

Quality Assurance Plan

Sr.	Item	Inspection Points	Method	Document	Sample Size
1	Sheet Metal	Hardness, Straightness, Bending	Visual, Micrometer / Std. Wire Gauge	Manufacturer's TC	1 sheet From One Box
2	Powder Coating	Thickness, Peel Off, Bonding, Impact	Visual, Thkness Gauge, Scratch, MEK, Impact tester	Self TC/Powder Coater TC	Sample Patti Of 6x2"
3	Switches	Operation, Hardware & Contact Fixing, Continuity	Visual, Manual Operation, Continuity Tester	Self TC	100% Of Receipt
4	Contactors	Operation, Hardware & Contact Fixing, Continuity, Coil Voltage, Rating, Brekages	Visual, Manual Operation, Continuity Tester, Test Jig	Self TC	10% of Receipt
5	Overl Load Relay	Operation, Hardware & Contact Fixing, Continuity, Rating, Brekages,	Visual, Manual Operation, Continuity Tester, Test Jig	Self TC	10% of Receipt
6	MCB / MCCB	Type, Operation, Hardware & Contact Fixing, Rating, Brekages, Settings, Accessories	Visual, Manual Operation, Continuity Tester,	Self TC	100% Of Receipt
7	ACB	Type, Hardware & Contact Fixing, Continuity, Rating, Brekages, Settings, Tripping, Accessories, DO Operation	Visual, Manual Operation, Continuity Tester,	Manufacturer's TC	100% Of Receipt
8	Busbar Insulators	Dimension, Shape, Type, SMC / DMC,	Visual, Insulation Resistance Test	Self TC/Manufacturer's TC	10% Of Receipt
9	Indicating Lamps	Voltage, Terminals, Caps, LED Glow, Color	Visual, Manual Operation & Test Jig	Self TC/Manufacturer's TC	100% Of Receipt
10	HT Hardware	Thread, Plating, Head	Impact on Floor, Thread Gauge, Visual	Self TC/Manufacturer's TC	10% Of Receipt
11	All Plated Components	Plating, Zinc / Cobalt	Visual & Coat Thkness Meter	Self TC/Manufacturer's TC	10% Of Receipt
12	Hinge & Hinge Bush	Dimensions, Hole, Plating	Vernier, Go-No-Go Gauge, Coat Thkness Meter	Self TC/Manufacturer's TC	10% Of Receipt
13	Push Button	Color, Type, Mechanical Operation, Contacts	Visual, Manual Operation	Self TC	100% Of Receipt
14	Wires	Size, Voltage, Type, Strand, Copper Quality, Continuity, Insulation, Color	Visual, Manual Operation, Continuity Tester, Micro Meter, HV Tester	Manufacturer's TC	1 out of 100 Coils
15	Lugs	Type, Size, Tinning, Hole Size, Material	Visual, Round File	Manufacturer's TC	1 out of 1000 Nos.
16	Bus Bar	Dimensional, Radius, Material, Conductivity	Mesuring Tape, Vernier, Visual, Conductivity meter	Manufacturer's TC & Self TC	1 Sample Piece From Each Uniform Lot to be Tested for Conductivity
17	Gasket	Shape, Color & Material, Softness	Visual & Burn Test	Manufacturer's TC & Self TC	1 Sample Piece from Each Uniform Lot
18	Name Plates/Legend Plates	Dimensional, Letter Description, Size Of Letter, Thickness Of Plate	Vernier, Visual	Self TC	100%
19	Completed Panel Board	Dimensional, BOM, Functional, Insulation Resistance-IS 8623 Verification of Dimensions Verification Of BOM Verification of Circuit Diagram Verification of Functional Checks Verification of Busbar Creepage Distances Verification of High Voltage Test 2U+1000V 1 Min Verification of Interchangeability of Drawout Trolleys Verification of Relay Function on EF, OC, UV, OV, SPPR	Mesuring Tape, Visual, Power Supply & HV Tester, Megger	Self TC	100%