

Manufacturer's Logo, if available Format No		MANUFACTURER'S NAME & ADDRESS:		MANUFACTURING QUALITY PLAN				PROJECT: BHEL PO NO & DATE:					
				PRODUCT:				MQP NO:					
SUB-SYSTEM :				REV NO:									
								DATE: DD/MM/YYYY				PAGE: 1 OF 2	
SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS	
1	2	3	4	5	6	7	8	9	D**	**	10	11	
1.0 RAW MATERIALS & BOUGHT OUT ITEMS (BOI):													
									√				
									√				
									√				
2.0 INPROCESS CONTROLS:													
									√				
									√				
									√				
3.0 FINAL INSPECTION :													
									√				
									√				
									√				
4.0 PAINTING, MARKING, PACKING AND PRESERVATION:													
									√				
									√				

QP shall be submitted in the format incorporating following minimum checks, format to be signed, sealed as token of acceptance

- a. Raw materials test certificate review (chemical & Mechanical tests) - per heat / heat treatment batch and NDT test (if applicable).
- b. BOI Items (if any) - Review of reports in line with specification.
- b. In process inspection stages like heat treatment, machining etc (as applicable)
- c. Visual & Dimension inspection, functional test (if applicable) (witness by BHEL TPI)
- d. Packing, Painting & preservation details
- e. Any other relevant stages as per specification / standard

		LEGEND: * RECORDS IDENTIFIED WITH “TICK” (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER, C: BHEL / BHEL AIA, N: CUSTOMER; P: PERFORM, W: WITNESS, V: VERIFICATION; CLASS: A - CRITICAL; B - MAJOR; C – MINOR; MTC- MILL /MANUFACTURER'S TEST CERTIFICATE; IR- INSPECTION REPORT.
PREPARED BY	REVIEWED & APPROVED BY	
MANUFACTURER	MAIN SUPPLIER (BHEL)	
SIGNATURE & SEAL		

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- NOTES:**
- Latest revision of standards & specifications shall apply.
 - Materials shall be procured in compliance to Functional Technical Specification.
 - Inspection shall be in compliance with approved Quality Control Procedure for the product.
 - Qualified Personnel shall carry out NDT with compliance to approved NDT Procedures and Acceptance Norms, as per ASME Section V.
 - Gauges and measuring Instruments, with valid calibration only shall be used
 - Cleaning and Painting of products shall be carried out as per Approved Painting Schedule as applicable.
 - Finished Products shall be packed to comply with approved Packing Schedule.
 - BHEL Authorized representatives shall have the right to witness the necessary inspection and testing of goods mentioned in the PO. Inspection / Inspection wavier / approval by BHEL does not absolve Supplier's responsibility for conformity of the specification as per the terms of PO.
 - QA Documentation package shall include copy of approved Data Sheets/ Drawings & QP, along with all Material Test Certificate (MTCs), CHPs, Material Dispatch Clearance Certificate for all items.
 - This QP shall be read along with relevant PO, BHEL drawing and approved data sheet.
 - This QP is applicable for mandatory spare also as applicable.

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