

## BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

			MA	NUFACTURING	QUALITY PLAN	мссв							
		Customer	Vendor's Code	Item:	MQP No: 012					Valio			15.01.2016
		BSPTCL	Code	мссв	Rev. No. 00					Valio	d	-	Till Revision
		BSFICE		MCCB	Date : 02.01.2016					Page	e: 1 (	of 12	
Sr.	Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		Ар	plicat	ble Co	odes		Remarks
No.	Description of Test	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Sampling with basis			of Record	1	2	3	4	5	6	
	Indicates place where testing is						1 1						
Code 1	performed i.e. Inspection Location	ו		Code 2	Indicate who has to p The Equipment	perform the	e tests	i.e. 1	Festin	g Age	ency		
А	At Equipment Manufacturer's wor	ks		J	Manufacturer The Component								
В	At Component Manufacturer's wo	rks		К	Manufacturer								
C D	At Authorised Distributor's place			L M	The Third Party								
E	At Independent Lab At Turn Key Contractor's location			IVI	The Turnkey Contract	or							
F	Not specified												
	Indicates place who shall witnes	<b>s</b> tests i.e. Witne	ssing		Review of Test								
Code 3	Agency			Code 4	Reports/Certificates								
Р	Component Manufacturer itself			W	By Equipment manufa	acturer							
Q	Component Manufacturer and Eq			Х	By Contractor during	product/pro	cess in	spec	tion				
R	Component Manufacturer, Equipricontractor	nent Manufacture	er and	Y	BY BSPTCL during pr	roduct/proc	ess inc	necti	on				
ix.					By Contractor and/or					cess			
S	Equipment Manufacturer itself			Z	inspection.								
т U	Equipment Manufacturer and Cor Equipment Manufacturer, Contract												
V	Third Party itself												
	Whether specific approval of sub-				Whether test records					er fina	l inspe	ection	
Code 5	All packing cases should be mark	ed with BSPTCL	LOA details, name of p	Code 6	for issuance of Dispa Yes	tch Cleara	nce / In	struc	tions				
E N	Envisaged Not Envisaged			Y N	Yes No								

		B	IHAR STATE I	POWER TRAN	ISMISSION CO	MPAN	Y LIM	TEL	)			
			МА	NUFACTURING (	QUALITY PLAN I	мссв						
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			Code		Rev. No. 00		<u> </u>		Valid Upto			Till Revision
		BSPTCL		МССВ	Date : 02.01.2016					:: 20	f 12	
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Sr. No.	Components / Operations & Description of Test		Quantum of Check / Sampling with basis	Reference document for	Acceptance Norms	Format of	A 1 2	oplical 3	ole Co 4	des 5	6	Remarks
				Testing		Record						
1	NOTE: The MQP should be read in conju	action with BSPT	CL specification and st	all deem to include a	dditional tests if any req	uired as ne	ar the cont	act				
			•					acı.				
2	BSPTCL specification shall include test procedure applicable to the sp		tter of Award, BSPTCL	approved drawings /t	echnical data sheet / BC	OM / test so	chedule /					
3	In case of any contradiction betwee i) BSPTCL specification	en the manufactu	urer's plant standards,	this MQP and BSPTC	L specification following	precedenc	ce shall be	follow	ed :-			
	ii) This Manufacturing Quality pla iii) Manufacturer's plant standard											
4	It is the responsibility of the manuforder to avoid any delay at the time		that this document is	readily available at the	eir works, as well as at t	he works o	f their sub	vendo	rs in			
5	The manufacturer shall ensure that calibration certificates traceable to Key testing instruments will be ca	Indian/Internatio	nal standards. Calibra	tion records should be	e available during inspe			nave				
0						TO						
6	In case of any tests being carried		-									
7	The manufacturer shall maintain to available during inspection by BSI		tion of test certificates	from raw material stac	ge to finished product st	age and the	e records :	should	be			
8	Manufacturer shall show the appro specification at the time of final ins		engineering for all contr	act specific type tests	s, including specific type	tests if any	/ as per th	e BSP	TCL			
9	All packing cases should be mark for dispatch.	ed with BSPTCL	LOA details, name of p	project, item descriptio	n and Dispatch Clearar	nce / Instru	ctions nu	nber b	y whicl	h mate	erial ha	as been cleared
40	•		<i>2</i>									
10	One copy of test report, Dispatch	Clearance / Instru	uctions shall also be se	ent along with consign	ment.							

