 QUALITY ASSURANCE IVP- GOINDWAL		QUALITY PLAN FOR LAPPING & ASSEMBLY (FOR CAST CONVENTIONAL HAND OPERATED GATE VALVES OF 2" -6" 150 & 300 C)							QP No: QP:IVP:09 Rev.:00 Date: 13-12-2011 Page 1 of 1		
		Sl. No.	Operation	Characteristics	Check		Reference Doc./ Acceptance	Type of records		Agency	
Cl.	Type				Quantum	M		S	M	S	
1.1	Seat Ring Lapping	Surface Finish	B	Visual	20%	-	-	P	W		
1.2	Wedge Lapping	Surface Finish	B	Measurement	20%	Wedge Assembly Drawing	R	P	W		
1.3	Blue Matching	Proper Impression	A	Visual	100%	SIP:VS:21	R	P	W		Impression as per Annexure - I.
1.4	Valve Assembly	Compliance to PO/Drawing	A	Visual	100%	Valve Drawing	R	P	W		Refer Note - 3.
LEGEND:Cl:Class (A:Critical,B:Major,C:Minor)			Prepared By		Reviewed & Approved By:						
M: Vendor, S: BHEL/ Nominated Inspection Agency			Suneel		Suneel		13/12/11				
R: Dimension / Inspection Reports											
P: Perform, W: Witness											

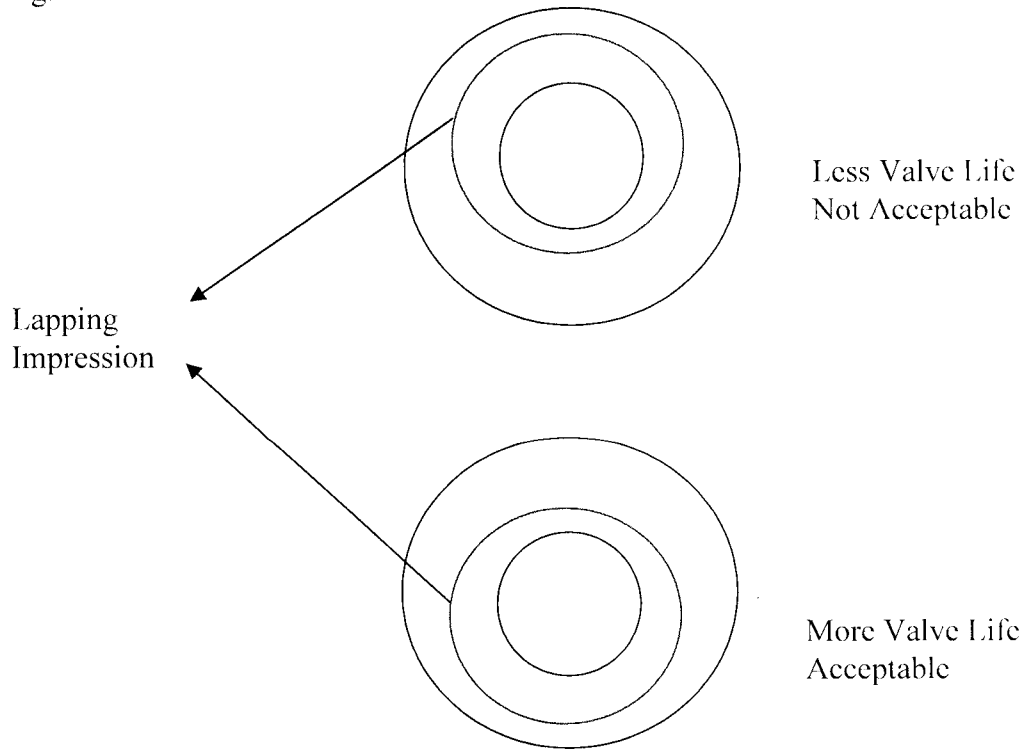
NOTE:- 1 Wherever special contract requirements are envisaged a separate TDC/CQP may be issued, special instructions may be provided through or stock material may be upgraded to special requirements.

NOTE:- 2 Machined/ Lapped surfaces should be placed/stacked on rubber sheet and should be protected from any damage.

NOTE:-3 Records of clearance for Wedge Lapping, Blue Matching. Proper placement of Lantern Ring. General fitting, Esthetic look etc. by BHEL to be produced during Final inspection.

Annexure – I to QP:IVP:09 Rev.:00 for Blue Matching Impression

After fitting lapped wedge in valve body, clear metal to metal contact is to be ensured as show in fig.



Acceptance Criteria: Impression should be preferably at bottom and must fall below the centre line.

Suneel Bansal
13/12/11

[Signature]
13/12/11