



## BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

### Manufacturing Quality Plan – Current Transformers (Upto 132 kV)

	Customer BSPTCL	Vendor's Code	Item: Current Transformers Up to 132kV	MQP No.- 016 Rev. No.-0 Date -02.01.2016	Valid From: 15.01.2016 Valid Upto: Till Revision Page: 1 of
Code 1	Indicates place where testing is planned to be performed i.e. inspection location		Code 2	Indicates who has to perform the tests i.e. Testing Agency	
A	At Equipment Manufacturer's works		J	The Equipment Manufacturer	
B	At Component Manufacturer's works		K	The Component Manufacturer	
C	At Authorised Distributor's place		L	The Third Party	
D	At Independent Lab		M	The Turnkey Contractor	
E	At TurnKey Contractor's location				
F	Not specified				
Code 3	Indicates who shall witness the tests i.e. Witnessing Agency		Code 4	Review of Test Reports/Certificates	
P	Component Manufacturer itself		W	By Equipment manufacturer during raw material/bought out component inspection	
Q	Component Manufacturer and Equipment Manufacturer		X	By Contractor during product/process inspection	
R	Component Manufacturer, Equipment Manufacturer and Contractor		Y	By BSPTCL during product/process inspection	
S	Equipment Manufacturer itself		Z	By Contractor and/or BSPTCL during product/process inspection	
T	Equipment Manufacturer and Contractor				
U	Equipment Manufacturer, Contractor and BSPTCL				
V	Third Party itself				
Code 5	Whether specific approval of sub-vendor / component make is envisaged?		Code 6	Whether test records required to be submitted after final inspection for issuance of CIP/MICC	
E	Envisaged		Y	Yes	
N	Not Envisaged		N	No	

Notes:

1. The MQP should be read in conjunction with BSPTCL specification and shall deem to include additional tests if any required as per the contract.
2. BSPTCL specification shall include provisions of letter of Award. BSPTCL approved drawings / technical data sheet / BOM / test schedule / test procedure applicable in the specific contract.
3. In case of any contradiction between the manufacturer's plant standards, this MQP and BSPTCL specification following precedence shall be followed:
  - a) BSPTCL specification
  - b) This Manufacturing Quality Plan
  - c) Manufacturer's Plan Standards
4. It is the responsibility of the manufacturer to ensure that this document is readily available at their works as well as at the works of their sub vendors in order to avoid any delay at the time of inspection.



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5. The manufacturer shall ensure that their as well as their sub vendors control, metering & testing instruments are duly calibrated and should have calibration certificates traceable to Indian / international standards, Calibration records should be available during inspection by BSPTCL. Key testing instruments will be calibrated only by NABL accredited laboratories.
6. In case of any tests being carried out at third party lab such lab / facility should be NABL accredited / accepted by BSPTCL.
7. Witnessing of Acceptance Tests by BSPTCL shall be on 100% of the number of samples for acceptance test for the first three orders after release of this MQP. After completion of first three orders sampling requirement will be reviewed by BSPTCL based on performance of product.
8. The manufacturer shall maintain the proper co-relation of test certificates from raw material stage to finished product stage and the records should be available during inspection by BSPTCL.
9. Manufacturer shall show the approval of BSPTCL engineering for all contract specific type tests including specific type tests if any as per the BSPTCL specifications at the time of final inspection.
10. All packing cases should be marked with BSPTCL LOA details, name of project, item description and CIP/MICC number (by which material has been cleared for dispatch).
11. One copy of test report, dispatch instructions/clearance shall be sent along with consignment.
12. Inspection of spare items ordered by BSPTCL shall also be governed by the provisions of this MQP. Item if not governed under MQP shall be offered for inspection as per BSPTCL specifications / Relevant-Indian / International Specification.
13. The manufacturer shall align their quality system and that of their sub-vendors to the requirements of latest ISO 9000 quality standards in a time bound manner.
14. The relevant details of plant standards and quality plan for different ratings are shown in attached Annexure.
15. BSPTCL may review the effective implementation of the processes during the product-inspection / process-inspection. In case any violations in process or process parameters are observed, the reason along with corrective & preventive measures shall be conveyed to BSPTCL within 2 weeks.
16. Repair procedure to be got approved form BSPTCL before taking up any repairing job on equipment supplied to BSPTCL.