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		BSPTCL	Code	МССВ	Rev. No. 00					Valid Upto:		+	Till Revision
				MOOD	Date : 02.01.2016					Page	: 3 0	of 12	
Sr.	Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		App	plicat	ole co	des		Remarks
No.	Description of Test		Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
11	Inspection of spare items ordered	by BSPTCL shal	I also be governed by t	he provisions of this N	IQP. Items if not gover	ned under	MQP s	hall b	be offe	ered fo	or insp	ectior	<u>ו</u>
	as per BSPTCL specification / Re	levant-Indian / In	ternational Specification	า									
12	The manufacturer shall align their	auality system a	nd that of their sub ven	dors to the requirement	nts of latest ISO 9000 o	uality stand	tarde ir	n a tir	ne ho	und M	annei	r	
12						uanty start		1 4 11			annei		
		1	1		1		1 1						l .
13	The relevant details of plant stand	dards and quality	plan for different rating	s are shown in attache	ed Annexure.								
11	BSPTCL may review the effective	implementation	of the processes during	the product increation	n / process inspection i		violotia	on in	nrooo		rooo		
14	parameters are observed, the rea						violatio	JUIU	proce	55 01	JIOCE	55	
		son along with oc				TZ WCCR3.							
	EM : Equipment Manufacturer		CM: Compo										
		1	Manufacturer		1		<u>г</u>			<b></b>		<u> </u>	I
		1										<u> </u>	
	All packing cases should be mark	ed with BSPTCL	LOA details, name of p	roject, item descriptio	n and Dispatch Cleara	nce / Instru	ctions	numl	ber by	/ which	n mate	erial h	as been cleared

			BIHAR STATE	E POWER TRA	NSMISSION C	COMPA	NY	LIN	1ITE	ED			
			Γ	MANUFACTURING	QUALITY PLAN	МССВ							
		Customer		Item:	MQP No: 012	-				Valid			15.01.2016
			Code							From:			10.01.2010
					Rev. No. 00					Valid		ļ	Till Revision
		BSPTCL		MCCB						Upto:			
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Sr.	Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		Ар		ole Coo			Remarks
No.	Description of Test		Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
Α	RAW MATERIAL/COMPONENTS	S INSPECTION:											
1.0	COPPER STRIPS												
1.1	Dimensions	Measurement	One sample from	BSPTCL	BSPTCL		А	J	S	W	Ν	N	
			each Lot	specification	specification	BSPTCL							
						Record							
1.2	Conductivity	Electrical		BSPTCL	BSPTCL		Α	J	S	W	Ν	Ν	
			each Lot	specification	specification	BSPTCL Record							
				-	min conductivity	Record							
					97.0 IACS								
1.3	Cleanliness & Surface	Visual	5% on each	As per EM	As per EM		А	J	S	W	N	N	
_	Smoothness (Visual Check)		lot	specification	specification	BSPTCL		-					
				The strips shall	The strips shall	Record							
				be bright and clean.	be bright and clean.								
				It shall be free from	It shall be free from								
				blisters, scale, fins,	blisters, scale, fins,								
				spills cracks and	spills cracks and								
				other defects.	other defects.								

			BIHAR STATE	E POWER TRA	NSMISSION C	OMPA	NY	LIM	ITE	ED			
			M	IANUFACTURING	QUALITY PLAN	МССВ							
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Sr.	Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		Ap	olicat	le Co	des		Remarks
No.	Description of Test		Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
2.0	BRASS STRIP/COIL/SHEET:												
													-
0.4				<b></b>						14/	NI	NI	
2.1	Dimensions	Meas.	One sample from	EM specification	As per EM	BSPTCL	Α	J	S	W	Ν	Ν	
			each Lot		specification								
						Record							-
													+
2.2	Conductivity	Elect.	One sample from	EM specification	As per EM		Α	J	S	W	Ν	Ν	1
			each Lot	BSPTCL Specs	specification	BSPTCL							
				İ '	Power Grid Specs	Record							
				Ĩ									
			50/										
2.3	Cleanliness & Surface	Visual	5% on each	As per EM	As per EM	50570	Α	J	S	W	Ν	Ν	
	Smoothness (Visual Check)		lot	specification	specification	BSPTCL							
				The strips shall	The strips shall	Record							
				be bright and clean.	be bright and clean.								
				It shall be free from	It shall be free from								+
				blisters, scale, fins,	blisters, scale, fins,								
				spills cracks and	spills cracks and								+
				other defects.	other defects.								
													+
	All packing cases should be mark	ed with BSPTCL	LOA details, name of p	project, item descriptio	n and Dispatch Cleara	ince / Instru	ictions	s num	ber b	y whic	h mat	terial h	nas been cleared
	One copy of test report, Dispatch	Clearance / Instr	uctions shall also be se	ent along with consign	ment.								

