



एनटीपीसी लिमिटेड

(भारत सरकार का उद्यम)

NTPC Limited

(A Govt. of India Enterprise)

(Formerly National Thermal Power Corporation Ltd.)

केन्द्रीय कार्यालय नोएडा

Corporate Centre NOIDA

Reference: CC:RM:104:2658

Date:27-07-18

From:	K.MUKHOPADHYAY AGM	To:	BHEL SSBG, KRIBHCO BHAWAN, SECTOR-1, NOIDA
		CC:	- - -
SUBJECT : KHTPP1, RENOVATION AND RETROFITTING OF ESP PACKAGE FOR KHSTPS STAGE-I 4X210 MW			
Please find enclosed following drawings/documents for necessary action at your end as indicated in purpose code.			
VENDOR DRG NO:	null		
NTPC DRG NO:	4210-104-QVC-G-026		
REVISION NO:	02		
DRG TITLE:	FQP penthouse roofing sheets		
APP CATEGORY:	I		
RELEASE DATE:	27-07-18		
COMMENTS:	CAT-I with Minor comments		



Engineering Division
ISO 9001:2008 Certified

अभियांत्रिकी कार्यालय परिसर, प्लॉट नं.- ए 8ए, सेक्टर-24, पोस्ट बॉक्स नं.- 13, नोएडा (उ प्र) पिन-201 307

टेलिफोन नं.- 0120-2410333, 2410116 फैक्स-0120-2410136, 2410137

पंजीकृत कार्यालय: एनटीपीसी भवन, स्कोप कॉम्प्लेक्स, 7 इंस्टीट्यूशनल एरिया, लोधी रोड, नई दिल्ली-110 003

टेलिफोन नं.- 011-24361018 फैक्स-011-24361018, वेबसाइट: www.ntpc.co.in

ENGINEERING OFFICE COMPLEX, Plot No: A-8A, Sector-24, Post Box No: 13, Noida (UP), Pin-201 307

Telephone No: 0120-2410333, 2410116 Fax-0120-2410136, 2410137

Registered Office: NTPC Bhawan, Scope Complex, 7 Institutional Area, Lodhi Road, New Delhi-110 003