EM : Equipment Manufacturer

CM : Component Manufacturer



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S.N	Components/ Operations & Description of Test	Type of Check	Quantum of Check / Sampling with basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks	
							1	2	3	4	5	6		
A	RAW MATERIAL INSPECTION													
1	<u>INSULATING OIL</u>											E		
1.1	Appearance	Physical	1 sample per lot	IS- 335	Oil shall be clear & transparent & free from suspended matter/sediments	CMTC	B	K	P	W			N	Review of CM/EM TC during final inspection by BSPTCL
1.2	Electric Strength (BDV) a. New unfiltered Oil b. After Filtration	Electrical	1 sample per lot IS-6792	IS-335	a. 30KV (min.) b. 60KV (min.)	a. CMTC b. EM Report	B	K/J	P/S	W			N	do
1.3	Dielectric Dissipation Factor (tan delta) at 90 degree C	Electrical	IS - 6262	IS-335	0.002 (max.)	CMTC	B	K	P	W			N	do



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							1	2	3	4	5	6	
1.4	Density at 295 deg C (g/cc)	Mechanical	IS-1448	IS-335	0.890 (max)	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
1.5	Kinematic Viscosity at 27 deg C (CST)	Mechanical	IS-1448	IS-335	27 (max)	CMTC	B	K	P	W		N	do
1.6	Flashpoint P.M.C.C (deg C)	Thermal	IS-1448	IS-335	140 (min)	CMTC	B	K	P	W		N	do



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							1	2	3	4	5	6	
1.7	Water Content (ppm)	Chemical	IS-13567	IS-335	50 (max)	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
1.8	Neutralisation Value (KOH/g)	Chemical	IS-1448	IS-335	0.03 (max)	CMTC	B	K	P	W		N	do
1.9	Interfacial Tension (N/m)	Physical	IS-6104	IS-335	0.04 (min)	CMTC	B	K	P	W		N	Do

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							1	2	3	4	5	6	
1.10	Specific resistance (ohm-cm) a. at 90 deg C b. at 27 deg C	Electrical	IS-6103	IS-335	a. $35 \times 10^{12}$ b. $1500 \times 10^{12}$	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
1.11	Pour Point	Physical	IS-1448	IS-335	-6 (max)	CMTC	B	K	P	W		N	do
1.12	Presence of oxidation inhibitors	Chemical	IS-13631	IS-335	Oil shall not contain antioxidant additive	CMTC	B	K	P	W		N	do
1.13	Ageing test a. Specific resistance i) at 90 deg C ii) at 27 deg C b. Dielectric dissipation factor c. Total Acidity (mg KOH/g) d. Total Sludge value (% by Wt)	Electrical	a. IS - 6103 b. IS - 6262 c. IS - 1448 d. IS - 12177	IS-335	a. (i) $2.5 \times 10^{12}$ (min.) (ii) $0.20 \times 10^{12}$ (min.) b. 0.20 (max.) c. 0.05 (max.) d. 0.05 (max.)	CMTC	B	K	P	W		N	Do



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							1	2	3	4	5	6	
2	<b><u>PORCELAIN BUSHING</u></b>										E		
2.1	Visual Inspection	Visual	100%	EM Std.	Smooth finish without blowholes	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
2.2	Dimension	Measurement	One sample per lot	Manufacturer's Drawing of Bushing	Within tolerance as specified in the drawing	CMTC	B	K	P	W		N	do
2.3	Creepage	Measurement	One sample per lot	As per BSPTCL approved GTP/approved drawing	As per BSPTCL approved GTP/approved drawing	CMTC	B	K	P	W		N	do
2.4	Electrical Routine Tests	Electrical	100%	IS-5621	IS-5621	CMTC	B	K	P	W		N	do
2.5	Porosity Test	Physical	One sample per lot	IS-5621	IS-5621	CMTC	B	K	P	W		N	do
2.6	Temperature Cycle Test	Thermal	One sample per lot	IS-5621	IS-5621	CMTC	B	K	P	W		N	do



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							1	2	3	4	5	6	
<b>3</b>	<b><u>O-RINGS &amp; GASKETS</u></b>										E		
3.1	Visual Inspection	Visual	10%	As per EM Work-order	Free from blisters holes bubbles cracks etc.	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
3.2	Specific Gravity	Measurement	10%	As per EM Work-order	1.2 ~ 1.4 gms/cm <sup>3</sup>	CMTC	B	K	P	W		N	do
3.3	Hardness Shore 'A'	Mechanical	One sample per batch	As per EM Work-order	70 ± 5 Shore 'A'	CMTC	B	K	P	W		N	do
3.4	Ageing Test in Transformer Oil at 110 deg C for 7 days a. Change in Weight b. Change in Hardness	Mechanical	One sample per batch	As per EM Work-order	a. ± 10 % b. ± 10 Shore A	CMTC	B	K	P	W		N	do
3.5	Tensile Strength (N/mm <sup>2</sup> )	Mechanical	One sample per batch	As per EM Work-order	11.0 N/mm <sup>2</sup> (min.)	CMTC	B	K	P	W		N	do
3.6	Compression set at 110 deg C for 70 hrs (%)	Mechanical	One sample per batch	As per EM Work-order	30 (max.)	CMTC	B	K	P	W		N	do
3.7	Elongation	Mechanical	One sample per batch	As per EM Work-order	270 % (min.)	CMTC	B	K	P	W		N	do