S	r.	Components / Operations &	Type of	Quantum of Check /	Reference document for	Acceptance Norms	Format		Ар	plicab	le Co	des		Remarks
No	0.	Description of Test	Check	Sampling with basis	Testing		of Record	1	2	3	4	5	6	
3.0		Plastic granules/chips: Arnit	e, Stanyl & Nyl	on PA6										
	3.1	Type / Description	Visual	check the lot	As per vendor MTC	As per identity tag with		А	J	S	W	N	Ν	
	0		Tioud.			packing bag & Bill data sheets	BSPTCL		•					
							Record							
4.0		components:												
	4.1	Fix Contact			As per approved BSPTCL	As per approved BSPTCL		A	Л	<u> </u>	14/	NI	N	
			-		drawings As per approved BSPTCL	drawings As per approved BSPTCL		А	J	S	W	N	Ν	
	4.2	Fix Contact Tip			drawings	drawings		A	J	s	w	Ν	Ν	
				As per Sampling	As per approved BSPTCL	As per approved BSPTCL	BSPTCL	Α	•	•				
	4.3	Fix Contact Packing	measurement	Plan IS 2500	drawings	drawings	Record		J	S	W	Ν	Ν	
	11	Arcing Horn			As per approved BSPTCL	As per approved BSPTCL		Α						
	4.4				drawings	drawings			J	S	W	Ν	Ν	
	4.5	Arcing Horn Rivet			As per approved BSPTCL	As per approved BSPTCL		Α		~				
				As per Sampling	drawings As per approved BSPTCL	drawings As per approved BSPTCL		^	J	S	W	N	Ν	
	4.6	Cross bar 3P	measurement		drawings	drawings		A	J	s	w	N	Ν	
				1 10 2000	As per approved BSPTCL	As per approved BSPTCL		Α	5	0	vv		1	
	4.7	Dolly			drawings	drawings		~	J	s	W	Ν	Ν	
		Machaniam Diata 18D			As per approved BSPTCL	As per approved BSPTCL		Α						
	4.8	Mechanism Plate- L&R			drawings	drawings			J	S	W	Ν	Ν	
		Dolly Support Guide Pin			As per approved BSPTCL	As per approved BSPTCL		Α		_				
	4.9		_		drawings	drawings			J	S	W	N	Ν	
	4.12	Latch		As per Sampling	As per approved BSPTCL drawings	As per approved BSPTCL drawings	BSPTCL	A	.1	s	w	N	Ν	
			measurement	Plan IS 2500	As per approved BSPTCL	As per approved BSPTCL	Record	Α	J	3	vv		IN	
	4.13	Latch Pin			drawings	drawings	Record	~	J	s	w	Ν	Ν	
			1		As per approved BSPTCL	As per approved BSPTCL	1	Α	-	-	- · ·			
	4.14	Dolly Support			drawings	drawings			J	S	W	Ν	Ν	
		Dolly Support Spring			As per approved BSPTCL	As per approved BSPTCL		Α						
	4.15	Bony capport opining	4		drawings	drawings	4		J	S	W	Ν	Ν	
	4.40	Mech Pin			As per approved BSPTCL	As per approved BSPTCL		A		<u> </u>	14/			
	4.16				drawings	drawings			J	S	W	Ν	Ν	

