





BHARAT HEAVY ELECTRICALS LIMITED SOLAR BUSINESS DIVISION PROF.C.N.R RAO CIRCLE, IISC POST MALLESHWARAM, BENGALURU-560012				STANDARD QUALITY ASSURANCE PLAN ITEM: 1.TOP COVER PLATE-3-982-10-13223 REV02 2.BOTTOM COVER PLATE- 3-982-10-13224 REV02				QP NO.: EPD_QP_IP_2020-21_0011 REV. NO.: 00 DATE: 27.03.2021 PAGE 2 OF 3					
BHEL-SBD		ITEM/ COMPONENT	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY		REMARKS	
SL. NO										M	B		
1.		2.	3.	4.	5.	6.	7.	8.	9.	**	10.	11.	
B	PRE DISPATCH INSPECTION AT VENDORS WORKS/ INSPECTION AT BHEL WORKS												
B.1	Top & Bottom Cover plate	Visual		Major	Physical	IS:2500 Ptl AQL 0.65%	IS 4759:1996, BHEL Drg./BHEL Spec	IS 4759:1996, BHEL Drg./BHEL Spec	Inspection Report	-	P / -	W/P	
B.2		Gauge Inspection (as applicable)		Major	Physical	IS:2500 Ptl AQL 0.65%	IS 4759:1996, BHEL Drg./BHEL Spec	IS 4759:1996, BHEL Drg./BHEL Spec	Inspection Report	-	P / -	W/P	
B.3		Dimensions		Major	Physical	2 per 1000 & part thereof			Inspection Report	-	P / -	W/P	
B.4		Mass/ Thickness of Zinc coating by Elcometer		Major	Physical	Min 3 per 1000 & part thereof	IS 4759:1996, BHEL Spec./ BHEL Drg.	IS 4759:1996, BHEL Spec./ BHEL Drg.	Inspection Report	-	P / -	W/P	610 g/m <sup>2</sup> Unless mentioned in BHEL Drg./ BHEL Spec
B.5		Uniformity of Zinc coating		Major	Chemical	Min 3 per 1000 & part thereof	IS 2633/ BHEL Spec	IS 2633/ BHEL Spec	Test Report	-	P / -	W/V	No permanent deposit of copper for 1 min each after 4 dips Unless mentioned in BHEL Drg./ BHEL Spec
B.6		Adhesion Test		Major	Mechanical	Min 5 per 5000 & part thereof	IS 2629 : 1985/BHEL Spec./ BHEL Drg.	No peel off	Inspection Report	-	P / -	W/P	

**Notes:**

1. Material supplied shall be in line with BHEL Purchase Order, Technical Specification, Approved Drawings, applicable Standard References, or any other document/references.
2. For first time supply by the vendor, sample approval to be obtained before bulk manufacturing from BHEL Quality/Engg.
3. The SQAP shall be read in conjunction with BHEL Specification mentioned in Purchase Order and shall deem to include any additional tests as per the specification/Standard.

<b>LEGEND:</b> *D: RECORDS, IDENTIFIED WITH "TICK" ( ✓ ) SHALL BE ESSENTIALLY INCLUDED BY VENDOR IN QA DOCUMENTATION.				FOR BHEL USE			
** M: MANUFACTURER/SUB-VENDOR, B: BHEL/BHEL NOMINATED INSPECTION AGENCY							
P: PERFORM W: WITNESS AND V: VERIFICATION.							
PREPARED BY: D K MUKHERJEE				APPROVED BY: ADITYA KUMAR MOURYA		QUALITY ASSURANCE	

 <b>BHEL-SBD</b>				<b>BHARAT HEAVY ELECTRICALS LIMITED</b> <b>SOLAR BUSINESS DIVISION</b> <b>PROF.C.N.R RAO CIRCLE, IISC POST</b> <b>MALLESHWARAM, BENGALURU-560012</b>				<b>STANDARD QUALITY ASSURANCE PLAN</b> <b>ITEM:</b> 1.TOP COVER PLATE-3-982-10-13223 REV02 2.BOTTOM COVER PLATE- 3-982-10-13224 REV02				<b>QP NO.: EPD_QP_IP_2020-21_0011</b> <b>REV. NO.: 00</b> <b>DATE: 27.03.2021</b> <b>PAGE 3 OF 3</b>			
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4. In case of any contradiction between this SQAP, BHEL Specifications the following precedence shall be followed:

1<sup>st</sup>: BHEL Purchase Order Specification;

2<sup>nd</sup>: This STANDARD QUALITY ASSURANCE PLAN & Applicable standard;


3<sup>rd</sup>: Manufacturers plant standards

5. Packing shall be as per BHEL purchase order.

6. **BHEL reserves the right for pre-dispatch inspection at vendor works by BHEL or BHEL nominated agency.**

7. In case of pre-dispatch inspection, vendor shall raise the inspection call in the online portal URL: [www.cqir.bhel.in](http://www.cqir.bhel.in) with inspection agency as BHEL SBD and shall upload Test Certificates, Internal inspection Report as per this SQAP in CQIR Portal. Final Pre dispatch inspection report must contain joint inspection report, internal inspection report & Test certificates duly signed by inspector.

8. Original Test Certificates, Internal Tests Report (Duly Sealed & signed) as per this SQAP shall be sent along with lot for review.

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