

Parasmani Tubes Pvt. Ltd.



Mfgs. of: AIRCONDITION & REFRIGERATION COPPER TUBES & FITTINGS

PTP K -SERIES		QUALITY ASSURANCE PLAN				QAP 01 (00 / 01.02.12)	
Product : Seamless Tubes							
Name of Customer					Date		
Alloy		DHP Copper, UNS No. C1220			Specification		JIS H3300 (2006)
Temper		T-1/2HARD DRAWN			P.O. No.		
Issuer					Sign		
Sizes		1) 6.35MM OD X 0.8MMTHK. X 10 FT 2) 9.52MM OD X 0.8MMTHK. X 10 FT					
Sizes		3)12.7MM OD X 0.8MMTHK. X 10 FT 4) 15.88MM OD X 1.0MMTHK. X 10 FT					
Sizes		5)19.05MM OD X 1.0MMTHK. X 10 FT 6) 22.22MM OD x 1.0mm Thk X 10FT					
Sizes		7) 25.4MM OD x 1.0mm Thk X 10FT 8) 28.6MM OD x 1.0mm Thk X 10FT					
Sizes		9) 31.8MM OD x 1.1mm Thk X 10FT 10)34.9MM OD x 1.21mm Thk X 10FT					
Sizes		11) 38.1MM OD x 1.32mm Thk X 10FT12) 43.3MM OD x 1.43mm Thk X 10FT					
Sr. No.	Process	Characteristics to be Checked	Measuring Instrument	Quantum to be checked	Format of Record	Scope of TPIA	
1	(RAW MATERIAL) Shell Inspection	Chemical Comp.	Test Report	Random Sampling	Log Book		
		Dimensions	Micro Meter	Random Sampling	Log Book		
		Appearance	Visual	100%	Log Book		
2	Drawing	Dimensions	Micro meter	Random Sampling	Log Book		
		Surface	Visual	100%	-		
3	Eddy Current Test(E-243)	Surface & Internal Defects	Eddy Current Testing Machine	100%	Log Book		
4	Hydro test	Pressure Test & Leakage	Hydro test Machine	100%	Log Book		
5	Dimensional Check	Outer Diameter, Wall Thickness, Straightness & Length	Micrometer & Measuring Tape	100%	Log Book		
				100%	Log Book		
		Cleaning	Visual	100%			
6	Visual Inspection	Surface OA & ID	Visual	100%	Log Book		
7	Mechanical Properties Test	Tensile Test Yield Strength	UTM	Random Sampling	Log Book		
		Hardness	Hardness Tester	Random Sampling	Log Book		
8	Packing	Marking & Packing	As per customer Requirement	100%	Packing List		

Legends : RW - Review, W – Witness

REGD. OFFICE & FACT. : 5/2, G. I. D. C. UMBERGAON - 396 171. TEL.: 0260 – 3242708
MUMBAI OFF.: 2A, D. S. KAPOLE NIWAS, KHETWADI, 4TH LANE, MUMBAI- 400 004. TEL . :022 – 32602795 / 66337296
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Mfgs. of: AIRCONDITION & REFRIGERATION COPPER TUBES & FITTINGS

PTP K - SERIES		QUALITY ASSURANCE PLAN			QAP 01 (00 / 01.02.12)	
Product : COPPER Seamless Tubes						
Name of Customer				Date		
Alloy		DHP Copper, UNS No. C1220		Specification		JIS H3300 (2006)
Temper		Annealed (O60) Condition (Bright)		P.O. No.		
Issuer				Sign		
Size		6.35MM OD X 0.8MMTHK. X 50 FT Coil				
Size		9.52MM OD X 0.8MMTHK. X 50 FT Coil				
Size		12.7MM OD X 0.8MMTHK. X 50 FT Coil				
Size		15.88MM OD X 1.0MMTHK. X 50 FT Coil				
Size		19.05MM OD X 1.0MMTHK. X 50 FT Coil				
Sr. No.	Process	Characteristics to be Checked	Measuring Instrument	Quantum to be checked	Format of Record	Scope of TPIA
1	(RAW MATERIALS) Shell Inspection	Chemical Comp.	Test Report	Random Sampling	Log Book	
		Dimensions	Micro Meter	Random Sampling	Log Book	
		Appearance	Visual	100%	Log Book	
2	Drawing	Dimensions	Micro meter	Random Sampling	Log Book	
		Surface	Visual	100%	-	
3	Eddy Current Test(E-243)	Surface & Internal Defects	Eddy Current Testing Machine	100%	Log Book	
4	Coiling	Length	Measuring Tape	100%	Log Book	
5	Pre-Inspection	Dimension & Length	Micrometer	100%	Log Book	
			Measuring Tape	100%	Log Book	
		Surface	Visual	100%	Log Book	
6	Annealing	Temperature	Thermo Couple	Lot Wise	Log Book	
		Speed	Speed Controller	Lot Wise	Log Book	
7	Dimensional Check	Outer Diameter, Wall Thickness, Straightness & Length	Micrometer & Measuring Tape	100%	Log Book	
				100%	Log Book	
8	Visual Inspection	Surface	Visual	100%	Log Book	
9	Chemical Analysis of Final Product	Chemical Comp.	Spectro Analyzer	Random Sampling	Log Book	
10	Mechanical Properties Test	Microscopic examination at 75X	Micro Scope	Random Sampling	Log Book	
		Expansion Test	UTM	Random Sampling	Log Book	
		Tensile Test Yield Strength	UTM	Random Sampling	Log Book	
		Hardness	Hardness Tester	Random Sampling	Log Book	
11	Packing	Marking & Packing	As per customer Requirement	100%	Packing List	

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