

 <b>BIHAR STATE POWER TRANSMISSION COMPANY LIMITED</b>						
<b>MANUFACTURING QUALITY PLAN -- ISOLATOR &amp; EARTHING SWITCHES UPTO 400kV</b>						
Manufacturer's Logo	Customer	Item	Vendor's Code	Manufacturer, Name & Add.	MQP No: 021 Rev. No. 00	Valid from: 15.01.2016
	<b>BSPTCL</b>	ISOLATOR & EARTHING SWITCHES UPTO 400kV			Date: 04.01.2016	Valid upto: Till Revision
<b>Code 1</b> Indicates place <b>where testing is planned</b> to be performed i.e. Inspection location A At Equipment Manufacturer's works B At Component Manufacturer's works C At Authorised Distributor's place D At Independent Lab E At Turn Key Contractor's location F Not specified			<b>Code 2</b> Indicates <b>who has to perform the tests</b> i.e. Testing Agency J The Equipment Manufacturer K The Component Manufacturer L The Third Party M The Turnkey Contractor			
<b>Code 3</b> Indicates <b>who shall witness</b> the tests i.e. Witnessing Agency P Component Manufacturer itself Q Component Manufacturer and Equipment Manufacturer R Component Manufacturer, Equipment Manufacturer and Contractor S Equipment Manufacturer itself T Equipment Manufacturer and Contractor U Equipment Manufacturer, Contractor and BSPTCL V Third Party itself			<b>Code 4</b> Review of Test Reports/Certificates W By Equipment manufacturer X By Contractor during product/process inspection Y By BSPTCL during product/process inspection Z By Contractor and/or BSPTCL during product/process inspection			
<b>Code 5</b> Whether specific approval of sub-vendor / Component make is envisaged? E Envisaged N Not Envisaged			<b>Code 6</b> Whether test records required to be submitted after final inspection for issuance of Dispatch Instructions/Clearance? Y Yes 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 to 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 plant 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.
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 10% of each type offered lot for acceptance test. The Contractor or Equipment Manufacturer will inform in advance the serial number of equipment/items being offered for inspection, so that BSPTCL can inform in advance to keep the selected samples ready for witnessing.

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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 specification,  
at the time of final inspection.

10. All packing cases should be marked with BSPTCL LOA details , name of project , item description and Dispatch Instructions/Clearance number  
(by which material has been cleared for dispatch ) .

11. One copy of test report , Dispatch Instructions/Clearance shall also be sent along with consignment .

12. Inspection of spare items ordered by BSPTCL shall also be governed by the provisions of this MQP . Items 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 list of component manufacturers for which approval are envisaged is enclosed herewith.

15. BSPTCL may review the effective implementation of the processes during the product-inspection / process-inspection.  
In case any violation in process or process parameters are observed, the reason along with corrective & preventive measures shall be conveyed to BSPTCL within 2 weeks.

16. In case of any discrepancy between TS/Approval drawing and MQP, details mentioned in TS/approved drawing shall prevail.

17. Any addition change in new vendor/design/process shall call for review by BSPTCL and change in MQP, if necessary.

EM : Equipment Manufacturer

CMTC : Component Manufacturer's Test Certificate



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Customer : BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturer :

MQP No: 021

Item: DISCONNECTORS / ISOLATORS

Sl. No	INDEX SHEET	Page No.
1	Cover Sheet with Notes and Codes	1 & 2
2	Process Flow Chart	1
3	Raw Material Inspection	1 to 4
4	In - Process Inspection	4 to 5
5	Final Acccceptance Inspection & Testing	5 to 6
6	Packing & Despatch	6
7	List of Component Manufacturer	1 to 5