		I		POWER TRANSMIS		LIMITED							
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Sr.	Components / Operations &	Type of	Quantum of Check /	Reference document for	Acceptance Norms	Format of		Appli	cab	le Co	odes		Remarks
No.	Description of Test	Check	Sampling with basis	Testing		Record	1	2	3	4	5	6	
	Components:												
4.17	Arc Chute R Plate			As per approved BSPTCL drawings	As per approved BSPTCL drawings		А	J	s	w	N	N	
4.18	Arc Chute L Plate	T		As per approved BSPTCL drawings	As per approved BSPTCL drawings		А	J	s	w	N	N	
4.40		1		As per approved BSPTCL	As per approved BSPTCL		~	J	3	vv	IN	IN	
4.19	Arc Chute Bottom plate	1		drawings	drawings		А	J	S	W	Ν	Ν	
4.2	Arc Chute Plate			As per approved BSPTCL	As per approved BSPTCL		А	J	s	w	N	N	
		ł		drawings As per approved BSPTCL	drawings As per approved BSPTCL		A	J	3	vv	IN	IN	
4.21	Arc Chute Rivet			drawings	drawings		А	J	s	W	Ν	Ν	
4.22	Arcing Flame Guide	Ţ		As per approved BSPTCL	As per approved BSPTCL				0			N	
	5	ł		drawings As per approved BSPTCL	drawings As per approved BSPTCL	_	A	J	S	W	Ν	IN	
4.23	Cross Bar Guide Bush			drawings	drawings		А	J	s	w	Ν	Ν	
4.24	M6 Nut Cover	measurement		As per approved BSPTCL	As per approved BSPTCL	BSPTCL			-				
		4	IS 2500	drawings As per approved BSPTCL	drawings As per approved BSPTCL	Record	Α	J	S	W	Ν	Ν	
4.25	Aux Tripping Knob			drawings	drawings		А	J	s	w	Ν	N	
4 26	Base bottom washer	1		As per approved BSPTCL	As per approved BSPTCL								
4.20		ł		drawings	drawings	_	Α	J	S	W	Ν	Ν	
4.27	Base Plug			As per approved BSPTCL drawings	As per approved BSPTCL drawings		А	J	s	w	Ν	N	
1 20	Arc chute Barrier	1		As per approved BSPTCL	As per approved BSPTCL								
4.20	Alt thute barrier	4		drawings	drawings		А	J	S	W	Ν	Ν	
4.29	Arc chute Barrier Cover			As per approved BSPTCL drawings	As per approved BSPTCL drawings		А	J	s	w	N	N	
4.0	T	1		As per approved BSPTCL	As per approved BSPTCL	_	~	Ŭ	<u> </u>				
4.3	Top Cover	1		drawings	drawings		А	J	S	W	Ν	Ν	
4.31	Phase Barrier			As per approved BSPTCL	As per approved BSPTCL		А	J	s	w	N	N	
				drawings As per approved BSPTCL	drawings As per approved BSPTCL		A	J	3	vv	IN	IN	
4.32	Base Moulding	1		drawings	drawings		А	J	S	W	Ν	Ν	
4.33	Brass Bush M4*6L	measurement	As per Sampling Plan IS 2500	As per approved BSPTCL drawings	As per approved BSPTCL drawings	BSPTCL Record	А	J	s	w	N	N	
4.0.1		†	0 2000	As per approved BSPTCL	As per approved BSPTCL	100010	~	5	0	vv	IN	IN	
4.34	Hex Nut M6;8.8 grade			drawings	drawings		А	J	S	W	Ν	Ν	
4.35	Switch			As per approved BSPTCL	As per approved BSPTCL		А	J	s	w	N	N	
		†	As per Sampling Plan	drawings As per approved BSPTCL	drawings As per approved BSPTCL	BSPTCL	A	J	3	vv	IN	IN	
4.36	Alarm Switch support	Elect.	IS 2500	drawings	drawings	Record	А	J	S	w	Ν	Ν	
4 27	Self tapping Screw M2x13			As per approved BSPTCL drawings	As per approved BSPTCL drawings		А	J	s	w	N	N	

