QUALITY ASSURANCE PLAN

THERMOCOUPLE CABLES [ANSI 96.1/9181, BS:5308/Part-I&II/88, IS:1554/Part-I/88]

S.N.	Component	Characteristic	Category Checked	Type	Extent Of Of Check	Acceptance Method
RAW MATERIAL						
01.	Thermocouple Conductor	Diameter	Major	Measurement Test	100%	BS:5308/I&II/86
		Thermal E. M. F.	Critical	Measurement Test	100%	ANSI 96.1 & IS
02.	PVC / HR / PE Compound	Thermal Stability	Critical	Chemical Test	10%	IS:5831/84
		T.S. & Elongation	Major	Physical Test	10%	BS:6746/90, BS:6234
03.	Test On G.I.Wire	Dia Meter	Major	Measurement Test	100%	IS:3975/79
		T. S. & Elongation	Major	Physical Test	10%	IS:3975/79
		Torsion Test	Major	Measurement Test	10%	IS:3975/79
		Mass & Uniformity Of Zinc	Major	Measurement Test	10%	IS:3975/79
IN PROCESS						
01.	Conductor Stranding	No. Of Strand/Dia of Wire	Major	Counting/Measurement	100%	GTP
		Thermal E. M. F.	Critical	Measurement Test	100% & Finish Of Each Drum	ANSI 96.1 & IS BS:5308/I&II/86
02.	Insulation PVC [Type – A / C / T11]	Spark Test Eccentricity	Critical	Visual	100%	BS:5308/I&II/86
		Core Diameter	Major	Measurement	Setting Start & Finish Of Each Drum	BS:5308/I&II/86
		Thickness	Major	Measurement	- do -	GTP, BS5308/I&II/86
03.	Core Laying	Color Sequence	Major	Visual	Setting Start & Finish Of Each Drum	Uniform/GTP
		Lay Direction/Lay Length	Major	Visual	Setting Start & Finish Of Each Drum	BS:5308/I&II/86
04.	Inner Sheath PVC [Type -ST1 / ST2 / TM1]	Thickness	Major	Measurement	Setting Start & Finish Of Each Drum	GTP, IS:1554/I/88
05.	Armouring	Armour Dimension	Major	Measurement	100%	GTP, IS:1554/I/88 & BS:5308/I&II/86
		Lay Direction/Lay Length	Major	Visual	Setting Start	BS:5308/I&II/86
		High Voltage	Critical	Measurement	100%	BS:5308/I&II/86
06.	Outer Sheath PVC [Type - ST1 / ST2 / TM1]	Thickness	Major	Measurement	Setting Start & Finish Of Each Drum	GTP, IS:1554/I/88
		Marking &/Embossing	Major	Visual	Continuous	GTP
		Color	Major	Visual	Continuous	GTP
FINAL TESTING BY QUALITY CONTROL & INSPECTION						
01.	Testing On Cable	Routine Test	Critical	Electrical Test	100%	BS:5308/I&II/86
		Type Test	Critical	Test	10%	BS:5308/I&II/86
		Acceptance Test For Inspection				
		Thermal E. M. F.	Critical	Electrical Test	As Per IS & BS	ANSI 96.1 & IS
		High Voltage Test	Critical	Electrical Test	As per IS	BS:5308/I&II/86 & GTP
		Insulation Resistance Test	Critical	Electrical Test	As per IS	BS:5308/I&II/86 & GTP
		Capacitance Test	Critical	Electrical Test	As per IS	BS:5308/I&II/86 & GTP
		L/R Ratio Test	Critical	Electrical Test	As per IS	BS:5308/I&II/86 & GTP
		Al. Mylar Tape Thickness Test	Critical	Physical Test	As per IS	BS:5308/I&II/86 & GTP
		Drain Wire Test	Critical	Electrical Test	As per IS	BS:5308/I&II/86 & GTP
		Insulation/Inner Sheath/Outer Sheath Thickness Test	Major	Physical Test	As per IS	BS:5308/I&II/86 & GTP
		Armour Wire Diameter	Major	Physical Test	As per IS	BS:53058/I & II/86 & IS:1554/I/88 & GTP
		Insulation/Sheath Tensile Strength	Major	Physical Test	As per IS & BS	IS:5831/84
		Insulation/Sheath Elongation	Major	Physical Test	As per IS & BS	IS:5831/84
		Flammability Test	Major	FRLS Test	As per IEC	IEC 332/Part-1
		Oxygen Index	Major	FRLS Test	As per ADTMD	ASTMD-2863
		Temperature Index	Major	FRLS Test	As per ADTMD	ASTMD-2863
		Smoke Density Rating	Major	FRLS Test	As per ADTMD	ASTMD-2843
02.	Packing	Drum	Major	Test	100%	Wood Should be free from Knot
		End Sealing Of Cable	Major	Visual	100%	