**BIHAR STATE POWER TRANSMISSION COMPANY LIMITED**

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						Date: 04.01.2016							
S.No	Components / Operations & Description of Test	Type of Check	Quantam of Check / Sampling with basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	
<b>SECTION - 1: RAW MATERIAL INSPECTION</b>													
<b>A</b>	<b>ELECTRICAL ITEMS</b>												
1.1	CONTACTORS											E	
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS 13947 (Part 4 / Sec4)	IS 13947 (Part 4 / Sec4)	CMTc	A	J	S	W		N	
b	Operation test at rated voltage	Electrical					B	K	P	W		N	
c	Verification of limits of Voltage	Electrical					B	K	P	W		N	
d	H.V Test	Electrical					B	K	P	W		N	
1.2	OVER LOAD RELAYS											E	
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS 13947 (Part 4 / Sec1)	IS 13947 (Part 4 / Sec1)	CMTc	A	J	S	W		N	
b	H.V Test	Electrical					B	K	P	W		N	
1.3	PUSH BUTTONS											E	
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS 6875	IS 6875	CMTc	A	J	S	W		N	
b	H.V Test	Electrical					B	K	P	W		N	
1.4	TERMINAL BLOCKS											E	
a	Appearance	Visual	S&S Sampling Plan IS 3669	IS 3669	IS 3669	CMTc	A	J	S	W		N	
b	I R Value	Electrical					B	K	P	W		N	
c	Continuity Check	Electrical					A	J	S	W		N	
d	H.V.Test	Electrical					B	K	P	W		N	
e	Check for wire grip	Mechanical					A	J	S	W		N	
1.5	AUXILIARY SWITCHES											E	
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS 6875	IS 6875	CMTc	A	J	S	W		N	
b	I R Value	Electrical					B	K	P	W		N	
c	H V test	Electrical					B	K	P	W		N	
d	Verification of NO & NC Contacts	Electrical					A	J	S	W		N	
1.6	HEATERS											E	
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS6446	IS6446	CMTc	A	J	S	W		N	
b	I R Value	Electrical					B	K	P	W		N	
c	H V test	Electrical					B	K	P	W		N	
d	Functional check	Mechanical					A	J	S	W		N	



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							<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	
1.7	FUSE Fittings & Fuse links												
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1				A	J	S	W		N	
b	Verification of amper range of Fuse Link	Electrical					A	J	S	W		N	
c	Dimensional Check	Mechanical		IS 9224 (Pt 1 & 2 )	IS 9224 (Pt 1 & 2 )	CMTC	A	J	S	W		N	
d	I R Value	Electrical					B	K	P	W		N	
e	H V test	Electrical					B	K	P	W		N	
1.8	INTERLOCK COILS												
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1				A	J	S	W		N	
b	I R Value	Electrical					B	K	P	W		N	
c	H V test	Electrical		QP/D/E/019	QP/D/E/019	CMTC	B	K	P	W		N	
d	Operation Check	Mechanical					A	J	S	W		N	
e	Limits of Operation	Mechanical					A	J	S	W		N	
1.9	CIRCUIT BREAKER (MCBs)												
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1										E
b	Dimensional Check	Electrical		IEC 60898-1-2002/ IS 8828-1996	IEC 60898-1-2002/ IS 8828-1996	CMTC	A	J	S	W		N	
c	I R Value	Electrical					B	K	P	W		N	
d	H V test	Electrical					B	K	P	W		N	
1.10	MOTORS												
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1										E
b	Dimensional check	Electrical					A	J	S	W		N	
c	I R Value	Electrical					A	J	S	W		N	
d	H V test	Electrical		IS 325	IS 325	CMTC	B	K	P	W		N	
e	No load operation	Electrical					B	K	P	W		N	
f	Blocked Rotor Test	Electrical					A	J	S	W		N	
g	Verification of limits of operation	Electrical					A	J	S	W		N	
1.11	GASKET (EPDM) / Neopherne												
a	Shore Hardness	Mechanical											E
b	Aging test	Mechanical	S&S Sampling Plan IS 2500 Pt - 1	Manufacturer std/ ASTM D - 1171	Manufacturer std/ ASTM D - 1171	CMTC	B	K	P	W		N	
c	Dimensional check	Mechanical					B	K	P	W		N	
d	Appearance	Visual					A	J	S	W		N	
e	Chemical Composition	Chemical					B	K	P	W		N	
1.12	THERMOSTATS												
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1										E
b	Verification of limits of operation	Electrical		IS 3017	IS 3017	CMTC	A	J	S	W		N	