			BIHAR STAT	E POWER TRA	ANSMISSION C	OMPAN	I YI	LIM	ITE	D			
				MANUFACTURIN	G QUALITY PLAN -	- МССВ							
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		BSPTCL		МССВ	Rev. No. 00	<u>.</u>				Valid Upto			Till Revision
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Sr.	Components / Operations &	Type of	Quantum of Check /	Reference	Acceptance Norms	Format		App	olicab	le Co	des		Remarks
No.	Description of Test	Check	Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
5.0	INPROCESS INSPECTION OF M	ССВ:											
5.1	Surface finish and Sub Assy	Visual	Sub assy inspected 3Times per day	Process & Quality check sheet	Process & Quality check sheet	BSPTCL Record	A	J	S	w	N	N	
	(Visual & Dimensional check)												
					Sub assy shall be ok								
					and free from any defect								
5.2	Riveting	Visual/Manual	Sub assy inspected	Process & Quality	Process & Quality	BSPTCL							
			3Times per day	check sheet	check sheet	Record	A	J	S	W	N	Ν	
5.3	SPOT WELDING	Manual	Sub assy inspected	Process & Quality	Process & Quality	BSPTCL							
			3Times per day	check sheet	check sheet	Record	A	J	S	W	N	Ν	

Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		Ар	olicab	le Co	des		Remarks
Description of Test		Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
Fix Contact Assy. Dimensional & Visual	Visual/VC	Sub assy inspected 3Times per day	As per Process & Quality check sheet			A	J	S	W	N	N	
<b>Cross Bar assembly</b> Dimensional & Visual	Visual/VC	Sub assy inspected 3Times per day	As per Process & Quality check sheet			A	J	S	W	N	N	
<b>6 Mechanism Assy.</b> Dimensional & Visual	Visual/VC	Sub assy inspected 3Times per day	As per Process & Quality check sheet			A	J	S	W	N	N	
Arc Chute Assy. Dimensional & Visual	Visual/VC	Sub assy inspected 3Times per day	As per Process & Quality check sheet			A	J	S	W	N	N	
	Description of Test   Fix Contact Assy.   Dimensional & Visual   Cross Bar assembly   Dimensional & Visual   Mechanism Assy.   Dimensional & Visual   Arc Chute Assy.	Description of Test Image: Construct Assy.   Fix Contact Assy. Visual/VC   Dimensional & Visual Visual/VC   Arc Chute Assy. Visual/VC	Description of Test Sampling with basis   Image: Second constraints Sub assy inspected 3Times per day   Image: Second constraints Visual   Visual Visual/VC   Sub assy inspected 3Times per day   Dimensional & Visual Visual/VC   Sub assy inspected 3Times per day   Dimensional & Visual Visual/VC   Sub assy inspected 3Times per day   Dimensional & Visual Visual/VC   Sub assy inspected 3Times per day   Tare Chute Assy. Visual/VC   Sub assy inspected 3Times per day	Description of TestSampling with basisdocument for Testing4Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheet5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheet6Mechanism Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheet7Arc Chute Assy.Visual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheet	Description of TestSampling with basisdocument for Testing4Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheet5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 	Description of TestSampling with basisdocument for Testingof Record4Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL Record5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL Record5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL Record6Mechanism Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL Record7Arc Chute Assy.Visual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL Record	Description of TestSampling with basisdocument for Testingof Record14Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordA5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordA5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordA6Mechanism Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordA7Arc Chute Assy.Visual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordA	Description of TestSampling with basisdocument for Testingof Record12Image: Second	Description of TestSampling with basisdocument for Testingof Record1234Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJS5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJS5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJS5Mechanism Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJS7Arc Chute Assy.Visual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJS	Description of TestSampling with basisdocument for Testingof Record1234Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSW5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSW5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSW6Mechanism Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSW7Arc Chute Assy.Visual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSW	Description of TestSampling with basisdocument for Testingof Record123454Fix Contact Assy. Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSWN5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSWN5Cross Bar assembly Dimensional & VisualVisual/VCSub assy inspected 3Times per dayAs per Process & Quality check sheetProcess & Quality check sheetBSPTCL RecordAJSWN6Mechanism Assy. 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			BIHAR STATE	E POWER TRA	NSMISSION C	OMPA	NY	LIM	ITE	D			
			N	IANUFACTURING	QUALITY PLAN	МССВ							
		Customer		Item:	MQP No: 012					Valid			15.01.2016
			Code							From			13.01.2010
					Rev. No. 00					Valid			Till Revision
		BSPTCL		MCCB						Upto:		<u> </u>	
					Date : 02.01.2016					Page	: 10	of 12	
Sr.	Components / Operations &	Type of Check	Quantum of Check /	Reference	Acceptance Norms	Format		Ар	olicab	le Co	des		Remarks
No.	Description of Test		Sampling with basis	document for Testing		of Record	1	2	3	4	5	6	
5.8	Base Assy.	Visual	Sub assy inspected 3Times per day	As per Process & Quality check sheet	Process & Quality check sheet	BSPTCL Record	А	J	s	w	N	N	
	Visual					Record							
5.9	Cover Printing & Assy	Visual	Line inspection	As per Process &	Process & Quality	BSPTCL	А	J	S	w	N	N	
	Visual			Quality check sheet	check sheet	Record		0	0	**			
5.10	Visual Check	Visual	100% visual inspection	As per Process & Quality check sheet	Process & Quality check sheet	BSPTCL Record	A	J	s	w	N	N	
	Visual												

