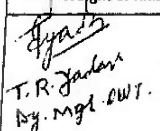


		MANUFACTURER'S NAME AND ADDRESS:		STANDARD MANUFACTURING QUALITY PLAN				PO NO. & DATE (To be filled by the vendor)				
				ITEM: MACHINING OF PELTON RUNNER (FROM FORGED DISC)		QP NO.: QA/HT/2143 REV.NO.: 00 DATE: 11/06/2022 PAGE: 01 OF 01						
REFERENCE DOCUMENT: PURCHASE ORDER & BHEL DRAWING AND INSPECTION SHEET												
SL. NO	OPERATIONS & CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOC.	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY		REMARKS
				M	B				D*	M	B	
1.	2.	3.	4.	5.		6.	7.	8.	D*	**	10.	11.
1.	Template check (check of templates with 1:1 drawing)	Critical	Measurement	100%	100%	1:1 drawing / BHEL drawing		QCR	✓	P	W	
2.	Checking of bucket Chord / pitch	Critical	Measurement	100% (each bucket)		Drawing /Drawing TR /BHEL inspection sheet		QCR	✓	P	W	Each bucket to be identified with running serial number hard punched
3.	Checking of bucket Inner & outer width	Critical	Measurement	100% (each bucket)		-do-		QCR	✓	P	W	
4.	Checking of bucket PCD	Critical	Measurement	100%	100%	-do-		IR	✓	P	W	
5.	Check of complete bucket profile (longitudinal & transverse) including root area, splitter section, bucket angle w.r.t. hub, blending radius & bucket thickness	Critical	Measurement	100% (each bucket)		-do-		QCR	✓	P	W	
6.	Final main dimensions (Runner OD, ID, Hub thickness)	Major	Measurement	100%	100%	-do-		QCR	✓	P	W	
7.	Surface finish (to be recorded separately for hub, central bore and each bucket inside & outside region)	Critical	Measurement	100%	100%	-do-		QCR	✓	P	W	
8.	Waviness check & undulation check	Major	Measurement	100% (each bucket)		-do-		QCR	✓	P	W	
9.	Visual inspection (check for sling, tool marks etc)	Minor	Measurement	100%	100%	-do-		QCR	✓	P	W	
10.	Identification	Major	Visual	100%	100%	-do-		CoC	✓	P	W	
11.	Packaging & bucket protection	Major	Visual	100%	100%	-do-		CoC	✓	P	V	Photographs to be approved by BHEL before dispatch
12.	Weight of finished runner	Minor	Measurement	100%	100%	-do-		QCR	✓	P	V	
 T.R. Jaiswal Ag. Mgt. LWT.		LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER C: SUPPLIER/ SUPPLIER NOMINATED INSPECTION AGENCY, B:BHEL'S CUSTOMER/ BHEL QC/ BHEL APPOINTED INSPECTION AGENCY (OR ANY COMBINATION OF 2 AGENCIES) P: PERFORM W: WITNESS AND V: VERIFICATION IR-INSPECTION REPORT QCR-QC REPORT TC-TEST CERTIFICATE RR-REVIEW OF RECORD COC: CERTIFICATE OF COMPLIANCE							ACCEPTED BY (VENDOR'S QC REPRESENTATIVE)			
Signature (BHEL)												

1. Upon observance of any forging defect during machining, vendor has to stop machining and inform BHEL regarding the same. Vendor to further proceed only after written confirmation from BHEL in such case.
2. Compliance with this QAP does not absolve the vendor from their responsibility of machining and supply as per BHEL PO and drawing so as to give satisfactory performance upon commissioning.
3. In case of any discrepancy / interpretational issue, BHEL PO and Drawing shall be binding.