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1.13	CASTLE LOCKS													
	1) Appearance	Visual	100%	Manufacturer' s Catalogue	Manufacturer' s Catalogue	CMTC	A	J	S	W			E	N
	2) Dimension	Mechanical	S&S Sampling Plan				A	J	S	W				N
1.14	ROTARY SWITCHES AND TOGGLE SWITCHES												E	
a	Appearance	Visual	S&S Sampling Plan	S&S Sampling Plan	Manufacturer' s Catalogue	CMTC	A	J	S	W				N
b	Sequence test	Electrical	IS 2500 Pt - 1	IS 2500 Pt - 1			A	J	S	W				N
c	H V test	Electrical					B	K	P	W				N
d	Functional Check	Mechanical					A	J	S	W				N
1.15	LIMIT SWITCHES												E	
a	Appearance	Visual	S&S Sampling Plan	IS 6875	IS 6875	CMTC	A	J	S	W				N
b	H V test	Electrical	IS 2500 Pt - 1				B	K	P	W				N
c	Functional Check	Mechanical					A	J	S	W				N
<b>B</b>	<b>OTHER ITEMS</b>													
1.16	MS STRUCTURAL STEEL (Chennels, sheets, plates, rods & flats)	Mechanical											E	
a	Appearance	Visual	S&S Sampling Plan	IS 2062, IS 1079	IS 2062, IS 1079	CMTC	A	J	S	W				N
b	Dimensional Check	Mechanical	IS 2500 Pt - 1	IS 1570, 9550	IS 1570, 9550		A	J	S	W				N
c	Chemical Compostion	Mechanical		IS 1852	IS 1852		B	K	P	W				N
d	Physical Properties	Mechanical					B	K	P	W				N
1.17	TUBES ( STEEL & G.I)												E	
a	Appearance	Visual	S&S Sampling Plan	IS 1239 PT 1 & IS 4736	IS 1239 PT 1 & IS 4736	CMTC	A	J	S	W				N
b	Dimensional Check	Mechanical	IS 2500 Pt - 1				A	J	S	W				N
c	Chemical Compostion	Mechanical					B	K	P	W				N
d	Physical Properties	Mechanical					B	K	P	W				N
1.18	ALUMINIUM TUBES, FLATS PROFILES / 63401 WP												E	
a	Appearance	Visual	S&S Sampling Plan	IS 2678 / IS 3965	IS 2678 / IS 3965	CMTC	A	J	S	W				N
b	Dimensional Check	Mechanical	IS 2500 Pt - 1	IS 5082 / IS 733	IS 5082 / IS 733		A	J	S	W				N
c	Chemical Compostion	Mechanical					B	K	P	W				N
d	Physical Properties	Mechanical					B	K	P	W				N



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							<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>								
1.19	COPPER RODS, PROFILES, FLATS / PIPES																			
a	Appearance	Visual	S&S Sampling Plan IS 2500 Pt - 1	IS 613 / IS 191 IS 2501 / IS 1897 IS 2826, IS 5493	IS 613 / IS 191 IS 2501 / IS 1897 IS 2826, IS 5493	CMTC	A	J	S	W		N								
b	Dimensional Check	Mechanical					A	J	S	W		N								
c	Chemical Compostion	Mechanical					B	K	P	W		N								
d	Physical Properties	Mechanical					B	K	P	W		N								
e	Conductivity	Mechanical					A	J	S	W		N								
1.20	SILVER PLATED COMPONENTS																			
a	Appearance	Visual	5% per lot	As per approved drg	As per approved drg	CMTC	A	J	S	W		N								
b	Coating Thickness	Mechanical	2 per lot				A	J	S	W/Z		N								
<b>SECTION 2: INPROCESS INSPECTION</b>																				
2.1	DRIVE ASSY	Operation Check	IS 9921/ IEC - 62271 - 102	IS 9921/ IEC - 62271 - 102 Apprd. Drgs	IS 9921/ IEC - 62271 - 102 Apprd. Drgs	CMTC	A	J	S	W	N	N								
a)	Operation test (Close & Open)	Electrical	100%	IS 9921/	IS 9921/ IEC - 62271 - 102 Approved drg															
		Mechanical																		
b)	IR Value Check	Electrical	100%	More than 2 mega Ohms	To be withstood															
c)	High Voltage test	Electrical	100%	1.75 kV / 1 min	To be withstood															
d)	Dimensional Check	Mechanical	10%	IS 9921/ IEC - 62271 - 102 Apprd. Drgs	IS 9921/ IEC - 62271 - 102 Apprd. Drgs Free From Damage															
e)	Appearance	Visual	100%	do																
f)	Check for Manual operation interlock	Electrical	100%	do	OK/NOT OK															
	O/L, Relay operation	Electrical	100%		OK/NOT OK															
	Degree of rotation	Mechanical	100%		OK/NOT OK															
	Current Drawn by motor	Electrical	100%		Not more than rated current															
	Powder coating thickness	Mechanical	5%		60 Microns min															
g)	Check for Pick-up & Drop out voltage on contactors	Electrical	10%	IS 13947 (Part 4 / Sec4) IS 6875	OK/NOT OK															



