

QUALITY ASSURANCE PLAN

ITEM DESCRIPTION - HYDRAULIC BOLT TENSIONER CASE 1 TO CASE 6

P.O. No. :

Quality Plan No. : HCM/BT821102006/2021/01 Dt. 23/09/2020

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Date : 23/09/2020

SN	Component & operations	Characteristics	Class	Type of check	Quantum	Reference Document	Acceptance Norms	Format of Records	Agency			Remarks
1	2	3	4	5	6	7	8	9	P	W	R	11
1	Raw Material Test											
1.10	Raw Material Inspection for major parts listed in BOM of GA drawing & COC for rest item as per note 1.	Chemical Composition	Major	Chemical Composition	One Per Heat	BHEL Spec./Approved GA Drawing/Data sheet	As per Applicable Material Standard	Lab TC	2	1	1	In absence of original material TC, Test shall be carried out at NABL approved Lab
2	Final Assembly											
2.10	Dimension	Dimension Check	Major	Dimension Check	100%	BHEL Spec./Approved GA Drawing/Data sheet	BHEL Spec./Approved GA Drawing/Data sheet	Inspection report	-			
2.20	Load Test	As Per BHEL Approved Test Procedure		Elongation & Overload Check				Test report	2	1	-	
2.30	Visual	Visual Check		Visual Check	100%	NA	No Physical Damage	Inspection report	-			All accessories & assembly co-related with GA drg.

06/10/2020

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Prepared by: 
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QHC

Safety Deptt.

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Pressure Hose, Pressure Gauge, Hand Pump, Coupler/Fittings

3	Pressure Hose, Pressure Gauge, Hand Pump, Coupler/Fittings	Visual Check	Major	Visual Check	100%	Certificate of Conformance/ other documents by vendor	No Physical Damage, intactness of all items, No leakage during testing, No sluggish operation	Inspection report	2	1	-	
4												
4.10	BHEL	Shipping release	Major	Report	NA	NA	NA	All reports	1			

Shipping release

Vendor

Approved By

LEGEND:

P- Performed by
W- Witnessed by

R- Reviewed by

2- Supplier

1- BHEL/TPI
A

NOTE :

- 1) BOM items should be Catagorized as "A & B" in GA drawing. Catagory-A should be follows clause no.1.1 and catagory-B shall be complying with CERTIFICATE OF CONFORMANCE (COC).
- 2) The COC shall carry warranty of Two Year from the date of dispatch.
- 3) This QAP should be read along with specification, approved GA drawings & approved data sheet (latest revisions to be considered as per PO).
- 4) GA Drawing / datasheet shall prevail over quality plan for contradiction, if any.
- 5) Any projects/customer specific requirements, which shall be notified have to be fulfilled by the vendor at the time of execution of order.
- 6) Seaworthy packing if applicable shall be witnessed by BHEL/BHEL nominated inspection agency for overseas projects.
- 7) Consultant inspection agency if any shall be intimated during quality plan approval.
- 8) Test procedure of hydraulic bolt tensioner containing " Minimum elongation check on test stud at working load, test set up diagram, equipment use for testing, acceptance norms, stud elongation calculation based on BHEL provided data sheet.
- 9) Final commissioning will be done at BHEL, Bhopal for performance check.

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06/10/2020

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Safety Deptt.

Vendor Signature with Official Stamp