

08MANUFACTURER'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 &	08.03.2018								
							REV	04								
		DRG. NO.	AS PER PO													
		SPEC.	TG 60432													
		REV	04													
		CHARACTERISTICS		CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS		FORMAT OF RECORDS		AGENCY		REMARKS		
SL. NO.	COMPONENT & OPERATIONS											M	B	N		
1	2	3		4	5	6	7	8		9		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%	BHEL APPD DWG	BHEL APPD DWG	LAB TEST REOPRT	✓	P	V	-	NOTE: Chem & mech tests shall be carried out at independent lab on the samples identified by vendor & shall be witnessed by vendor
1.2	NUTS & BOLTS	TRADE MARK & PRPERTY CLASS	MAJOR	VISUAL	100%	IS:1367	AS PER VENDOR'S PROCEDURE	IR/COC	✓	P	V	-	
1.3	AC INDUCTION MOTOR	ROUTINE & TYPE TESTS CERTIFICATE INCLUDING DEGREE OF PROTECTION AND EXPLOSION PROOFNESS	MAJOR	REVIEW	100%	IEC:60034-1 IP 55 IEC:60079	IEC:60034-1 IP 55 IEC:60079	TC	✓	P	V	-	
2.0	INPROCESS INSPECTION												
2.1	ALL WELDS	QUALITY OF WELDS	MAJOR	DPT	100%	ORDERING SPECIFICATION	ASME VIII	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%	ISO:1940	ISO:1940 GR6.3	IR	✓	P	V	-	
2.3	ASSEMBLY OF FAN	INTERNAL CLEARANCE BETWEEN IMPELLER & CASING	MAJOR	MEASUREMENT	100%	BHEL APPD DWG	BHEL APPD DWG	IR	✓	P	V	-	
3.0	FINAL INSPECTION ON THE COMPLETE ASSEMBLY												
3.1		OVERALL DIMENSIONS	MAJOR	MEASUREMENT	100%	BHEL APPD DWG	BHEL APPD DWG	IR	✓	P	W	-	

		FOR CUSTOMER USE	
MANUFACTURER/ SUBCONTRACTOR	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		

Digitally signed
by PRITIKUMAR
RANJAN
Date:
2022.11.18
09:50:23 +05'30'

08MANUFACTURER'S NAME AND ADDRESS				STANDARD QUALITY PLAN					TO BE FILLED BY BHEL				TO BE FILLED BY BHEL			
VENDOR'S NAME		ITEM	VAPOUR EXHAUSTER		QP NO.	QA/BE/QP/306										
					DATED & REV	08.03.2018 04										
BHEL		DRG. NO.	AS PER PO													
		SPEC.	TG 60432													
		REV	04													
		CHARACTERISTICS			CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS		AGENCY		REMARKS		
SL. NO.	COMPONENT & OPERATIONS	3	4	5	6	7	8	9	D	M	B	N	11			
1	2															

3.2	PERFORMANCE (INCLUDING AIR DELIVERY, PRESSURE & POWER CONSUMPTION)	MAJOR	PERFORMANCE	100%	ISO:5801	TC	✓	P	W	-	
3.4	FAN SPEED, SMOOTH RUNNING, DIRECTION OF ROTATION	MAJOR	VISUAL	100%	ORDERING SPECIFICATION	IR	✓	P	W	-	
3.5	NOISE LEVEL	MAJOR	MEASUREMENT	100%	IEC:60034-9	IR	✓	P	W	-	
3.6	VIBRATION	MAJOR	MEASUREMENT	100%	IEC:60034-14	IR	✓	P	W	-	
3.7	APPEARANCE INCLUDING PAINT THICKNESS (DFT)	MAJOR	VISUAL & MEASUREMENT	100%	ORDERING SPECIFICATION	IR		P	-	-	
3.9	COMPLETION OF DOCUMENTS	MAJOR	PHYSICAL	100%	ORDERING SPECIFICATION/ BHEL APPD DWG/ QP/ PO	DOCUMENT TS	✓	P	V	-	
4.0	PACKING										
4.1	SOUNDNESS OF PACKING AGAINST TRANSIT DAMAGE	MAJOR	PHYSICAL	100%	ORDERING SPECIFICATION/ VENDOR'S STD	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.

Digitally signed
by PRITI KUMAR
RANJAN
Date: 2022.11.18
09:50:43 +05'30'

MANUFACTURER/ SUBCONTRACTOR	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	
			APPROVED BY	