

NSS Quality Assurance Program

National Switchgear has in place a **Quality Assurance Program** to guarantee the best possible product:

- 19 **In-process Quality** sign-off points for the technicians during the re-manufacturing process
- 13 in-process **Hold Points** signed by inspectors during the re-manufacturing process
- 29 point **Final Inspection** signed by both the technician and the inspectors
- 16 point **Packaging Inspection** performed by the shipping team
- 24 point **Shipping Inspection** performed by the shipping team signed by both the shipper and the inspectors

National Switchgear follows a written **Re-manufacture Procedure**. The procedure is constantly being improved and revised. The procedure details the following areas:

- **Initial Test and Inspection** of breakers prior to re-manufacturing
- **Disassembly**
- **Parts reconditioning** of mechanism, current carrying, and insulating components
- **Re-assembly** details the assembly, adjustment, wiring, labeling, and retrofitting
- **Testing** is very thorough to NETA standards and recorded on computerized data sheets
- **Final Inspection** assures detailed records and finest quality

National Switchgear develops detailed **Circuit Breaker Specifications** based on original manufacturers data. The specifications cover the following areas:

- **Insulator List**
- **Hardened Parts List** (plating of certain hardened parts can cause failure)
- **Paint/Powder Coat Colors**
- **Plating**
- **Adjustments**
example for GE AK-50 circuit breaker
- 44 **Contact Adjustments** are required for an AK-50
- Up to 15 **Mechanism Adjustments** are required for the AK-50
- Up to 16 **Electrical Control Adjustments** are required for the AK-50
- 7 **Rack-In Mechanism Adjustments** are required for the AK-50
- 36 **Primary Disconnect Adjustments** are required for the AK-50