

		MANUFACTURER'S NAME & Address		MANUFACTURING QUALITY PLAN							CONTRACT & PACKAGE			
BHEL Ranipet		Approved Vendors.		ITEM: REFLEX COUPLING							STANDARD QUALITY PLAN			
				OP NO: SQP.FAN:373							CONTRACTOR : M/s BHEL, RANIPET			
				REV NO: 01										
				DATE: 05.02.13										
				PAGE NO: 1 of 3										
SL No	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE STANDARD	FORMAT OF RECORDS.	AGENCY			REMARKS		
								M	C	B				
1	2	3	4	5	6	7	8	9	D+	10++	11			
1.0	MATERIAL													
1.1	RAW MATERIAL													
1.1.1	SHAFT TUBE	CHEMISTRY&MECHANICAL	MAJOR	CHEM& TENSILE,	MELTWISE	Respective Material spec.	APPROVED Drawing	TC		P	V	V		
1.1.2	PLATES	-DO-	MAJOR	-DO-	-DO-	-DO-	-DO-	TC		P	V	V		
1.1.3	HUB PLATE	-DO-	MAJOR	-DO-	-DO-	-DO-	-DO-	TC		P	V	V		
1.1.4	HUB CORE	CHEMISTRY&MECHANICAL PROPERTIES&SOUNDNESS	MAJOR	CHEM& TENSILE&UT	-DO-	-DO-	INDICATION EQUIVALENT REFLECTOR SIZE OF 3MM OR LOWER ARE ONLY ACCEPTABLE	TC		P	V	V		
1.1.5	DRIVE DISC	CHEMISTRY&MECHANICAL PROPERTIES	MAJOR	CHEM& Tensile	-DO-	-DO-	APPROVED DRG	TC		P	V	V		
1.1.6	INTERMEDIATE COUPLING FLANGE	-DO-	MAJOR	-DO-	-DO-	-DO-	-DO-	TC		P	V	V		
LEGENDS:														
M-MANUFACTURER/SUB CONTRACTOR-C-CUSTOMER							PREPARED BY			REVIEWED & APPROVED BY				
B-BHEL/TPA : P-PERFORM W-WITNESS & V-VERIFICATION							R. RA			G. Sman				
REP REPORT							RARUNACHALAM			GBALASUBRAMANIAN				

 MANUFACTURER'S NAME & Address		MANUFACTURING QUALITY PLAN				CONTRACT & PACKAGE					
BHEL Ranipet		APPROVED VENDORS				ITEM: REGIFLEX COUPLING					
						OP NO: SOP-FAN:373 REV NO: 01 DATE: 05 02 13					
						PAGE NO: 3 of 3					
SL No	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE STANDARD	FORMAT OF RECORDS	AGENCY	REMARKS	
1	2	3	4	5	6	7	8	9	D+	10++	11
2.2	MACHINING										
	INTERMEDIATE SHAFT DRIVE FLANGE & COUPLING										
2.2.1		DIMENSIONS	MAJOR	MEASUREMENT	100%	DRAWING		REP	P	V	V
2.3	DYNAMIC BALANCING										
2.3.1	COUPLING HUBS	UNBALANCE COMPENSATION	MAJOR	RESIDUAL UNBALANCE	100%	ISO 1940	ISO 1940 G 2.5	REP	P	W	W
2.3.2	INTERMEDIATE SHAFT										
3	Final Inspection.										
3.1.1	REGIFLEX COUPLING ASSY										
	IDENTIFICATION PAINTING PRESERVATION	DIMENSIONS	MAJOR	MESUREMENT	100%	DRAWING	DRAWING	REP	P	W	W
3.1.2		COMPLIANCE TO COMPANY STANDARD	MAJOR	VISUAL	100%						
01	05 02 13										
00	18 07 09										
Based on the CQ/Chemical team feed back on 02022013 clause 2.3.1 & 2.3.2 verification stage revised as witness.											
ORIGINAL ISSUE											
DESCRIPTION											
PREPARED BY											
REVIEWED & APPROVED BY QA											
M-MANUFACTURER/SUB CONTRACTOR/C-CUSTOMER B. BHEL/TPA. P-PERFORM.W-WITNESS & V-VERIFICATION REP-REPORT											
R. ARUNACHALAM											
G.BALASUBRAMANIAN											

 MANUFACTURER'S NAME BHEL & Address		MANUFACTURING QUALITY PLAN				CONTRACT & PACKAGE			
APPROVED VENDORS		ITEM: RECIFELEX COUPLING				STANDARD QUALITY PLAN			
OP NO: SOP-FAN373 REV NO: 01 DATE: 05.02.13		PAGE NO. 2 of 3				CONTRACTOR: M/s BHEL, RANIPET			
SL No COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE STANDARD	FORMAT OF RECORDS	AGENCY M C B	REMARKS
1	2	3	4	5	6	7	8	9	10
1.2	SUB DELIVERIES								
1.2	SPRING ELEMENTS, FIT BOLTS & NUTS	COMPLIANCE TO P.O	MAJOR	VERIFICATION	100%	PURCHASE ORDER	PURCHASE ORDER	TC	P V V
1.2.1	INPROCESS INSPECTION								
2.0									
2.1	WELDING**								
2.1.1	INTERMEDIATE SHAFT WELDING		MAJOR	VISUAL	100%		DRAWING **	REP	P V V
		WELD SIZE							
		WELD SOUNDNESS	MAJOR	MT/PT	100%	VENDOR PRACTICE	VENDOR PRACTICE #	NDT REP	P V V
LEGENDS							PREPARED BY		
M-MANUFACTURER/SUB CONTRACTOR-C-CUSTOMER IB-BHEL/TPA-P-PERFORM-W-WITNESS & V-VERIFICATION REP-REPORT							R.RUDNAGHALAM		
REVIEWED & APPROVED BY QA							G.BALASUBRAMANIAN		

**WELDERS AND PROCEDURES ARE QUALIFIED AS PER ASME SEC IX
LINEAR INDICATIONS ARE UNACCEPTABLE