



QUALITY ASSURANCE PLAN

DOC NO. : F-QC-18-01

IN COMING / IN - PROCESS & FINISH GOODS INSPECTION AND TEST PLAN

REVISION NO. : Rev-00

ISSUE DATE : 1-4-2018

	DESCRIPTION	CHARACTERISTICS	TYPE OF CHECK	EXTENT OF CHECK	SPEC CODES & STANDARDS FOR ACCEPTANCE CRITERIA	FORMAT OF RECORDS	TEST INSTRUMENT	INSPECTION BY	REMARKS
1 FABRICATION									
1.1	Fabrication of primary structure	a) Dimension b) Thickness c) Part Identification	a) Length b) Width c) Height d) Other dimensions	a) 100%	As per drawing As per BOM As per client's requirement	A) Fabrication Report B) Work Inspection Report	a) Measurement Tape b) Vernier calliper c) Wire gauge		
1.2	Final Inspection before painting	a) Dimension b) Thickness c) Part Identification	a) Length b) Width c) Height d) Other dimensions	a) 100%	As per drawing As per BOM As per client's requirement	a) Powder Coating Report B) Work Inspection Report	a) Measurement Tape b) Vernier calliper c) Wire gauge		
2 IN PROCESS AND RAW MATERIALS									
2.1	Assembly	a) Visually	a) As per switchgear rating	a) 100%	As per drawing	N/A	N/A		
2.2	Alignment	a) Visually	a) Door b) Handle c) Interlocking	a) 100%	As per drawing	N/A	N/A		
3 SWITCHGEAR,BUSBARS & OTHER ELECTRICAL PARTS									
3.1	Switchgears	a) Visual b) Make	a) Quantity b) As specified in BOM	a) 100%	As per BOM As per client's requirement	a) Purchase Order b) BOM	N/A N/A		
3.2	Electrical parts & Accessories	a) Visual b) Make	a) Quantity b) As specified in BOM	c) 100%	As per BOM As per client's requirement	a) Purchase Order b) BOM	N/A N/A		
3.3	BUSBARS(Aluminium & Copper)	a) Dimension b) Thickness	a) Length b) Width C) Thickness	a) 100%	As per drawing As per switchgear rating	a) Inspecon reports for busbars	a) Vernier calliper b) Measure Tape		
4 SURFACE CLEANING & PAINTING									
4.1	Surface cleaning & Painting Process	a) Surface preparation b) Powder coating	a) Measurement & Visual b) Measurement- DFT	a) 100%	Between 80-120 micron	a) Inspecon reports for powder coating	a) DFT meter		
5 EDGE OF INSPECTION									
5.1	Power charging & Testing	a) Functioning b) Voltage c) Insulation Resistance check d) HV Test e) Operational	a) Visually b) As per drawing c) As per calibration	a) 100%	As per client's requirement As per drawing As per switchgear rating	a) Final Test Report	a) HV Test panel b) Meggar c) Series Lamp d) Multimeter		