

TD -106 -1 Rev. No. 5 Form No.		PRODUCT STANDARD HYDERABAD		Prod. Std. No. GT14032
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<u>QUALITY INTERVENTIONS FOR CRITICAL ITEMS</u> 1.0 Description This standard specifies the quality interventions required for critical items in Gas Turbine. 2.0 Following are the Quality Interventions 1) Vendor to submit manufacturing Quality Plan (Inspection & Test Plan) prior to start of production for review, approval and mark-up of any hold/witness points by the purchaser. 2) Pre Inspection Meetings – final agreement of QC plans. 3) Approval of Sub-Vendors/requirement for copies of sub-orders. 4) Review of design documentation, drawings, calculations or procedures after award and before manufacture. 5) Resident inspection by Customer or Customer appointed Third Party Inspector during all stages of manufacture. 6) Independent inspection/design review by independent inspection authority. 7) Witnessing of specific stage QC hold points by CUSTOMER or CUSTOMER appointed TPI or specialist engineer as identified in the QC Plan. 8) Surveillance visits by BHEL at Vendor/Sub-Vendor's works to review ongoing inspection and test activities. Review of verifying records. 9) Witnessing of final performance/functional testing (Factory Acceptance Test) by CUSTOMER or CUSTOMER appointed TPI or specialist engineer as identified in the QC Plan. 10) Witnessing of final performance/functional testing (Site Acceptance Test) by CUSTOMER or CUSTOMER appointed TPI or specialist engineer, following installation at site. 11) Final inspection release by CUSTOMER or CUSTOMER appointed TPI including review of material certification, manufacturing, inspection and test records.				
Ref.Doc. None	Revisions : Refer to record of revisions :	Prepared : Saranya	Approved : KSN	Date : 24/02/2015

RESTRICTED USE



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	Rev. No.	Date	Revision Details	Revised	Approved	
	00	24.02.15	First Made	-	-	
	Ref. Doc					