



Manufacturer Name and Address		MANUFACTURING QUALITY PLAN				APPLICABILITIES TO	
BHEL Haridwar accepted sub-contractors only	ITEM/EQUIPMENTS	HP OUTER CASING-EXHAUST END	Q.P. NO	QP/QA/254021	PROJECT		
			DATE	04.09.2025			
	W.O. NO.		REV. NO.	00	CONTRACTOR	BHEL (HEEP) HWR	
			PAGE NO.	Page 1 of 2	Indent	20250432 rev 00 dated 22.08.2025	

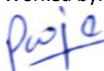

S. No.	COMPONENT OPERATION	CHARACTERISTIC CHECKED	CATEGORY	TYPE/METHOD OF CHECKED	QUANTITY OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	FORMAT OF RECORD	D	M	B	C	REMARK
1	2	3	4	5	6	7	8	9	10	11	12	13	14
1.0	Material Receiving Inspection at sub-contractor's work	Verification of identification of material	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	INPROCESS-INSPECTION												
2.1		Verification of machined dimensions & visual inspection after machining	Major	Measurement & visual	100%	As per drg./ Standard/ TDC	As per drg./ Standard/ TDC	Logsheet/ Observation sheet	✓	P	W	W	1.Dimensions, which are not covered in logsheet shall be recorded in observation sheet. 2. "W" as per logsheet by customer/ customer nominated inspection agency and rest random by BHEL/BHEL nominated agency.
2.2		Surface Finish of machined surfaces	Major	Measurement & visual	100%	As per drg./ Standard/ TDC	As per drg./ Standard/ TDC	Logsheet/ Observation sheet	✓	P	W	-	W- Random by BHEL/BHEL nominated agency.
3.0	FINAL-INSPECTION	check for cleanliness & completeness of Job, Documentation	Major	Visual	100%	As per drg./ Standard/TDC	As per drg./ Standard/TDC	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. & I.R.No
3.1		Preservation	Minor	Visual	100%	As per drg./ Standard/ TDC	As per drg./ Standard/ TDC	COC	✓	P	V	-	

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; CHP: Customer Hold Point (Work will not proceed unless the clearance from customer)	For BHEL Use	
		Worked by:  Pooja Singh, (QAX)	Approved by:  Braj Bhushan Tripathy, Sr.Manager (QAX)

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			DATE	04.09.2025		
	W.O. NO.	10886A11501	REV. NO.	00	CONTRACTOR	BHEL (HEEP) HWR
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3.2		Packing	Minor	Visual	100%	As per drg./ Standard/ TDC	As per drg./ Standard/ TDC	COC & Photo of packed item	✓	P	V	-	
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1. All requirements of P.O., standard and drawing shall be fulfilled.
2. BHEL reserves the right for conducting repeat test, if required.
3. During in process, BHEL job identification and customer seal is to be protected. Vendor to raise call for seal transfer, if required.

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