

		MANUFACTURER'S NAME & ADDRESS: BHEL APPROVED TURBINE BLADE SUPPLIER		SAMPLE QUALITY PLAN												
		ITEM: MOVING BLADES Stage : 1B PROJECT : 30 MW ROTOR NSPCL BHILAI-SPARE		QP NO. : STE/DOC/2026/006 REV. : 00 DATE : 06.09.2024 PAGE : 1 OF 1		SIGN OF MFR		QP.NO: REV.: DATE : VALID UPTO :		REVIEWED BY		APPROVED BY				
SL.NO	COMPONENTS & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK M B/N		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY M B N			REMARKS		
1	2	3	4	5	6		7	8	9	D	10			11		
1.000	Material receiving inspection															
1.100		Verification of PMIV	Major	review	100%		MTC	As per BHEL drg./Spec.	Receiving inspection record	√	P	V		RECORDS OF RUB-OFF OF HEAT NUMBER IDENTIFICATIONS OF SUPPLIED BARS		
2.000	In process inspection															
2.100	Dimensions	Dimensional examination after machining (including profile check)	Major	Measurement	100%	5%/stage	Drawing	Drawing	Obs. Sheet	√	P	W				
		Dimension check on CMM	Major	Measurement	5%	02 No. blades / stage	Drawing	Drawing	Obs. Sheet	√	P	W				
2.200	Material mix up test by PMI	Material mix up test	Major	Material mix up test	100%	5%/stage	-	As Per Specification	Report	√	P	W				
2.300	NDT	MPI on finished blades	Major	NDT	100%	10%/stage	HW0993001	HW0993001	Inspection report	√	P	W				
2.400		Identification	Major	Visual	100%	-	-	Hard punch , stg No., BHEL PO No. at bottom of root	-	√	P	V				
3.000	Final inspection															
3.100		Check for cleanliness and completeness.	Minor	Visual	100%		Drawing	Drawing	COC	√	P	V	-			
3.200		Preservation, Packing & Dispatch	Major	Visual	100%		TRP for preservation. In wooden box to avoid any transit damage.		-		P	-	-			
LEGEND: - *RECORDS IDENTIFIED WITH 'TICK' SHALL BE ESSENTIALLY INCLUDED BY CONTRACTORS IN QA DOCUMENTATION. **M: MANUFACTURER / SUB-SUPPLIER. B: BHEL/BHEL TPIA, N: NSPCL, INDICATE P: PERFORM. 'W'-WITNESS. 'V'-VERIFICATION OF RECORDS. CHP :NSPCL SHALL BE IDENTIFIED IN COLUMN N.																