
 Ranipet		MANUFACTURER'S NAME & ADDRESS		MANUFACTURING QUALITY PLAN				BHEL P.O No. DATE: PROJECT: AS PER PO					
				ITEM: RESILIENT GRID TYPE COUPLINGS AS PER BHEL SPECN. APSQ:050		QP NO: RGC:002 Rev No. :00 Date: 09.05.2025 Page 1 of 2							
SL NO	COMPONENT & OPERATION	CHARACTERISTICS	CLASS OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK 6		REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		Agency M B C		REMARKS
1	2	3	4	5	M	B/C	7	8	9	D	10	11	

1.0	RAW MATERIALS											
1.1	Coupling hubs	Chemical analysis & Mechanical testing	Major	Review of TC	One per heat	BHEL Approved Drawing / BHEL Specification / Relevant material standard	TC	√	P	V	-	
1.2	Grid spring	Chemical & Hardness test	Major	Review of TC	Random sample	BHEL Approved Drawing / BHEL Specification / Relevant material standard	TC	√	P	V	-	
2.0	IN PROCESS INSPECTION											
2.1	Components	Machining dimension	Major	Measurement	100%	BHEL Approved drawing / manufacturer standard procedure	Report	-	P	-	-	
3.0	FINAL INSPECTION & TESTING											
3.1	Resilient grid type coupling assembly	Visual, overall dimension inspection	Major	Visual check, Measurement	100%	As per BHEL Sampling plan BHEL Approved Drawing / BHEL Specification / relevant standard	Report	√	P	W	-	
4.0	PAINTING, MARKING, PACKING AND PRESERVATION											
4.1	Resilient grid type coupling	Preservation, Marking and Packing	Major	Visual check	100%	BHEL purchase specification / approved drawing / Manufacturer standard	Report	√	P	V	-	

M – Manufacturer / Subcontractor, B - BHEL / BHEL Authorized Inspection Agency, C - Customer, P - perform, V - Verification of reports W - Witness, TC - Test certificate “D” – Record, identified with tick (√) shall be essentially included by Supplier in QA documentation. TDC – Technical Delivery Condition COC – Certificate of Conformance	MANUFACTURER – SIGN & SEAL	APPROVED BY (BHEL)
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Notes:

- 1. Latest version of standards & specifications shall be applied. Gauges and measuring instruments with valid calibration only shall be used.
- 2. Material specification mentioned in quality plan is for reference only. Actual material shall be as per Engineering drawing or purchase specification.
- 3. This QP shall be read along with relevant PO, BHEL specification, relevant material standard / drawing and all the requirements shall be complied
- 4. Inspection / Inspection wavier / approval by BHEL does not absolve supplier's responsibility for conformity of the specification as per the terms of PO.
- 5. BHEL / BHEL authorized representatives shall have the right to witness the necessary inspection and testing of goods mentioned in the PO.
- 6. The approval of this document by BHEL does not absolve / relieve the supplier from his responsibilities regarding the compliance of PO / contract and other Engineering / Quality approved documents.

RECORD OF REVISION

REV NO	DATE	DESCRIPTION
00	09.05.2025	Original Issue

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