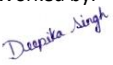
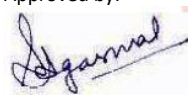


Manufacturer Name and Address		MANUFACTURING QUALITY PLAN				APPLICABILITIES TO	
BHEL Haridwar accepted sub-contractors only	ITEM/EQUIPM-ENTS	INDUCTION HARDENING OF CENTERING BOLT	Q.P. NO	QP/QA/232201	PROJECT		
	W.O. NO.	10866P11501, 10867P11501, 10868A11501, 10869A11501, 10870A11501, 10871A11501	DATE	15.01.2024			
			REV. NO.	00	CONTRACTOR	BHEL (HEEP) HWR	
			PAGE NO.	Page 1 of 2	Indent	20230702 rev 02 dated 31.12.2023	

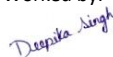
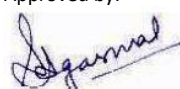
S. No.	COMPONENT OPERATION	CHARACTRISTIC CHECKED	CATE-GORY	TYPE/ METHED OF CHECKED	QUANT-UM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	FORMAT OF RECORD	AGENCY				REMARK
									D	M	B	C	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
1.0	Material Receiving Inspection at sub-contractor's work	Verification of identification of material	Major	Visual inspection	100 %	As per Drg./ Standard	As per Drg./ Standard	PPMIV/ Q.no.	✓	P	V	-	Material will be supplied by BHEL, transfer of identification to be ensured.
		Verification of dimensions and visual Inspection	Major	Measurement	100 %	As per drg./ Standard	As per drg./ Standard	Obs. Sheet	-	P	-	-	
2.0	<b>INPROCESS-INSPECTION</b>												
2.1	For sample	Induction hardening & tempering, hardness check, NDT	Major	Process	As per drg./ Standard	As per drg./ Standard	Standard	Record	✓	P	V	-	Refer Note 4
2.2	For actual job	Induction hardening & tempering	Major	Process	As per drg./ Standard	As per drg./ Standard/ Established process parameters	Standard/	Record	✓	P	V	-	BHEL approved process shall be used.
2.3		Check for hardness	Major	Measurement	As per drg./ Standard	As per drg./ Standard	As per drg./ Standard	Report	✓	P	W-Random	-	
2.4		NDT	Major	NDT	As per drg./ Standard	As per drg./ Standard	As per drg./ Standard	Report	✓	P	W	-	
2.5		Completeness of Job, Documentation	Major	Visual	100%	As per drg./ Standard	As per drg./ Standard	Record	✓	P	V	-	Item shall be dispatched to BHEL after acceptance by BHEL/ BHEL nominated agency after duly identifying by P.O.No., drg no. Plant Order No. and I.R.No

- All requirements of P.O., standard and drawing shall be fulfilled.
- Preservation of machined surfaces to be done with grease or oil (as per indent).

Manufacturer/ Subcontractor	Legends: P Perform by; W Witness by; V Record review; C Customer; B BHEL/BHEL Representative; M Manufacturer/ sub-contractor; D: documents with tick mark shall be submitted by vendor to BHEL.	For BHEL Use	
		Worked by:  Deepika Singh, (QAX)	Approved by:  Sugandh Agarwal, Manager (QAX)

Manufacturer Name and Address		MANUFACTURING QUALITY PLAN				APPLICABILITIES TO	
BHEL Haridwar accepted sub-contractors only	ITEM/EQUIPM-ENTS	INDUCTION HARDENING OF CENTERING BOLT	Q.P. NO	QP/QA/232201	PROJECT		
	W.O. NO.	10866P11501, 10867P11501, 10868A11501, 10869A11501, 10870A11501, 10871A11501	DATE	15.01.2024			
			REV. NO.	00	CONTRACTOR	BHEL (HEEP) HWR	
			PAGE NO.	Page 2 of 2	Indent	20230702 rev 02 dated 31.12.2023	

3. BHEL reserves the right for conducting repeat test, if required.
4. Process qualification test results on sample (provided by BHEL) are to be submitted to BHEL for review & acceptance. Vendor may submit process qualification report if carried out earlier for item of similar grade; BHEL shall review the same and if, acceptable, may waive off the process qualification requirement.

<b>Manufacturer/ Subcontractor</b>	<b>Legends:</b> P Perform by; W Witness by; V Record review; C Customer; B BHEL/BHEL Representative; M Manufacturer/ sub-contractor; D: documents with tick mark shall be submitted by vendor to BHEL.	<b>For BHEL Use</b>	
		Worked by:  Deepika Singh, (QAX)	Approved by:  Sugandh Agarwal, Manager (QAX)