



Manufacturer Name and Address		MANUFACTURING QUALITY PLAN						APPLICABILITIES TO					
BHEL Haridwar accepted sub contractors		ITEM/EQUIPMENTS	Impeller						Q.P. NO	QP/QA/20230682		PROJECT	Kaleshwaram-1
		WORK ORDERS	20275T20201						DATE	28.12.2023		CONTRACTOR	BHEL (HEEP) HWR
									REV. NO.	00			
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S. No.	COMPONENT OPERATION	CHARACTERISTIC CHECKED	CATEGORY	TYPE/METHOD OF CHECKED	QUANTITY 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	INPROCESS-INSPECTION												
2.1	Dimensions after machining	Final dimension after machining and visual inspection	Major	Measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	
2.2		Surface roughness of machined surfaces	Major	Measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	
3.0	FINAL-INSPECTION												
3.1		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

1. All requirements of P.O., standard and drawing shall be fulfilled.
2. Preservation of machined surfaces to be done with grease or oil (as per indent).
3. BHEL reserves the right for conducting repeat test, if required.

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-Mfg.)	Approved by:  Sunil Pandey, Manager (QAX-Mfg.)