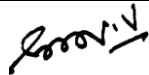
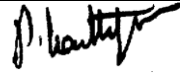


 RANIPET		Quality assurance M/S BHEL BAP RANIPET TAMILNADU 632 406		STANDARD QUALITY PLAN						
				ITEM/SUB SYSTEM PINION (37,42,43,47,50 TEETH)			Doc No	SQP APH 112		
							Rev No.	00		
							Date	18 05 2010		
							Page No	Page 1 of 2		
Sl No	Component /Description	Characteristics	Type of check	Quantum of check	Reference document	Acceptance standard	Format of Records	Agency Supplier	BHEL	Remarks

1.0 Raw material										
1.1	Chemistry	Material composition	TC verification	One no per heat	Materail specification as per APSQ/Approved drawing	Test certificate	W	V		
1.2	Mechanical test	Tensile/yield /Elongation,	TC verification	One no per heat	Materail specification as per APSQ/Approved drawing	Test certificate	W	V		
2.0 Inprocess Inspection										
2.1	Dimensional inspection(Proof machining)	Dimensions	Measurement	100%	Approved drawing	Inspection report	W	V		
2.2	Non destructive testing	Soundness	UT	100%	ASTM A388 (**)	-DO-	W	V		
3.0 Final Inspection										
3.1	Finish turning/teeth machining	Measurement	Measurement	100%	APSQ /Approved drawing	-DO-	W	W	Ref Note	\$\$

() When back wall Echo is set to 100 % of FSH in Sound area a) Defect Echo not to exceed 20 % of FSH during scan.b) Back wall Echo loss permissible is 20 % of FSH.**

(\$\$) 1.Faceout,2.Runout,3.Bore diameter,4.Key location,5.Key dimension,6. Diametral pitch, no of teeth, circular pitch, Total tooth depth, chrordal height , chordal width, width across 5 teeth,.

Prepared By	Reviewed by	Approved by
		

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3.2	Teeth hardening	Type of hardening	Hardness	100%	APSQ/ Approved drawing	-DO	W	W	
3.3	Surface examination	NDT	Dye penetrant testing	100%	No visual defects	-DO-	W	W	
4.0	Identification	Serial no and supplier name	Visual	100%	Vendor practice	-DO-	W	V	
4.1	Protective coating	Surface preparation	Measurement	100%	APSQ/Approved drawing	-DO-	W	V	Two coats Zinc phosphate on body (60 microns)and Sea worthy Rust preventive oil on teeth.
		Painting/Protect ive coating	-do-	-do-	APSQ/Approved drawing	-DO-	W	V	
5.0	Packing (Two layers - Polythene and Gunny bag in wooden box packing)	Visual	Visual	100%	BHEL appvd drawing/vendor drawing	-DO-	W	V	

Not e : Dimnessions and tolerance shall be as per respective APSQ .

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