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							1	2	3	4	5	6			
<b>4</b>	<b><u>KRAFT PAPER</u></b>														
4.1	Thickness	Measurement	One sample per lot	IS-9335	+/- 10%	CMTC	B	K	P	W		N		Review of CM/EM TC during final inspection by BSPTCL	
4.2	Width	Measurement	One sample per lot	Verify Width	+/- 2mm.	CMTC	B	K	P	W		N		do	
4.3	Ash Content (%)	Physical	One sample per lot	IS-9335	1.0 (max.)	CMTC	B	K	P	W		N		do	
4.4	pH value of aqueous extract	Physical	One sample per lot	IS-9335	(6-8)	CMTC	B	K	P	W		N		do	
4.5	Conductivity of aqueous extract (ms/m)	Electrical	One sample per lot	IS-9335	10 (max.)	CMTC	B	K	P	W		N		do	
4.6	Dielectric strength of dry paper (kV/mm)	Electrical	One sample per lot	IS-9335	7.0 (min.)	CMTC	B	K	P	W		N		do	
4.7	Tensile strength (Nm/g) MD CD	Mechanical	One sample per lot	IS-9335	78 (min.) 28 (min.)	CMTC	B	K	P	W		N		do	
4.8	Apparent Density	Physical	One sample per lot	IS-9335	0.8 +/- 0.05	CMTC	B	K	P	W		N		do	



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							1	2	3	4	5	6	
5	<b><u>SUPER ENAMELLED COPPER WIRE</u></b>										E		
5.1	Diameter	Measurement	One sample per lot	IS-13730	IS-13730	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
5.2	BDV	Electrical	One sample per lot	IS-13730	IS-13730	CMTC	B	K	P	W		N	do
5.3	Resistance	Electrical	One sample per lot	IS-13730	IS-13730	CMTC	B	K	P	W		N	do
5.4	Elongation	Mechanical	One sample per lot	IS - 13730	IS - 13730	CMTC	B	K	P	W		N	do
5.5	Abrasion	Mechanical	One sample per lot	IS - 13730	IS - 13730	CMTC	B	K	P	W		N	do
5.6	Heat Shock	Thermal	One sample per lot	IS - 13730	IS - 13730	CMTC	B	K	P	W		N	do
5.7	Cut through	Mechanical	One sample per lot	IS - 13730	IS - 13730	CMTC	B	K	P	W		N	do



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							1	2	3	4	5	6	
<b>6</b>	<b><u>CORES</u></b>										E		
6.1	Dimension	Physical	10%	EM Work-order	+ / - 2 mm.	CMTC	B	K	P	W		N	Review of CM/EM TC during final inspection by BSPTCL
6.2	Surface finish	Physical	10%	EM Std.	Smooth with Min. air gaps, No bends on edges	EM Report	A	J	S	W		N	do
6.3	Material grade	Electrical	10%	EM Work-order	EM Work Order	CMTC	B	K	P	W		N	do
6.4	Measurement of Excitation current	Electrical	10%	EM Work-order	EM Work Order	EM Report	A	J	S	W		N	do
<b>7</b>	<b><u>MS FABRICATED TANKS</u></b>										E		
7.1	Dimension	Physical	10%	Fabrication & Approved Drawing	Fabrication & Approved Drawing	EM Report	A	J	S	W		N	do
7.2	Pressure Leak Test	Mechanical	10%	EM Std. 1.2kg /sq.cm. for 2 min.	EM Std. 1.2kg/sq.cm. for 2 min.	EM Report	A	J	S	W		N	do
7.3	Finish	Visual	10%	Grinding should be proper	Smooth Finish, No sharp edges.	EM Report	A	J	S	W		N	do
7.4	Painting a. Visual Inspection b. Thickness	a. Visual b. Measurement	a. 100% b. One sample per lot	a. Free from defects. Smooth uniform coating b. Min. 60 Micron Thick	a. Free from defects. Smooth uniform coating b. Min. 60 Micron Thick	EM Report	A	J	S	W		N	do



