

QUALITY PLAN							Page 1 of 3					
BHEL	BHEL APPROVED SUB VENDOR NAME & ADDRESS:		DESCRIPTION OF ITEM			DRG. NO		PROJECT:				
			AIR EXHAUSTER WITH MOTOR (GSC AIR EXHAUSTER)			REV:						
			QP NO.: QP No: QA/BE/QP/307 Dated: 27.02.2025			SPEC:						
SL. NO.		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. RAW MATERIAL													
1.1	CASING, IMPELLER, BLADES & BASE FRAME/ PLATE	CHEMICAL COMPOSITION MECHANICAL PROPERTIES SIZE	MAJOR	CHEMICAL MECHANICAL MEASUREMENT	1 / HEAT 100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	MTC	✓	P	V	V	NABL TC shall be submitted
1.2	NUTS & BOLTS	TRADE MARK & PROPERTY CLASS	MAJOR	VISUAL	100%	As per vendor's Procedure	As per vendor's Procedure	IR	✓	P	V	-	
1.3	AC INDUCTION MOTOR (Please mention Make, degree of Protection and Rating).	ROUTINE & TYPE TESTS CERTIFICATE INCLUDING DEGREE OF PROTECTION	MAJOR	REVIEW	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	coc	✓	P	V	V	Customer Approved sources
2. INPROCESS INSPECTION													
2.1	CASING, MOTOR BRACKET, BASE FRAME & INLET CASING	QUALITY OF WELD	MAJOR	DPT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR	✓	P	V	-	NOTE:1
2.2	IMPELLER	DIMENSIONS DIMENSIONS AFTER MACHINING DYNAMIC BALANCING	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR IR TC	- - ✓	P P P	- - V	- - V	
2.3	ASSEMBLY OF FAN	INTERNAL CLEARANCES BETWEEN IMPELLER & CASING	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR	✓	P	V	V	
3.0 FINAL INSPECTION													
3.1	COUNTER FLANGE	PHYSICAL VERIFICATION	MAJOR	VISUAL	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	COC	✓	P	w	V	

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		ALL 'W' INDICATED IN COLUMN 'N' SHALL BE 'CHP' OF CUSTOMER		

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3.2	COMPLETE ASSEMBLY	OVERALL DIMENSIONS	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	
3.3		THICKNESS OF ZINC COATING OF IMPELLER	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR	✓	P	V	-	Thickness=
3.4		LEAKAGE TEST OF CASING & GASKET JOINTS AT DESIGN PRESURRE	MAJOR	LEAK TEST	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	Design Pressure=
3.5		PERFORMACE TEST (INCLUDING AIR DELIVERY, PRESSURE & POWER CONSUMPTION)	MAJOR	PERFORMANCE	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	
3.6		FAN SPEED	MAJOR	ELECTRICAL	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	
3.7		FAN SPEED, SMOOTH RUNNING & DIRECTION OF ROTATION	MAJOR	VISUAL	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR	✓	P	W	-	
3.8		NOISE LEVEL	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	Max=
3.9		VIBRATION	MAJOR	MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	Max=
3.10		APPEARANCE INCLUDING PAINT THICKNESS (DFT)	MAJOR	VISUAL & MEASUREMENT	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	TC	✓	P	W	V	Total DFT=
3.11		COMPLIANCE OF TECHNICAL REQUIREMENT	MAJOR	--	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	COC	✓	P	V	-	

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3.12		COMPLETION OF DOCUMENTS	MAJOR	PHYSICAL	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	DOCUMENTS		P	V	-	
4.0 PACKING													
4.1		SOUNDNESS OF PACKING AGAINST TRANSIT DAMAGE	MAJOR	PHYSICAL	100%	BHEL APPD. DRG. / SPEC. / DATA SHEET	BHEL APPD. DRG. / SPEC. / DATA SHEET	IR		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 instruments to be used for testing/ inspection shall have valid 'calibration certificates' to be verified by agencies/ manufacturer/contractor/TPIA.

Note 3: 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 4: One 'index' page containing the document descriptions, their page no's & QAP cl no. shall be attached upfront the inspection documents.

Note 5: Painting can be done only after inspection clearance, as per customer's /BHEL approved paint specification / schedule (if required). otherwise manufacturer's standard shall be followed.

Note 6: For any spares item, apart from 'visual inspection' the 'interchangeability fitment certificate' or 'material TC' are to be submitted, with specific mentioning of the ' part no/ item no of the approved GA/ x-sec Drg.".

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