



# BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

## QUALITY ASSURANCE PLAN FOR FAN MCD TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. – QAP/QT/QT/VENDORQAP/2021-22/ FAN MCD 4601 DTD 10.12.2021 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	All tests	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.
2)	Dimension	a) CTQ Dimension	3D-CMM	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
3)	Surface finish	b) Other Dimension Burr, Sharp edges, surface finish	Instrument/gau ges visual	20%	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
4)	Casting	Stress relieving & sand blast/shot blast	Verification	100%	100%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness

Prepared By

Approved By

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5)	NDT TEST	a) DP & MPI	TEST	100%	20%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
		b) RADIOGRAPHY TEST	TEST	100%	5%					
6)	Static balancing	Static balancing	visual	100%	5%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness
7)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Embossing to be done as per drawing
8)	Primer paint	Paint	verification	100%	100%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	

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