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2.2	BASE CHANNEL				Apprd. Drgs										
	Including rotor bearing housing assembly / Main frame structure assembly.			Apprd. Drgs	Specn. / Apprd. Drgs / Apprd. Data sheet										
	a) Appearance	Visual	100%	do	do										
	b) Dimensional Check	Mechanical	5%	do	do		A	J	S	W		N			
	c) Check for thickness of Zinc coating	Mechanical	One sample per lot	86 microns / min	86 microns / min										
2.3	Male & Female Contact assembly														
	a) Appearance	Visual	100%	IS 9921 / IEC 129 Apprd. Drgs	IS 9921 / IEC 129 Apprd. Drgs										
	b) Dimensional Check	Mechanical	5%	do	Specn. / Apprd. Drgs / Apprd. Data sheet										
	c) Contact Resistance/ MV drop test	Electrical	100%	1.2 Times Type Test value Max.	1.2 Times Type Test value Max.		A	J	S	W		N			
2.4	EARTH SWITCH														
	a) Appearance	Visual	100%	IS 9921 / IEC 129 Apprd. Drgs	IS 9921 / IEC 129 Apprd. Drgs										
	b) Dimensional Check	Mechanical	5%												
<b>3</b>	<b>SECTION 3: FINAL INSPECTION</b>														
3.1	ACCEPTANCE TEST ON COMPLETE ISOLATOR ASSEMBLY & ALL ACCESSORIES AS PER BSPTCL SPECN. / APPRD. DRGS.	Visual	10% of each type per lot (To the nearest whole no.) (Minimum one)	IS 9921 / IEC 129 / IEC - 1129 / IEC 62271-102 Apprd. Drgs	IS 9921 / IEC 129 IEC - 1129 / IEC 62271-102 Apprd. Drgs										
	With available standard insulator and support structure can be used for acceptance test minimum 2 mt height to the approved drawing Forming part of the same Isolator with MOM (All acceptance Test as per contract to be conducted)	Mechanical							A	J	U	W/Z		Y	
		Electrical													





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3.2	<b>Operation test</b>												
	Witness 50 operation in high voltage & 5 operation in low voltag at rated motor vottage.MV drop test will be checked before & after operation (Contact Resistance).	Mechanical Electrical		IEC 62271-102 Apprd. Drgs	IEC 62271-102 Apprd. Drgs	Routine Test report	A	J	U	W/Z		Y	
	i) Check for current drawn by motor & operating time Test on Motor Drive Assembly a) Main Stroke b) Motor Drive Starting Current c) Continous Current d) Moving Time Switching Device d) Test on Control Circuit with diif. Voltages	Electrical		do	do	Routine  Test report	A	J	U	W/Z		Y	
	ii) Check for manual (Mech). operation & interlock (electrical & mechanical)	Electrical Mechanical		do	do	Routine Test report	A	J	U	W/Z		Y	
	iii) Vertically Alignment Check & Clearance Check	Electrical Mechanical		do	do	Routine Test report	A	J	U	W/Z		Y	
	iv) General assembly Dimensional Check & Aux. Switch and Limit Switch Operation	Electrical Mechanical		do	do	Routine Test report	A	J	U	W/Z		Y	
	v) Appearance for Completeness	Visual		Apprd. Drgs	Apprd. Drgs		A	J	U	W/Z		Y	
	vi) Dimensional measurement between Phase to earth& between conductive parts	Mechanical		do	do	Routine Test report	A	J	U	W/Z		Y	
	vii) Dielectric test on aux. and control ckt	Electrical		do	do				do				
<b>4</b>	<b>SECTION 4: PACKING &amp; DESPATCH</b>												
4.1	Verification of completeness of equipment & accessories	Visual	100%	Apprd. Drgs	Apprd. Drgs		A	J	S	W		N	
4.2	Check for soundness packing	Visual	100%	DO	DO		A	J	S	W		N	
4.3	Verification of Dispatch Instructions/Clearance Reference on Packing / Crates	Visual	100%	DO	DO		A	J	S	W		N	

**Notes:**

- Mechanical Operation Tests in Acceptance Testing as mentioned above shall be applicable as per the effective TS of a particular Project/Package. Sampling plan shall be 10% each type each lot or otherwise specified in the TS of BSPTCL.
- If Insulators are in the scope of Isolator Manufacturer then the same shall be inspected separately (being a separate CIP item) for which separate MQP shall be followed.
- Approval of Type Test Reports of Auxiliary Switches shall be applicable as per the effective GTR of a particular Project/Package.



PROCESS FLOW DIAGRAM FOR ISOLATOR MANUFACTURING

