



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY ASSURANCE PLAN FOR STATOR & ROTOR END PLATE TO BHEL ORDERING SPECIFICATION/DRAWING
AS PER PO

QUALITY PLAN NO. – QAP/QTM/VENDORQAP/2021-22/STATOR & ROTOR END PLATE/IM3004 DTD 29.03.2023 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 (investment casting)	a) Chemical properties b) Mechanical properties c) Heat treatment per heat	TC verification	100%	100%	AA19511	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 3 samples per heat/heat treatment batch to be submitted to BHEL duly punched by TP/A
2)	Dimension	Dimension	TC verification & Measurement	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 10% Witness
3)	NDT test (before machining)	A) Ultrasonic testing	Test	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % RR & 10% Witness
4)	Identification vendor name, PO & job serial no.	Verification	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Embossing as per drawing

Prepared By

श्री. एस. एस. राठौर / G.S. RATHORE
अथ प्रबंधक / Dy. Manager
अथ. टी. एस. निर्यात / QTM Division
बी.एस.ई.एल. भोपाल / BHEL, BHOPAL

Approved By

श्री. राहुल टोपो / RAHUL TOPPO
अथ प्रबंधक / Manager
अथ. टी. एस. निर्यात / QTM Division
बी.एस.ई.एल. भोपाल / BHEL, BHOPAL

