

BHARAT HEAVY ELECTRICAL LIMITED, BHOPAL QUALITY CONTROL- MOTOR GROUP QUALITY PLAN-CASTED STATOR FRAME FOR H COMPACT QAP No. QA/MT/BOI/058 REV.-00 DTD. 27.09.2019													
SL.NO.	COMPONENT S	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENTS	ACC.NORMS	REC. FORMAT	D	AGENCY		REMARKS
					M	B					M	B	
1	2	3	4	5	6	7	8	9	10	D*	11		12
1	STATOR FRAME CASTING												
1.1	INPROCESS	HEAT TREATMENT	MAJ.	MECH	100%	100%	AA 19702/DRG	AA 19702/DRG	QCR	✓	P	V	
		MECHANICAL PROPERTIES (TENSILE STRENGTH, HARDNESS)	MAJ.	MECH	Sample		AA 19702/DRG	AA 19702/DRG	TC	✓	P	W	
		SURFACE FINISH	MAJ.	VISUAL	100%	100%	DRG	DRG	QCR		P	V	
		DIMENSIONAL CHECKS	MAJ.	MEAS.	100%	100%	DRG	DRG	QCR	✓	P	W	
		MAGNETIC PARTIAL EXAMINATION	MAJ.	NDT	100%	ONE FRAME PER TYPE AND RATING	AA 0850133	AA 0850134	TC	✓	P	W	TEST RECORD REVIEW
1.2	DESPATCH	IDENTIFICATION ON CASTING AS PER CPS	MAJ.	VISUAL	100%	100%	DRG./PO	DRG./PO	QCR		P	V	

D*- Documents for submission
 M MANUFACTURER/SUB-SUPPLIER, B: BHEL/TPIA, P: PERFORM, W: WITNESS, V: VERIFICATION AS APPROPRIATE
 QCR-QC record, TC -Test Certificate

(Signature)
 Sr. Asstt. Engineer, QA, BHEL, Bhopal
 Date: 27.09.2019

Prepared By

Approved by