



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY ASSURANCE PLAN FOR VENTILATOR BLADES TO BHEL ORDERING SPECIFICATION/DRAWING AS PER
PO

QUALITY PLAN NO. – QAP/QTM/VENDORQAP/2021-22/IM3601/VENTILATOR BLADES DTD 26.08.2022 REV 00
 Reference Document- PO DRAWING/SPECIFICATION

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SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP/A					
1)	Raw material	a) Chemical properties b) Mechanical properties c) Heat treatment per heat	TC verification	100%	100%	TM185/2	As per Specification	MTC	BHEL/TP/A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL /Supplier to get the raw material TC correlated with material TC.
2)	Dimension	Dimension	TC verification & Measurement (100 % CTQ on 3D-CMM & others by gauged/instruments	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 10% Witness
3)	Balancing	Static & Dynamic balancing	visual	100%	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 5 % Witness
4)	NDT test	A) DP test	Test	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 10% Witness

Prepared By

Approved By

(Signature)
S. RATHORE
 Dy. Manager
 QTM Division
 B.H.E.L., BHOPAL

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RAHUL TOPPO
 Dy. Manager
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				TP	TP/A					
		B) MPI TEST	Test	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 10% Witness
		C) Radiographic examination	Test	100%		As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % report to be reviewed by TP/A and reports to be submitted along with films
		Verification	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Embossing as per drawing
5)	Identification vendor name, PO & job serial no.	Verification	Visual	100%	10%	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	
6)	paint & shot blasting	Verification	Visual & TC verification	100%	10%	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	
7)	Packing to avoid transit-damage	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & specification		BHEL/TP/A	Packing to be such that no damages should occur during transit

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V. Manager
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