	Vis + M	100%	Drg./Spec	QCR	P	V, W	20 % to be witness by QIX/TPIA
		c) Visual & Dimensional checks of stator pressing plate Assy.	Cri	Vis + D	100%	Drg./Spec	QCR	P	V, W	20 % to be witness by QIX/TPIA
HGE			HGM			QIG			QA-HYDRO	

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QGX-9

QUALITY ASSURANCE DEPARTMENT

QA PLAN FOR: STATOR PRESSING PLATE ASSY.

QA PLAN NO: QA/HO/499

SHEET 2 OF 2

REVISION: 02

DATE-23/06/2017

SL. NO.	COMPONENT/ASSY/ OPERATION	CHARACTERISTICS	CLASS	TYPE	QUANTUM OF CHECK	REF. DOC.	RECORD FORMAT	AGENCY		REMARKS
								SUPPLIER	QIX/TPIA	
		d) Painting & Paint adhesion test	Maj	Vis + T	100%	Drg./Spec	QCR	P	V, W	10 % to be witness by QIX/TPIA
		e) Marking, Identification, Protection, Packing & despatch	Maj	Vis	100%	Drg./Spec	QCR	P	V	

Notes:

1. MOT / Fixture are to be made for checking of pressing plates to be arranged by vendor. Dimensions of MOT/Fixture to be approved by QIX before Checking.
2. Each pressing plate assy to be manufactured and checked as per TR mentioned in drawing.
3. Welding and TRP applications are to be done as per requirement mentioned in drawing.
4. Surface finish of machined surfaces shall be as per drawing requirement.
5. On each pressing plate Assy. project wise running serial number to be hard punched.

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

- I) Raw material test certificates of original manufacturer and material test certificate from NABL approved lab.
- II) Test certificates/inspection records of tests conducted on pressing plate as per drawing/specification.

Abbreviations: Chem - Chemical, Cri - Critical, D - Dimension, DP - Dye Penetration test, 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.

Rev.00 Dt. 25/08/2016

Rev.01 Dt. 24/12/2016: (1). Inspection agency modified in agency column. (2). Note I modified. (3). Remark column modified.

Rev.02 Dt. 23/06/2017: (1). Type, Record format, Agency & Remark column modified. (2). Paint adhesion test, Note 5 & abbreviations added. (3). MPT & S.no. 3 of certification deleted.

HGE

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