

 BHOPAL	TECHNICAL PRE-QUALIFICATION REQUIREMENTS (T-PQR)	DOC. NO. : HGG-1905 DATE: 17.05.2019 REV. - 00 PAGE 1 OF 1
	HYDRO GENERATOR ENGINEERING DIVISION	

Technical Pre-Qualification Requirements (T-PQR) for POLE KEY for hydro-generators.

S. No.	Description of pre-qualification requirement	Vendor Response	
		Complied/Not complied	Supporting Documents required to accept compliance
1.	Compliance to attached Drawing of Pole Keys & Quality Plan QA/HG/570		Confirmation required.
2.	Company to be ISO-9001 certified		Valid ISO-9001 certificate.
3.	Source of Raw material - Use of raw material from reputed national/ international brands.		Confirmation required.
4.	The company should have experience of supplying at least 3 supplies of Pole Keys or similar tapered long keys in last 10 years.		Copy of PO to be submitted

Note:

1. Financial year to be considered for the said experience period i.e. material supplied F.Y 2010-11 onwards will be acceptable.
2. Compliance to above Pre-qualification requirements are mandatory. In absence of compliance of above requirements vendor PQ application is liable to be rejected.
3. BHEL has right to verify information/ confirmation furnished, by asking additional documents proofs etc.


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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/HIG/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

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