



BHARAT HEAVY ELECTRICALS LIMITED, JHANSI

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BHEL CX007/0006		STANDARD SUB-VENDOR QUALITY PLAN FOR : Electro Plating of Silver On Aluminium and it's Alloys		MATERIAL INSPECTION / IN PROCESS INSPECTION / FINAL INSPECTION		SUB-VENDOR'S / VENDOR'S / CONTRACTOR'S WORKS.		QP.No. QP/BD/164, Ro2 Rev.02 Date 16.07.2003 Page 1 of 4	
COMPONENT AND OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTAN CE NORMS	FORMAT OF RECORD	AGENCY	REMARKS
2	3	4	5	6	7	8	9	10	11
A Composition And maintenance of Bath Solution	a) Alkaline degreasing solution	B	I	Sample to be taken	SG: 15600 Cl. 6.1	SG: 15500 Cl. 6.1	Sub vendor Check list / Formats / Records	Sub vendor	Review of records by BHEL (periodic surveillance by BHEL inspector)
	b) Chromic sulphuric acid pickling solution	B	I	from bath	Cl. 6.2	Cl. 6.2			
	c) De oxidizing solution	B	I	Sample	Cl. 6.4	Cl. 6.4			
	d) Zincate solution	B	I	Sample	Cl. 6.5	Cl. 6.5			
	e) Copper plating solution	B	I	Sample	Cl. 6.6	Cl. 6.6			
	f) Potassium Cyanide dip solution	B	I	Sample	Cl. 6.7	Cl. 6.7			
	g) Silver strike solution	B	I	Sample	Cl. 6.8	Cl. 6.8			
	h) Silver plating solution	B	I	Sample	Cl. 6.9	Cl. 6.9			
	i) Brighter addition	B	I	Sample	Cl. 7.9	Cl. 7.9			
	j) Anti tarnishing solution	B	I	Sample	Cl. 6.10	Cl. 6.10			

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STANDARD SUB-VENDOR QUALITY PLAN FOR Electro Plating of Silver On Aluminium and it's Alloys

MATERIAL INSPECTION / IN
PROCESS INSPECTION /
FINAL INSPECTION

SUB-VENDOR'S /
VENDOR'S /
CONTRACTOR'S
WORKS

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Rev.02
Date 16.07.2003
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CHANDRA SHEEL ELECTRICALS LIMITED

B.E.L. COX/007/0006		STANDARD SUB-VENDOR QUALITY PLAN FOR Electro-Plating of Silver On Aluminium and its Alloys		MATERIAL INSPECTION / IN PROCESS INSPECTION / FINAL INSPECTION		SUB-VENDOR'S / VENDOR'S / CONTRACTOR'S WORKS		QP.No. QP/BD/164 Rev.02 Date 18.07.2003 Page 4 of 4		
SL No	COMPONENT AND OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTAN CE NORMS	FORMAT OF RECORD	AGENCY	REMARKS
1	2	3	4	5	6	7	8	9	10	11
F	Protection coating for silver plating	a). Application of protective coating a) Drying b) Packing c) Removal of packing & protective coating	B B B B	I I I I	100% 100% 100% 100%	BD:15012 P Cl. 1.0 Cl. 2.0 Cl. 3.0 Cl. 4.0	BD:15012 P Cl. 1.0 Cl. 2.0 Cl. 3.0 Cl. 4.0	Sub vendor Check list / Formats	Sub vendor At Site	Review of Records
AGENT - A - Critical Inspection - B - Major Inspection - C - Minor Inspection - D - Final Inspection										
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LEGENT :- A :- Critical, I :- Inspection, B :- Major, TC :- Test Certificate, T :- Testing
OS :- Observation sheet, C :- Minor, V :- Visual, Drg. :- Drawing.

Prepared by

(H N SHAKYA)
Dy. MANAGER (COX)

Approved by

(P K JAIN)
DGM (COX)

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