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<b>8</b>	<b><u>HOT DIP GALVANIZING</u></b>										E		
<b>8.1</b>	Strip Test / mass of Zinc coating a. 1.2-2mm Thick b. 2 - 5mm Thick c. Above 5mm Thick	Measurement	One sample per lot	IS 2633/ IS 2629	a. 340 gm/mm <sup>2</sup> b. 460 gm/mm <sup>2</sup> c. 610 gm/mm <sup>2</sup>	CMTC	B	K	P	W		N	do
8.2	Zinc coating (in microns)	Measurement	One sample per lot	IS-4759	IS-4759	CMTC	B	K	P	W		N	do
8.3	Adhesion Test (Pivot Hammer Test)	Physical	One sample per lot	IS-2633/IS-2629	No peeling of Coating	CMTC	B	K	P	W		N	do
8.4	Preece Test (Uniformity of Zinc Coating)	Physical	One sample per lot	IS-2633/IS-2629	Reddish Deposit of Copper after 6 Dips in CuSO <sub>4</sub> (Duration of Each Dip 1 Min.)	CMTC	B	K	P	W		N	do
<b>9</b>	<b><u>COPPER CONDUCTOR</u></b>										N		
9.1	Visual	Visual	One sample per lot	Uniform & Free form defects	Uniform & Free form defects	CMTC	B	K	P	W		N	do
9.2	Cross Section	Measurement	One sample per lot	As per EM Work-order	As per EM Work-order	CMTC	B	K	P	W		N	do
9.3	Purity of Copper	Chemical	One sample per lot	99.90%	99.90%	CMTC	B	K	P	W		N	do



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<b>10</b>	<b><u>CREPE PAPER</u></b>										<b>E</b>		
10.1	Tensile Strength	Mechanical	One Reel per lot	IS-9335	IS-9335	CMTC	B	K	P	W		N	do
10.2	Elongation	Mechanical	One Reel per lot	IS-9335	IS-9335	CMTC	B	K	P	W		N	do
10.3	Moisture Content	Physical	One Reel per lot	IS-9335	IS-9335	CMTC	B	K	P	W		N	do
10.4	Ash Content	Physical	One Reel per lot	IS-9335	IS-9335	CMTC	B	K	P	W		N	do
10.5	Conductivity of Aqueous Extract	Electrical	One Reel per lot	IS-9335	IS-9335	CMTC	B	K	P	W		N	do
<b>11</b>	<b><u>PRIMART METAL PARTS</u></b>										N		
11.1	Primary Metal Parts	Physical	20%	EM Component Drawing	EM Component Drawing	EM Report	A	J	S	W		N	Do
<b>12</b>	<b><u>TERMINAL CONNECTOR</u></b>										<b>E</b>		CIP at manufacturer works.
<b>13</b>	<b><u>Bellows</u></b>										<b>E</b>		
13.1	Major Dimensions	Physical	1 No / Lot	EM Plant Drg	EM Plant Drg	Component Mfr's TC /	A	J	S	W		N	Major Dimensions
13.2	Visual	Visual	100%	EM Plant Drg	EM Plant Drg	Component Mfr's TC /	A	J	S	W		N	Visual



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<b>B</b>	<b><u>SECTION : IN PROCESS INSPECTION</u></b>												
<b>1</b>	<b><u>SECONDARY WINDING : METERING</u></b>												
	1. No. of Turns	Measurement	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Review of CM/EM TC during final inspection by BSPTCL
	2. Over voltage intertern test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
	3. Accuracy test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
<b>2</b>	<b><u>SECONDARY WINDING : PROTECTION</u></b>												
	1. No. of Turns	Measurement	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Do
	2. Over voltage intertern test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
	3. Accuracy test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
	4. Composite Error Test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do



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<b>3</b>	<b><u>SECONDARY WINDING : PS</u></b>												
	1. No. of Turns	Measurement	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Review of CM/EM TC during final inspection by BSPTCL
	2. Over voltage intertern test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
	3. Resistance Measurement	Electrical	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Do
	4. Knee Point Voltage & Excitation Current Measurement	Electrical	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Do
	5. Turns ratio Error	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
<b>4</b>	<b><u>STACKING OF COILS</u></b>												
	1. Polarity Test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
<b>5</b>	<b><u>PRIMARY WINDING &amp; INSULATION</u></b>												
	1. Cross Section Area	Measurement	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Do
	2. No. of Turns	Physical	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Do