Telephone No: 011-24360100 Fax-011-24361018, Website: www.ntpc.co.in

PROFILER'S NAME & ADDRESS : Multicolor Steels (I) Pvt. Ltd., Plot No. 370-371, Sector - 3, Phase-4, Bawal, Haryana			MANUFACTURING QUALITY PLAN			DATE : 18.07.2018			PROJECT: KAHALGAON			
Coil Manufacturer Details : Bhushan Power & Steels, Sambalpur, orissa/ JSW Steel, Kalmeshwar			ITEM : Permanently Colour Coated Metal Sheets for Roof & Cladding.			PAGE : 1 OF 2			MAIN SUPPLIER : M/S BHEL Ltd, RANIPET			
			QIP No. : 4281147 dt. 15.05.2018			QIP No. : MSIP/L/18-19/1001			PO NO. : 4281147 dt. 15.05.2018			
			Rev No. 0									
SL. NO.	COMPONENTS & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS
					M	C/N			D	M	C/N	
1	2	3	4	5	6	7	8	9	10			11
1	Weight of galvanised coating (both sides inclusive)	To check the weight of coating	Major	Measurement	100%	Ref Note 1	Approved Data Sheet 1397	Test Report	✓	P	W	Mass of Zinc coating for triple spot test = 275 gsm
2	Chemical Composition of Bare metal	To check chemical analyses of bare metal	Major	Chemical	100%	Ref Note 1	Approved Data Sheet	Test Report	✓	P	V	Manufacturer's Test Certificate
3	Bare Metal Thickness	To check the thickness	Major	Measurement	100%	Ref Note 1	Approved Data Sheet / IS 513	Test Report	✓	P	W	
4	Thickness of colour coating	To check the Coating	Major	Measurement	100%	Ref Note 1	Approved Data Sheet	Test Report	✓	P	W	To check coating by paint inspection gauge
5	Yield strength/UTS & % Elongation	To verify mechanical properties	Major	Mechanical Test	100%	Ref Note 1	Standard referred in approved Data Sheet	Test Report	✓	P	W	
6	Pencil Hardness of painted surface (2H)	To check hardness	Major	Mechanical Test	100%	Ref Note 1	AS 2728 /NTPC Specs	Test Report	✓	P	W	
7	Impact Resistance Test	To check for impact strength	Major	Mechanical Test	100%	Ref Note 1	AS 2728 /NTPC Specs	Test Report	✓	P	W	
8	Bend Test	To check no peeling of paint during bending	Major	Mechanical Test	100%	Ref Note 1	AS 2728 /NTPC Specs	Test Report	✓	P	W	
9	Finish type of paint/ coating both sides	To check the Coating	Minor	Certificate of Conformance	100%	Ref Note 1	Approved Data Sheet	Test Report	✓	P	V	To furnish Certificate of Conformance
10	Video Jet Printing @ 1.5m on sheet with Coil Manufacturer's name & date	As per order	Major	Visual	100%	Ref Note 1	Indication of Marks	Inspection Report	✓	P	W	To be verified first at Coil Manufacturer's work & second at profiler's work with proper correlation
11	Colour Match of Batch	To check colour	Major	Visual	100%	Ref Note 1	Colour to match as per approved data sheet & drawing.	Inspection Report	✓	P	W	
 MANUFACTURER / SUBCONTRACTOR FOR CUSTOMER USE  REVIEWED BY DOC No.:												
D : Records identified with "Tick" shall be essentially included by contractor in QA documentation. M : Manufacturer/Sub contractor, C : MAIN CONTRACTOR, N : NTPC ; P : Perform, W : Witness V : Verification P/R : Perform at Coil Manufacturer's Works R : Review of TC at Profiler Works												
NAME & SIGN OF APPROVING AUTHORITY												

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				MDL NO: 4210-104-QVC-G-026		QP No. : MS/PL/ 18-19/1001		PO NO.: 4281147 dt. 15.05.2018				
				Rev No. 0								
SL. NO.	COMPONENTS & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY	REMARKS		
1					M				D			
12	Salt Spray Test for 1000hrs	3	4	5	6	7	8	9	10	11		
13	Dimensions(after Profiling)	To check corrosion	Major	Chemical Test	Remark 1	Remark 1	No corrosion on both sides	Test Report	✓	ASTM B 117		
14	Workmanship, Visual examination and appearance of profiled sheet	To check dimension	Major	Measurement	100%	Approved data sheet/Approved Dwgs	Approved data sheet/Approved Dwgs	Test Report	✓	Tolerance as per IS 277		
			Major	Measurement/ Visual	100%	No surface defects and no peeling of colour	Approved Drawings/NTPC Tech Specs.	Inspection Report	✓	At Profile Manufacturer		
Note: (1) Random ☒ samples shall be selected out of total quantity offered for inspection during visit by NTPC & Contractor at coil manufacturer works for testing of coil.												
Note: (2) Tests 1 to 11 shall be carried out at coil manufacturer's works before despatch of coils. SI no. 13 & 14 shall be carried out at Profiler's Works												
Note: (3) Coil manufacturer's co related TCs also to be submitted for review.												
Remarks: 1. For Salt spray test, minimum ☒ samples shall be selected during inspection of coils by NTPC and any one to be sent for testing at 3rd party lab Spectro Analytical Labs. Test reports to be submitted for review and acceptance of NTPC authority.												
				LEGEND D : Records identified with "Tick" shall be essentially included by contractor in QA documentation. M : Manufacturer/Sub contractor; C : MAIN CONTRACTOR ; N : NTPC ; P : Perform, W : Witness V : Verification P/R : Perform at Coil Manufacturer's Works R : Review of TC at Profiler Works				FOR CUSTOMER USE 			DOC No.:	
MANUFACTURER / SUBCONTRACTOR				MAIN SUPPLIER				REVIEWED BY				
								NAME & SIGN OF APPROVING AUTHORITY				