

**QUALITY PLAN FOR ROOTECH ROOTS BLOWERS**  
 (PERFORMANCE / MECHANICAL RUN ROUTINE TEST)  
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**ROOTECH**  
**ROOTS BLOWERS**  
**TWIN LOBE TYPE**

No.	PART DETAIL	CHARACTERISTICS	CHECK	QUANTUM	REF. DOC.	ACCP. NORM	FORMAT	AGENCY			REMARKS
								AV	M	I	
<b>1.00</b>	<b>RAW MATERIAL</b>										
1.01	BODY,SIDE PLATES & ROTORS	a) MECHANICAL b) HARDNESS	TENSILE TEST MEASUREMENT	ONE PER HEAT	IS 210 :1993 App.data sheet	FG260 BHN 180-230	LAB T.C	P	V	V	
1.02	SHAFTS	a) CHEMICAL	CHEM. ANALYSIS	1 PER LOT	BS970(1955) App.data sheet/drg.	EN19	LAB T.C	P	V	V	
1.03	GEARS (FORGING)	a) CHEMICAL Hardness	CHEM. ANALYSIS Hardness	1 PER LOT	DIN17210	EN19 16MnCr5	LAB T.C LAB T.C	P	V	V	
<b>2.00</b>	<b>IN PROCESS INSPECTION</b>										
2.01	BODY,PLATES,ROTOR & GEARS	a) DIMENSIONS	MEASUREMENT	100%	MFG. DRG.	MFG. TOL.	Internal Inspection Report		P	V	
2.02	BODY,PLATES,ROTOR	b) HYDROSTATIC	HYDRO TEST AT MIN 1.5Kg/cm2	100%	NO LEAKAGE	NO LEAK	Internal Inspection Report		P	V	
2.02	SHAFTS	a) HARDNESS b) SUR.CRACKS	TESTER D.P Test (Shaft>40mm)	100%	MFG. DRG. MANF. PROCEDURE	MFG. TOL. NO DEFECT	Internal Inspection Report Internal Inspection Report		P P	V V	
2.03	GEARS	a) HARDNESS	SURFACE HARD.	HEAT LOT	MFG. DRG.	MFG. TOL.	Internal Inspection Report		P	V	
2.04	ROTOR ASSEMBLY	a) BALANCING	DYNAMIC	100%	ISO 1940-1,1986 -IS11732-1,1992	ISO1940-Gr 6.3	Internal Inspection Report	P	V	V	
<b>3.00</b>	<b>FINAL INSPECTION</b>										
3.01	PERFORMANCE TEST	a) PRESSURE,FAD SPEED,POWER b) NOISE c) VIBRATION	PERFORMANCE NOISE SCALE A VIB. TEST	100% 100% 100%	BS 1571 II 1975 DATA SHEET DATA SHEET	BS 1571 II 1975 do do	Internal Inspection Report Internal Inspection Report Internal Inspection Report		P P P	W W W	WORK/INST/DUTY POINT CONDITIONS
	BLOWER ASSEMBLY	a) DIMENSIONS	MEASUREMENT	Major	G.A. DRAWING	MFG. TOL.	Internal Inspection Report		P	V	After performance witness test only
3.02	PAINTING	a) PRIMING b) PAINTING	VISUAL VISUAL	100% 100%	App.data sheet	App.data sheet	Internal Inspection Report		P P	V V	After performance witness test only
4.00	DESPATCH										
4.01	DESPATCH	A.) Despatch	Visual for completeness and defect free	100%	Despatch Clearance and Work Instructions	G.A Drawings Despatch clearance	Internal Inspection report		P	V	After performance witness test only

ES :-

M- MANUFACTURER,AV- Approved Vendor, I-Inspector (Inspecting Agency)

1.) ALL TEST EQUIPMENT CALIBRATED / CERTIFIED TRACEABLE TO NATIONAL STANDARDS

P= PERFORM V= VERIFY W=WITNESS

2.) IN CASE OF ANY DEVIATION / NON CONFORMITY CLEARANCE SHALL BE TAKEN FROM ENGINEERING / CLIENT

#=ONLY IF SPECIFIED WHILE ORDERING