

Supplier LOGO			MANUFACTURING QUALITY PLAN							For Spec No.			
Manufacturer Name and address:			Item: Chain Pulley block with trolley			QP No		Project : BIFCL - MAITREE					
						Rev no		CLIENT : BHEL Ranipet					
			System : Material handling equipment (Manual)			Date		Order No.:					
						Pg No		Date:					
SI	Component Operation	Characteristics	Class	Type of check	Quantum of check	Reference doc	acceptance norms	Formats of record	E	Agency 11			Remarks
1	2	3	4	5	6	7	8	9	10	VE	M	B	12
A. Raw Material													
01	Gear pinion	Chemical	Major	Measure	Random	Appd drgs	EN 8/ EN 9	Lab rep/MTC	√	P	V	V	
02	Pawl/Ratchet	Chemical	Major	Measure	Random	Appd drgs	EN 8/ EN 9	Lab rep/MTC	√	P	V	V	
03	Load Chain	Callibration Proof load Brake load	Major	Visual	100%	Appd drgs	ISO 3077	Mfg/TC	√	P	V	V	
04	hand chain	Callibration	Major	Visual	Random	Roll on H. Wheel		IR/MTC	√	P	V	V	
05	Hook as per standard	Chemical Mechanical	Major	Mgg/TC	1 sample each lot	Appd drgs	IS 15560/BS 2903	Mfg/TC	√	P	V	V	
MANUFACTURER/SUB CONTRACTOR			LEGENDS: C OF C : CERTIFICATE OF CONFORMANCE VE : MANUFACTURER/SUB CONTRACTOR VENDOR B : NOMINATED INSPECTION AGENCY E : RECORD IDENTIFIED WITH √SHALL BE ESSENTIAL INCLUDED BY CONTRACTOR IN QUALITY DOCUMENTATION P : PERFORM										
Prepared by		reviewed by											
Name and Signature													
			INDICATE 'P' PERFORM, 'W' WITNESS AND 'V'V VERIFICATION AS APPROPRIATE						NAME AND SIGN OF APPROVING AUTHORITY AND SEAL				

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B. Process Control													
01	Gear cutting	Gear teeth	Major	Measure	Random	Appd drgs	Appd drgs			P	V	--	
02	Machining	Dimension	Major	Measure	Random	Appd drgs	Appd drgs			P	V	--	
03	Assembly	Assembly	Major	Visual	Random	Appd drgs	Appd drgs			P	V	--	
04	Hooks	Dimension Proof load	Major	Measure Load test	100%	Appd drgs	IS 15560/BS 2903	Mfg/TC	√	P	V	V	
C. Final Inspection													
01	load test		Major	150% SWL	100% & Capacity	Appd drgs	Appd drgs	Mfg/TC	√	P	W	W	
	Capacity/Lift		Major	Measure		Appd drgs	Appd drgs	Mfg/TC	√	P	W	W	
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02	Surface	Preparation	Major	Visual	100%	As per tender	Specification			P	--	--	
	Cleaning Protection	Painting	Major	Visual	100%	As per tender	Specification			P	V	V	
03	Identification Packing	Name Plate Stability	Major	Verification	100%	As per tender	As per tender			P	V	V	
			LEGENDS: C OF C : CERTIFICATE OF CONFORMANCE VE : MANUFACTURER/SUB CONTRACTOR VENDOR B : NOMINATED INSPECTION AGENCY E : RECORD IDENTIFIED WITH $\sqrt{\quad}$ SHALL BE ESSENTIAL INCLUDED BY CONTRACTOR IN QUALITY DOCUMENTATION P : PERFORM										
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