

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY CONTROL TRANSPORTATION
QUALITY ASSURANCE PLAN(QAP)

QA PLAN NO.: QTM/TXM/VENDOR/QAP/2017-18/ARMATURE SHAFT REV 00 DT. 16.09.2017
REFERENCE- SPEC NO. TM 10463/ dng no.34394060058

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TP/A			
1.0	Raw Material Test Certificate	A	VR	100%	100%	As per spec.	TR	TEST LAB NABL/ SOURCE MILL
								Material TC along with Heat treatment Details graph is to be submitted
2.0	Dimensions	A	I	100%	10%	As per Drg/PO	SR	Dimensions Report is to be Submitted
3.0	Testing (mechanical and chemical)	A	I	One sample per heat/forge	Sample identification with seal	As per spec.	SR	300 mm Extended length on 3 nos shaft per heat is to be supplied to BHEL for testing.
4.0	MP1 test	A	I	100%	10%	As per spec	SR	Report to be submitted
5.0	Surface finish	A	I	100%	10%	As per drg.	SR	Report to be submitted
6.0	Identification Vendor Name, PO no., Heat no. & item serial no.	A	VR	100%	10%	PO/Drawing	SR	Identification on all bars is to be done

PREPARED BY

PREPARED BY

APPROVED BY

Notes:

1) All TRS checked by TR (fully checked & signed)

... shall be submitted along with commitment.

Abbreviation: A - Critical, B - Major, VR - Verification, I - Instrument/ Gauges

Major, VN – Verification

AGENCIES:

TPA-BHEL appointed third Party Inspecting Agency

TP – Task Performer