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							1	2	3	4	5	6	
<b>6</b>	<b><u>CT ASSEMBLY</u></b>												
	1. Polarity Test	Electrical	100%	EM Work Order	EM Work Order	EM Report	A	J	S	W		N	Review of CM/EM TC during final inspection by BSPTCL
	2. High voltage test on secondary winding	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Report	A	J	S	W		N	Do
	3. Pressure test on entire assembly for 5 min	Mechanical	100%	EM Work Order	1.0 kg/sqcm for 5mins	EM Report	A	J	S	W		N	Do
<b>7</b>	<b><u>DRYING &amp; OIL FILLING UNDER VACUUM</u></b>												
	1. Measurement of temp of vacuum chamber	Measurement	Every Cycle	EM vacuum process instruction	105 deg C & 65 deg C	EM Report	A	J	S	W		N	Do
	2. Megger values (between primary & sec)	Electrical	100%	After every Heating cycle	1000 Mohms	EM Report	A	J	S	W		N	Do
	3. Measurement of vacuum	Measurement	Every Cycle	EM vacuum process instruction	0.05 Torr for 132kv CT & 0.1 Torr for 33KV CT	EM Report	A	J	S	W		N	Do
	4. Measurement of BDV of filtered oil	Electrical	One sample per lot	EM Std.	60 KV min.	EM Report	A	J	S	W		N	Do



## BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

### Manufacturing Quality Plan – Current Transformers (Upto 132 kV)

				Vendor's Code	Item: Current Transformers Up to 132kV	MQP No.- 016 Rev. No.-0 Date -02.01.2016	Valid From: 15.01.2016 Valid Upto: Till Revision						
S.N	Components/ Operations & Description of Test	Type of Check	Quantum of Check / Sampling with basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
<b>C</b>	<b><u>SECTION : FINAL INSPECTION &amp; TESTING</u></b>												
<b>1</b>	<b><u>ROUTINE TESTS</u></b>												
	1. Verification of Terminal Marking & Polarity	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	2. Power Frequency Dry withstand voltages on primary	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	3. Power Frequency Dry withstand voltage on secondary	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	4. Over voltage inter turn test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	5. Partial Discharge test (for 66KV and above CT only)	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	6. Measurement of Capacitance and Tan Delta for 66KV and above CT only at 10kV, 0.3, 0.7, 1.0 & 1.1 Um / rt3 voltage before and after HV test	Electrical	100%	IS-2705/1992	< 0.004	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	7. Metering Core a. Accuracy Tests-Ratio & Phase angle error	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	8. Protection Core a. Accuracy Tests-Ratio & Phase angle error b. Comp. site error c. KPV (as applicable)	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%



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S.N	Components/ Operations & Description of Test	Type of Check	Quantum of Check / Sampling with basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
	9. Class – PS a. Measurement of Secondary Winding Resistance b. Measurement of Knee Point Voltage & Exciting Current c. Turns Ratio Error Test	Electrical	100%	IS-2705/1992	IS-2705/1992	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	10. IR Measurement between Primary & Secondary (Earth)	Electrical	100%	BSPTCL Specs	BSPTCL Specs	EM Test Report	A	J	U	W/Z		Y	CIP on 100%
	11. Painting/HDG Check	Measurement	100%	85 Microns (min.) / BSPTCL specs	85 Microns (min.) / BSPTCL specs	EM Test Report	A	J	U	W/Z		Y	CIP on one No. per lot
12	Test on transformer oil from CT after HV Test												
i	BDV	Electrical	1 sample/ lot	IEC 60422	>60KV	Test Report	A	J	U	W/Z		Y	CIP on one No. per lot
ii	Tan Delta	Electrical	1 sample/ lot	IEC 60422	at 90degC 0.01 (max)	Test Report	A	J	U	W/Z		Y	CIP on one No. per lot
iii	Moisture Content	Electrical	1 sample/ lot	IEC 60422	< 10mg/kg	Test Report	A	J	U	W/Z		Y	CIP on one No. per lot
iv	Specific Resistivity @ 90 deg C	Electrical	1 sample/ lot	IEC 60422	at 90 deg C Min 60 Gigaohm meter	Test Report	A	J	U	W/Z		Y	CIP on one No. per lot



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D	<b><u>SECTION: PACKING &amp; DESPATCH- CT</u></b>											
1	N2 Gas Filling	Mechanical	100%	N2 is filled at 0.75kg	Pressure is observed after 1 hour. To check leakage		A	J	S	W		N
2	Checking for completeness of the equipment and accessories including	Visual	100%	As per EM Process Specification	As per EM Process Specification		A	J	S	W		N
3	Check for proper packing	Visual	100%	As per EM Process Specification	As per EM Process Specification		A	J	S	W		N
4	Insure supply of operation manual packing list and test reports along with copy of inspection reports CIP and MICC	Visual	100%	As per EM Process Specification	As per EM Process Specification		A	J	S	W		N