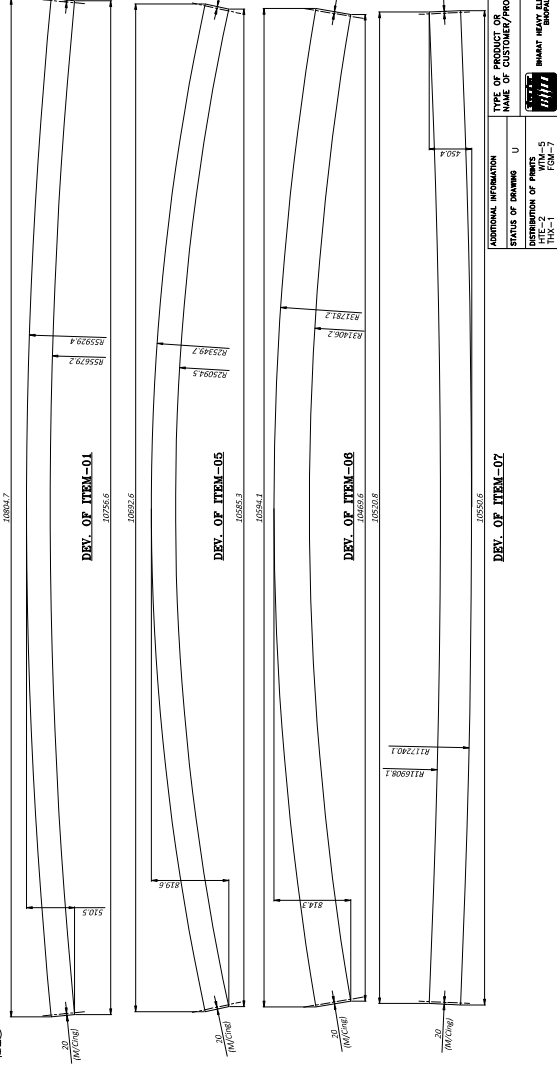
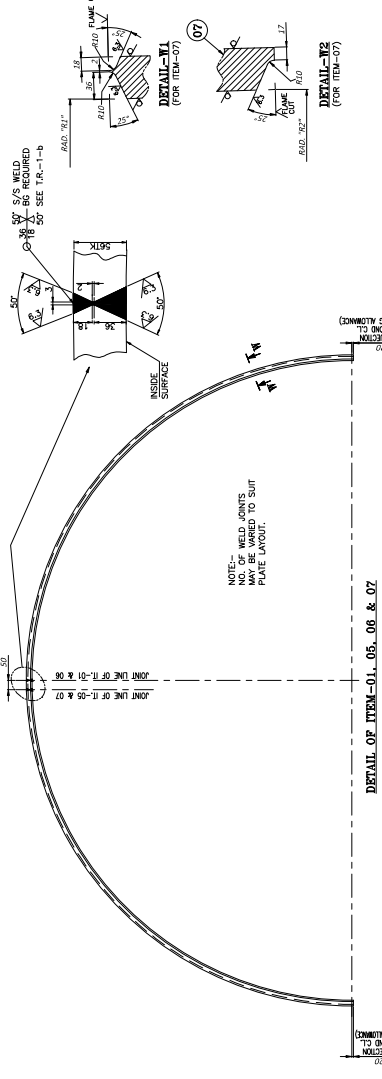
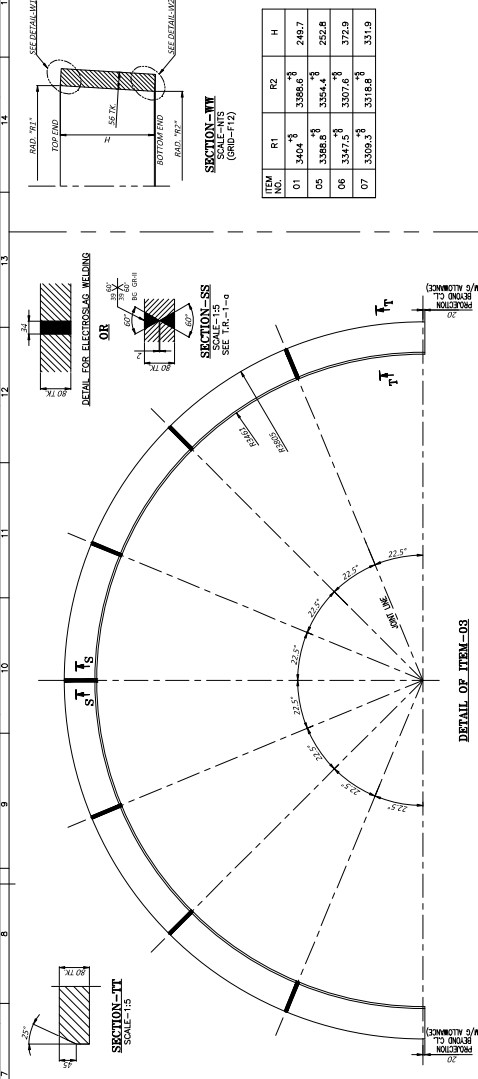
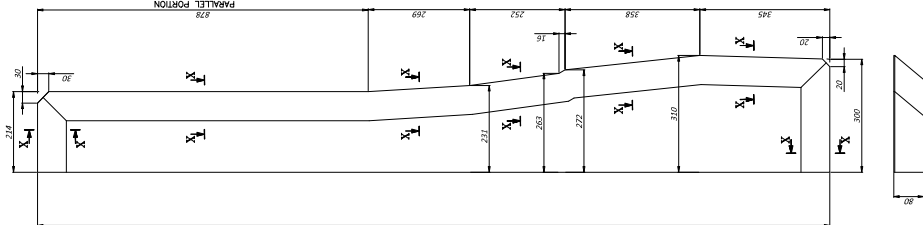


