




Annexure Q		
	Indent No:	Enquiry no:
Sl.No	BHEL / Customer Requirements	## Specific confirmations by the manufacturer (Acceptable/Not acceptable)
	Quality Plan Requirement: (If SQP is not given & Vendor QP applicable)	
	(i) MQP (Manufacturing Quality Plan) shall be submitted in attached format for BHEL/Customer review & approval. Our SQP/Typical MQP/ MQP Format is attached for guidance & use.	
	(ii) MQP shall invariably cover w.r.t Inward inspection including on Raw material Procurement, In process and Final inspection in elaborated way/details.	
	(iii) Bidder shall also to give specific confirmation that on need basis, their competent officials shall visit to BHEL / customer for finalization of Quality plan including test procedure/methodology during preaward / post award approval / detailed engineering in the event of an order.	
	(iv) No deviation on BHEL/Customer approved MQP/ SQP (In case BHEL SQP is provided) is acceptable.	
1	(v) Bidder shall agree to submit all cross referred documents other than codes/standards to BHEL/Customer/Consultant.	
	Important Notes shall be included in MQP : (a) Latest revision of Standard s & Specification shall apply. Only International Standards are applicable. (b) Materials shall be procured in compliance to Functional Technical Specification. (c) Inspection shall be in compliance with Approved Quality Control Procedure for the Product. (d) NDT shall be carried out by Qualified Personnel with compliance to Approved NDT Procedures and Acceptance Norms, as per ASME standard. (e) Gauges and measuring Instruments, with valid calibration only shall be used. (f) Cleaning and Painting of products shall be carried out as per Approved Painting Schedule. (g) Finished Products shall be packed to comply with Approved Packing Schedule. (h) Welding shall be carried out by Qualified Personnel with compliance to Approved NDT Procedures and Acceptance Norms, as per ASME standard.	
2	Domestic / Inland Inspection will be carried out by BHEL/BHEL appointed Third Party Inspection Agency (TPIA) / Customer/Customer Appointed Inspection Agency/Consultant. This is applicable for all Stage inspection and Final Inspection identified as "W" - Witness or "CHP" - Customer Hold Point as per customer approved Quality Plan/ Technical specification / Approved Drawing/ Approved Data sheet / Scheme / PID / PFD / SLD (Process Instrumentation Diagram / Process Flow Diagram / Single Line Diagram) etc. (as applicable).	
3	Inspection Agency for Foreign Bidders and also for Indian Bidder but importing from Foreign Sources: (1) Any one of the following Third Party Inspection Agency (TPIA) shall be appointed by the bidder and same shall be furnished by the bidder in techno commercial bid itself. (2) The details of TPIA with contact details like Name of the official, Phone no, Email id shall also to be submitted during pre/post award. However cost for such inspection agency shall be borne by the bidder only. Inspection charges for such inspection agency shall be indicated separately so that if BHEL/Customer is undertaking the inspection by on their own , then these charges are non claimable by the bidder. List of TPIA 1.M/s Bureau Veritas 2.M/s TUV-Nord 3.M/s TUV-SUD 4.M/s TUV Rheinland 5.M/s Lloyds Register 6.M/s SGS 7.M/s Germanischer Lloyds 8.M/s QUEST 9.M/s Certification Engineers International 10.M/s Intertek 11.M/s IR Class Systems and Solutions 12.M/s DNV 13. M/s Fichtner 14. M/s ABS Inspection Services	

