

	MANUFACTURING QUALITY PLAN						PROJECT : NEYVELI/ CHHABRA PACKAGE : CONTRACT NO. : CONTRACTOR : BHEL			
	ITEM : LP INNER OUTER CASING (INDENT NO. : T201/6/4150W Dt: 23.09.06) SUB SYSTEM: 10741				QP NO.: 1.03.09 REV: 00 DATE: 30-Sep-06 PAGE: 1 of 1					

SL NO.	COMPONENT AND OPERATIONS	CHARACTERSTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE OF NORMS	FORMAT OF RECORDS	AGENCY			REMARK
									S	B	C	
1	2	3	4	5	6	7	8	9	D*	10		11
1.000	Material											
1.100		Verification of suppliers certificate of plates	Major	TC review	100%	AA 10108 AA 10119	AA 10108 AA 10119	Receiving inspection record	✓	V	V	
2.000	Inprocess inspection											
2.100		Visual inspection of welds	Minor	Visual	100%	Drg.	Drg.	Obs.sheet	✓	P	V	
2.200		Verification of stress relieving records	Major	Visual	100%	Drg.	Drg.	Chart	✓	P	V	
2.300		UT of butt welds	Major	NDT	10%	Drg.	Drg.	Report	✓	P	W	
2.400		DPT of fillet welds	Major	NDT	10%	Drg.	Drg.	Report	✓	P	V	
2.500		DPT of lifting lugs	Major	NDT	100%	Drg.	Drg.	Report	✓	P	V	
2.600		Verification of dimensions & visual inspection after machinin	Major	Measurement	100%	Drg.	Drg.	Logsheet	✓	P	W	NOTE-1
3.000	Final inspection											
3.100		Visual inspection after final machining, cleanliness & completeness.	Major	Visual	100%	Drg.	Drg.	Report	✓	P	V	

NOTE-1: IN ADDITION TO LOGSHEET, VENDOR TO SUBMIT DETAILED INSPECTION REPORT OF DIMENSIONS, THREADING, SURFACE FINISH.

NOTE-2: CUSTOMER HOLD POINT WILL BE INFORMED LATER ON.

		LEGEND: ** S: SUB-VENDOR B: BHEL/ BHEL NOMINATED INSPECTION AGENCY. C: CUSTOMER, P: PERFORM, W: WITNESS AND V:REVIEW OF RECORDS. "W" INDICATED IN COLUMN "C" SHALL BE 'CHP' CHP: CUSTOMER HOLD POINT * RECORDS IDENTIFIED WITH "TICK" SHALL BE SUBMITTED TO CUSTOMER AS A QA DOCUMENTATION PACKAGE.		DOC NO.: _____ REV.....	
MANUFACTURER/ SUB CONTRACTOR	MAIN-SUPPLIER				
SIGNATURE			FOR CUSTOMER USE	REVIEWED BY	APPROVED BY
					APPROVAL SEAL