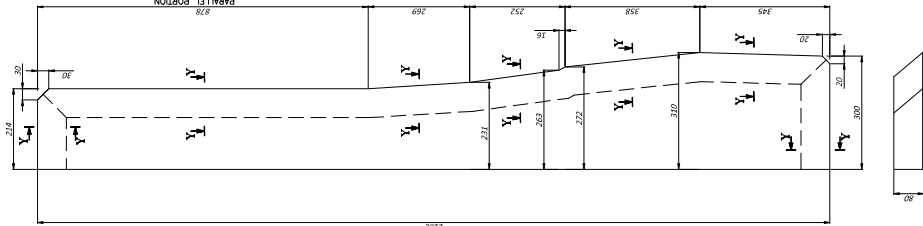
0 202 06 14202	
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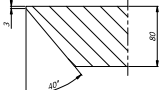
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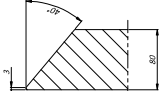
DETAIL OF ITEM-08



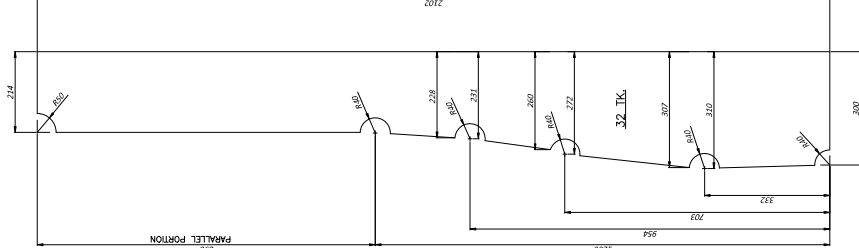
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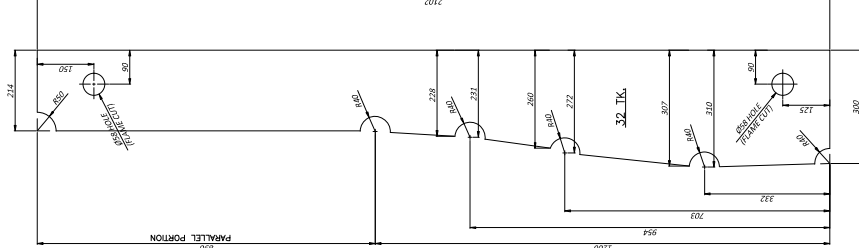
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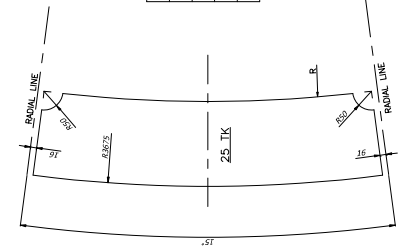
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DETAIL OF ITEM-10