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4	Stage Inspection during manufacturing Process : Stage Inspection during manufacturing shall be carried out as per approved quality plan and all necessary documents shall be provided for review, verification and clearance for further processing. This inspection call shall be given well in advance (at least 2 weeks before) to TPI/Bidder's own inspection agency to avoid delay in the manufacturing processes.	
5	Inspection before despatch for domestic supplier : Inspection before despatch at supplier's works shall be carried out by BHEL appointed Inspection agency (as in SI no. 2). Inspection shall be done as per approved Quality plan/ Technical specification/ Approved Drawing/ Approved Data sheet .	
6	Inspection at Foreign Source/Supplier: (a) As in sl no: 3. shall be ensured without fail (b) No material / items shall be despatched without getting the written communication from BHEL / Customer inspection carried out by Bidder appointed Third Party Inspection Agency (As per SI no.3) / Customer/Customer Appointed Inspection Agency/Consultant. This is applicable for all Stage inspection and Final Inspection identified as "W" - Witness or "CHP" - Customer Hold Point as per customer approved Quality Plan/ Technical specification / Approved Drawing/ Approved Data sheet / Scheme / PID / PFD / SLD (Process Instrumentation Diagram / Process Flow Diagram / Single Line Diagram) etc. (As applicable). Inspection before despatch for Foreign supplier : Inspection before despatch at supplier's works shall be carried out by bidder appointed inspection agencies having international presence at vendors and or vendor's sub vendor works. Inspection shall be done as per approved Quality plan/ Technical specification/ Approved Drawing/ Approved Data sheet by TPIA mentioned in SI no: 03 at supplier's cost.	
7	Painting shall be done strictly as per BHEL/Customer approved painting schedule / scheme only. Paint Thickness / Paint shade shall be ensured as per BHEL / Customer approved painting schedule / specification / data sheet etc. No deviation is acceptable unless otherwise accepted by BHEL/Customer in writing. Any conflict if any among BHEL / Customer approved painting schedule / Spec / data sheet etc. shall be brought to the notice of BHEL well in advance before proceeding including the BOI being procured for assy / skid like motors etc.	
8	Specific conformation for document package in the event of an order (2 Hard copies & soft copy in PDF file) is to be given containing the following with proper linkages (i) Index Sheet (ii) MOP/RQP/Endorsement Sheet (As applicable) (iii) TCs identified by BHEL/ Customer for record for "CHP" / "W" and Verification portion ("V") as given in approved OP. (iv) Final inspection report + TC including Chemical + Mechanical + HT + NDT etc. (v) Third party Inspection report + TC (vi) Customer CHP/ MDCC (vii) Type test / Performance Test reports conducted (viii) Type test / Performance Test approval/ clearance obtained from BHEL/Customer (ix) BOM with As Build Drgs with actual make / rating used with BHEL/customer approved drawings.	
9	Packing / Seaworthy Packing shall be as per BHEL Packing schedule / approved drg / sketch. This shall be ensured to take care transit / handling / transhipment in Road / Sea / Air. Photographs are to be submitted for BHEL review before despatching the material as per contract conditions.	
10	Outsourcing of test facilities: Bidder shall ensure all the testing facilities in house. However If any of the test facilities are not available with successful bidder, then bidder shall ensure the same at NABL accredited third party lab / Govt / Govt Lab for major testing such as NDT, Electrical & Mechanical testing.	
11	Important Note: No deviation on the above requirement 01 to 10 is acceptable with respect to Quality Requirement and those offers not meeting these specific customer requirement is liable for rejection and hence the bidder shall submit all the required documentary evidences in the offer itself.	
12	## Necessarily to be filled up by the bidder at the time of offer itself otherwise the offer may not be considered w.r.t Quality Requirement being customer specific requirement.	
VENDOR SIGN AND STAMP:		Vendor Name & Address:

 Ranipet		MANUFACTURER'S NAME & ADDRESS BHEL/ BHEL APPROVED SOURCE		STANDARD QUALITY PLAN				PROJECT: AS PER PO.						
				ITEM: FABRIC FOR NON METALLIC EXPANSION JOINT		QP NO: FAN: 397 Rev No. : 00 Date: 06.12.2021 Page 1 of 2								
SL NO	COMPONENT & OPERATION	CHARACTERISTICS	CLASS OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		Agency			REMARKS
					6						M	B	C	
1	2	3	4	5	M	B/C	7	8	9	D	10		11	

1.0 RAW MATERIALS														
1.1	Fabric Layers (All the layers separately)	Weight, Thickness,	Major	Physical	10% of the offered lot		Approved Drawing / Data sheet / Purchase Order	Report	√	P	V	-		
1.2		Tensile Strength (Warp & Weft)	Major	Mechanical Test	One per heat / batch / size		Approved Drawing / Data sheet / Purchase Order	Report	√	P	V	-		
2.0 IN PROCESS CONTROL														
2.1	Fabric Cutting	Length, Width	Minor	Measurement	100%	-	Manufacturer Drawing / Approved Drawing / Data Sheet / Purchase Order	Report		P	-	-		
3.0 FINAL INSPECTION														
3.1	Finished Fabric Bellow	Dimension and Finish	Major	Visual & Dimension	100%	100%	Approved Drawing / Data sheet / Purchase Order	Report	√	P	W	-		
4.0 PAINTING, MARKING, PACKING AND PRESERVATION														
4.1	Finished Fabric - Packing, Marking & preservation	Verification of identification marking and packing	Major	Visual	100%	100%	Purchase Order Specification / Approved drawing / Data Sheet	Report	√	P	V	-		

M - Manufacturer / Subcontractor, B - BHEL /BHEL Authorized Inspection Agency, C - Customer, P - perform, V - Verification of reports W - Witness, TC - Test certificate "D" - Record, identified with tick (√) shall be essentially included by Supplier in QA documentation. RT- Radiographic Test. DP - Dye penetrant testing UT - Ultrasonic Testing	Prepared & Reviewed by		Approved by	
	 ABDUL GHANI / SR. ENGR (QA)		 RENJITH K / MANAGER (QA)	



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					M	B/C			M	B		
1	2	3	4	5	M	B/C	7	8	9	D	10	11

Notes:

1. Latest version of standards & specifications shall be applied.
2. All the critical drawings and dimensions of items shall be checked for dimensional conformity.
3. Materials shall be procured in compliance to Functional Technical Specification.
4. Quantum of check for BHEL and supplier shall be 100%. Acceptance norms for material & dimensional inspection shall be according to BHEL drawing / data sheet.
5. Gauges and instruments with valid calibration only shall be used.
6. Inspection / Inspection waiver / approval by BHEL does not absolve Supplier's responsibility for conformity of the specification as per the terms of PO.
7. BHEL /BHEL Authorized representatives shall have the right to witness the necessary inspection and testing of goods mentioned in the PO.
8. This QP Shall be read along with relevant PO, BHEL Specification/Drawing.
9. Inspection stage / type of check / quantum of check may change in case of project / customer specific requirements (if applicable)

RECORD OF REVISION

REV NO	DATE	DESCRIPTION
00	06.12.2021	Original Issue – First submission

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