Sr.	Components / Operations &	Type of	Quantum of Check /	Reference	Acceptance Norms	Format of		App	olicab	le Co	des		Remarks
No.	Description of Test	Check	Sampling with basis	document for Testing		Record	1	2	3	4	5	6	
	FINAL INSPECTION & TESTING	:											
6.0	ROUTINE TESTING												
6.1	Magnetic Hold/ Trip	Elect	100% inspection	As per BSPTCL spec.	As per BSPTCL spec.	BSPTCL Record	А	J	U	Y		Y	Dispatch Clearance / Instructions will be issued based on sample
													test by BSPTCL Sample=01 unit per type, all routine tests.
6.2	Thermal Test	Elect	100% inspection	As per BSPTCL spec.	As per BSPTCL spec.	BSPTCL Record	A	J	U	Y		Y	-
6.3	OPERATIONAL TEST												
	10 Times ON & OFF	Manual	100% inspection	As per (IS/IEC-	As per Routine test	BSPTCL	А	J	U	Y		Y	Conduct before contact resistar
	Push to Trip at Max ON Push to Trip at Max OFF	Manual Manual	100% inspection 100% inspection	60947) Routine test instruction sheet	instruction sheet	Record							
	Push to Trip at Mini ON Push to Trip at Mini OFF	Manual Manual	100% inspection 100% inspection										
6.4	HV Test	Elect	100% inspection	As per (IS/IEC- 60947) Routine test	2.5kv for 1 sec	routine test report	A	J	U	Y		Y	Conduct before contact resistar
				instruction sheet									
	All packing cases should be mark	ed with BSPTC	LINA details name of r	roject item description	n and Dispatch Cleara	nce / Instruct	one	umbe	rbyy	which	mater	ial has	s been cleared

C	3		Η	BIHAR STATE	POWER TRAN	SMISSION CO	MPANY	LI	MIT	ED				
VA	J			M	ANUFACTURING Q	UALITY PLAN I	ИССВ							
				Vendor's	Item:	MQP No: 012					Valid			15.01.2016
				Code		Rev. No. 00					From Valid			Till Revision
			BSPTCL		МССВ						Upto			
						Date : 02.01.2016					Page	: 12	of 12	
Sr.	No.	Components / Operations &	Type of Check		Reference document	Acceptance Norms	Format of				ole Co		r	Remarks
		Description of Test		Sampling with basis	for Testing		Record	1	2	3	4	5	6	
	6.5	Contact Resistance	Elect	100% inspection	As per Routine test instruction sheet	Reference sheet	computeris ed test bench/Reg ister report	A	J	U	Y		Y	Dispatch Clearance / Instructions will be issued based on sample test by BSPTCL Sample=01 unit per type, all routine tests.
7.0		PACKING & DISPATCH (Check for identification & packing)												
	7.1	PRIMERY PACKING:	Visual	100.00%	As per BSPTCL instructions	As per BSPTCL	Register	A	J	U	Y		Y	
8.0		<b>TYPE TESTS</b> All type tests to be carried out as Engineering Deptt. Approval.	per IS/IEC 60947	'-2 specifications for BS	SPTCL		Type Test Certificate							