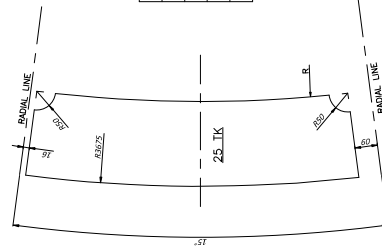


DETAIL OF ITEM-21



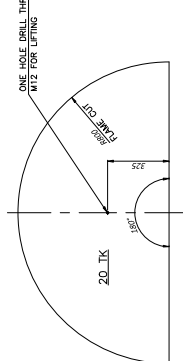
DETAIL OF ITEM-11, 13, 15 & 17

ITEM NO.	RADIUS "R"
11	3461
13	3449
15	3398
17	3368

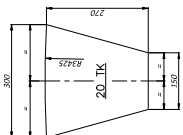


DETAIL OF ITEM-12, 14, 16 & 18

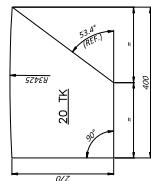
ITEM NO.	RADIUS "R"
12	3461
14	3449
16	3398
18	3368



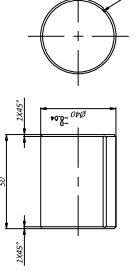
DETAIL OF ITEM-23
SCALE 1:10



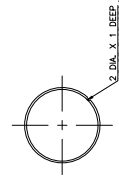
DETAIL OF ITEM-24





DETAIL OF ITEM-25



DETAIL OF ITEM-20



DETAIL OF ITEM-22
SCALE 1:2.5

<div><div>MANUFACTURER'S NAME AND ADDRESS</div><div>VENDOR'S NAME AND ADDRESS</div></div>		MANUFACTURING QUALITY PLAN					PO/ ENQIRY NO:			
		ITEM: RUNNER ENVELOPE (MACHINING)		QP NO.: QA/HT/2222 REV.NO.: 00 DATE: 11.01.2025 PAGE: 01 OF 01			RECORD FORMAT	AGENCY M B		REMARKS
SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	CHECK TYPE	QUANTUM OF CHECK	REF. DOC. & ACCEPTANCE NORM	7.	8.	9.	10.
1.	2.	3.	4.	5.	6.					
1.0 Joint Faces										
1.1	Straightness	Gap check after joining	Major	Meas / Vis	100%	BHEL Drawing		IR	P	V
2.0 Machining of full ring										
2.1	Marking of CL	CL band to be marked	Major	Vis	100%	BHEL Drawing		JIR	P	W
2.2	Dimensional check	Finished diameters/ radius	Critical	Meas / Vis	100%	-do-		JIR	P	W
2.3		Finished Heights-individual	Critical	Meas / Vis	100%	-do-		JIR	P	W
2.4		Finished chamfers / tapers (size, angle & location)	Major	Meas / Vis	100%	-do-		JIR	P	W
2.5		Surface finish check	Major	Meas / Vis	100%	-do-		JIR	P	W
2.6	Drilling operations	Drilling operation (PCD, Size & location of holes)	Major	Meas / Vis	100%	-do-		JIR	P	W
2.7		Tapping Operation check by GO-NOGO gauges	Major	Meas	100%	-do-		JIR	P	W
2.8		Dowelling & tag-welding of dowels	Minor	Vis	100%	-do-		JIR	P	W
<div><div>AADHAR SHARMA Manager QWTT Division BHEL, Bhopal</div></div>		LEGEND: M: MANUFACTURER/SUB-SUPPLIER, B: BHEL / BHEL APPOINTED THIRD PARTY P: PERFORM W: WITNESS, R: REVIEW OF RECORDS, COC -CERTIFICATE OF CONFORMANCE, IR: INTERNAL REPORT, JIR: JOINT INSPECTION REPORT MEAS: MEASUREMEENT, VIS: VISUAL CHECK		For Vendor's QC representative						

Note:1. Compliance with this QAP does not absolves the vendor from their responsibility of design, manufacture and supply as per purchase specification so as to give satisfactory performance.

Note 2: In case of any discrepancy / interpretational issue, BHEL Specification and Drawing shall be binding.

Note 3: The QAP states bare minimum testing requirement, which vendor is expected to fulfil. Any test not mentioned in the QAP, but a part of drawing or specification, is to be carried out and internal documents for the same shall be submitted.

Note 4: Documentation to essentially include: (a) Dimension Reports (b) Guarantee Certificate (GC) (c) CQIR