

MANUFACTURER'S NAME AND ADDRESS		STANDARD QUALITY PLAN					TO BE FILLED BY BHEL		TO BE FILLED BY BHEL			
BHEL	VENDOR'S NAME	ITEM	BUTTERFLY VALVE		QP NO.	QA_BI_QP_104						
				DATED	21.10.2014							
		DRG. NO.	AS PER PO									
		SPEC.	AS PER PO									
		REV	02		Page 1 of 1							
SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS
1	2	3	4	5	6	7	8	9	D	10		11

1	MATERIAL											
1.1	BODY, DISC	CHEMICAL COMPOSITION MECHANICAL PROPERTIES	MAJOR	CHEMICAL MECHANICAL	1 / HEAT	ORDERING SPEC. / BHEL APPD. DRG.	ORDERING SPEC. / BHEL APPD. DRG.	MILL TC	√	P	V	
		SURFACE DEFECTS	MAJOR	VISUAL	100%	MSS-SP-55	MSS-SP-55	TC	√	P	V	
		DIMENSIONS	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG.	BHEL APPD. DRG.	TC	√	P	V	
1.2	LIMIT SWITCH	FUNCTIONAL	MAJOR	ELECTRICAL	100%	BHEL APPD. DRG.	BHEL APPD. DRG.	COC	√	P	V	
2. IN PROCESS INSPECTION												
2.1	MACHINING OF BODY, DISC	DIMENSIONS	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG.	BHEL APPD. DRG.	IR	√	P	V	
		SURFACE DEFECTS	MAJOR	DPT	100%	ASTM E165 ASME B16.34	ASME B16.34	TC	√	P	V	
2.2	HARD FACING ON DISC & SEAT	HARDNESS	MAJOR	HARDNESS	10%	BHEL APPD. DRG.				P	V	IF CALLED IN DRAWING
3												
3.1	ASSEMBLY OF VALVE	DIMENSIONS	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG.	BHEL APPD. DRG.	TC	√	P	W	
3.2	FUNCTIONAL TEST	SMOOTH OPERATION OPENING & CLOSING TIME	MAJOR	OPERATION	100%	ORDERING SPEC. / BHEL APPD. DRG.	ORDERING SPEC. / BHEL APPD. DRG.	TC	√	P	W	
3.3	HYDRAULIC TEST	LEAKAGE	CRITICAL	HYDRAULIC	100%	ORDERING SPEC. / BHEL APPD. DRG.	ORDERING SPEC. / BHEL APPD. DRG.	TC	√	P	W	
3.4	SEAT LEAK TEST	LEAKAGE	CRITICAL	HYDRAULIC / PNEUMATIC	100%	ORDERING SPEC. / BHEL APPD. DRG.	ORDERING SPEC. / BHEL APPD. DRG.	TC	√	P	W	
3.7	PRESERVATION & PAINTING		MAJOR	VISUAL	100%	BHEL SPEC		IR	√	P		

		LEGEND: ! RECORDS IDENTIFIED WITH 'TICK' SHALL BE ESSENTIALLY INCLUDED BY CONTRACTOR IN QA DOCUMENTATION. M: MANUFACTURER / SUBCONTRACTOR B: BHEL / NOM. INSPECTION AGENCY N: CUSTOMER INDICATE 'P' PERFORM 'W' WITNESS AND 'V' VERIFICATION ALL 'W' INDICATED IN COLUMN 'N' SHALL BE 'CHP' OF CUSTOMER	FOR CUSTOMER USE
MANUFACTURER/SUBCONTRACTOR			APPROVED BY