

	<b>MANUFACTURING QUALITY PLAN</b>						<b>PROJECT :</b> NEYVELI/ CHHABRA <b>PACKAGE :</b> <b>CONTRACT NO. :</b> <b>CONTRACTOR :</b> BHEL						
	<b>ITEM :</b> LP INNER INNER CASING <b>( INDENT NO. : T201/6/4150W Dt: 23.09.06)</b> <b>SUB SYSTEM:</b> 10742 10304				<b>QP NO.:</b> 1.03.02 <b>REV:</b> 00 <b>DATE:</b> 30-Sep-06 <b>PAGE:</b> 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	
1	2	3	4	5	6	7	8	9	D*	S	B	C	11

1.000	Material												
1.100		Verification of suppliers certificate of plates & half ring.	Major	TC review	100%	HW 19572 AA 10119 AA10401	HW 19572 AA 10119 AA10401	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.**

MANUFACTURER/ SUB CONTRACTOR	MAIN-SUPPLIER	<b>LEGEND:</b> <b>** S: SUB-VENDOR</b> <b>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'</b> <b>CHP: CUSTOMER HOLD POINT</b>	FOR CUSTOMER USE	DOC NO.:		REV.....	
				CAT.....			
SIGNATURE		* RECORDS IDENTIFIED WITH "TICK" SHALL BE SUBMITTED TO CUSTOMER AS A QA DOCUMENTATION PACKAGE.	REVIEWED BY	APPROVED BY	APPROVAL SEAL		