

MANUFACTURER'S NAME AND ADDRESS			STANDARD QUALITY PLAN					TO BE FILLED BY BHEL		TO BE FILLED BY BHEL			
BHEL	VENDOR'S NAME	ITEM	VAPOUR EXHAUSTER	QP NO.	QA/BE/QP/306								
				DATED & REV	19.03.2025 04								
		DRG. NO.	AS PER PO										
		SPEC.	TG 60432										
		REV	AS PER PO			Page 1 of 2							
SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS		AGENCY			REMARKS
									D	M	B	N	
1	2	3	4	5	6	7	8	9	D	10			11

1.0	RAW MATERIAL												
1.1	CASING, IMPELLER, BLADES & BASE FRAME/ PLATE, SLEEVE, O-RING	CHEMICAL, MECHANICAL PROPERTIES & SIZE	MAJOR	TEST & MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	MTC	✓	P	V	V	
1.2	NUTS & BOLTS	TRADE MARK & PRPERTY CLASS	MAJOR	VISUAL	100%	AS PER VENDOR'S PROCEDURE	AS PER VENDOR'S PROCEDURE	IR	✓	P	V	-	
1.3	AC INDUCTION MOTOR (Please specify make, degree of protection and rating)	ROUTINE & TYPE TESTS CERTIFICATE INCLUDING DEGREE OF PROTECTION AND EXPLOSION PROOFNESS	MAJOR	REVIEW	100%	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	TC	✓	P	V	V	Also Include Enclosure Certificate as per Spec
2.0	INPROCESS INSPECTION												
2.1	ALL WELDS	QUALITY OF WELDS	MAJOR	DPT	100%	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	IR	✓	P	V	-	NOTE:1
2.2	IMPELLER	DIMENSIONS	MAJOR	MEASUREMENT	100%	ORDERING DWG	ORDERING DWG	IR	-	P	-	-	
		DIMENSIONS AFTER MACHINING	MAJOR	MEASUREMENT	100%	ORDERING DWG	ORDERING DWG	IR	-	P	-	-	
		DYNAMIC BALANCING	MAJOR	MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	TC	✓	P	V	V	
2.3	ASSEMBLY OF FAN	INTERNAL CLEARANCE BETWEEN IMPELLER & CASING	MAJOR	MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. / DATA SHEET	IR	✓	P	V	-	
3.0	FINAL INSPECTION ON THE COMPLETE ASSEMBLY												
3.1		OVERALL DIMENSIONS	MAJOR	MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	TC	✓	P	W	V	

		LEGEND: RECORDS IDENTIFIED WITH '✓' 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

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3.2		PERFORMANCE (INCLUDING AIR DELIVERY, PRESSURE & POWER CONSUMPTION)	MAJOR	PERFORMANCE	100%	IS:4894/ ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	IS:4894/ ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	TC	✓	P	W	V	
3.4		FAN SPEED, SMOOTH RUNNING, DIRECTION OF ROTATION	MAJOR	VISUAL	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	IR	✓	P	W	V	
3.5		NOISE LEVEL	MAJOR	MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	IR	✓	P	W	V	
3.6		VIBRATION	MAJOR	MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	IR	✓	P	W	V	
3.7		APPEARANCE INCLUDING PAINT THICKNESS (DFT)	MAJOR	VISUAL & MEASUREMENT	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	IR/TC		P	V	V	As per Customer/ BHEL Req. (if any)
3.8		COMPLIANCE OF TECHNICAL REQUIREMENTS	MAJOR	--	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	COC		P	V	-	
3.9		COMPLETION OF DOCUMENTS	MAJOR	PHYSICAL	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	DOCUMEN TS	✓	P	V	-	
4.0	PACKING												
4.1		SOUNDNESS OF PACKING AGAINST TRANSIT DAMAGE	MAJOR	PHYSICAL	100%	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	ORDERING SPEC. / BHEL APPD. DRG. & DATA SHEET	INTERNAL RECORDS		P	-	-	

NOTE:1 - Welding to be done by qualified welder as per ASME IX WPS and PQR to be checked by inspecting agency.

Note 2: All pages of the inspection documents shall be numbered in chronology with the QAP clauses, duly mentioning the corresponding QAP clause no. at the top of each page.

Note 3: One 'index' page containing the document descriptions, their page no's & QAP cl no. shall be attached upfront the inspection documents.

Note 4: For any spares item, apart from 'visual inspection' the 'interchangeability fitment certificate' or 'material TC' are to be submitted, with specific mentioning of the 'pert no/ item no of the approved GA/ x-sec drg.'.

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