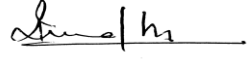


 Ranipet		MANUFACTURER'S NAME & ADDRESS BHEL/ BHEL APPROVED SOURCE		STANDARD QUALITY PLAN				PROJECT: AS PER PO.						
				ITEM: NON-METALLIC EXPANSION JOINT		QP. NO.: NMEJ:738 Rev No. :00 Date: 07.03.2020 Page 1 of 2								
SL NO	COMPONENT & OPERATION	CHARACTERISTICS	CLASS OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK 6		REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		Agency		REMAR KS	
					M	B/C					M	B	C	
1	2	3	4	5	M	B/C	7	8	9	D	10		11	

1.0	RAW MATERIAL													
1.1	Raw Material (Steel IS2062 E250)	Chemical Composition & Mech. Properties	Major	Review of MTC	One Sample per Heat	One Sample per Heat	Drawing /BHEL Spec/PO	MTC/ Lab. TC	√	V	V	-	Raw Materials shall be as per Approved Drawing.	
2.0	INPROCESS INSPECTION													
2.1	Fabric Layer	Weight	Minor	Measurement	Random Samples (10% of offered LOT)	Approved Drawing / Datasheet	TC	√	P	V	-	-		
2.2		Thickness	Major	Physical		Approved Drawing / Datasheet	TC	√	P	V	-	-		
2.3		Tensile strength	Major	Mechanical Test	One per Heat/Batch/Size	Approved Drawing / Datasheet	TC	√	P	V	-	-		
2.4		Air Permeability	Major	Leak Test		Approved Drawing / Datasheet	TC	√	P	V	-	-		
2.5		Temperature with stand ability test	Major	Temperature with stand ability test		Approved Drawing / Datasheet	TC	√	P	V	-	-		
2.6		Flexibility	Major	Fatigue Test		Approved Drawing / Datasheet/Manufacturer Plant procedure	TC	√	P	V	-	-		
3.0	FINAL INSPECTION													
3.1	Assembled Expansion Joints.	Dimension & Finish	Major	Visual & Dimensional	100%	100%	As per Approved Drawing / Specification/Datasheet	Inspection Report	√	P	W	-	-	
3.2	Packing, Painting & Preservation	Verification of Identification marking & Preservations.	Minor	Verification	100%	100%	As per P.O Drawing/Specification	COC	√	P	V	-	-	

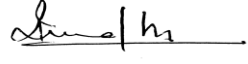
M – Manufacturer / Subcontractor, B - BHEL /BHEL Authorized Inspection Agency, C - Customer, P - perform, V - Verification of reports, COC – Certificate of compliance. W - Witness, TC - Test certificate "D" – Record, identified with tick (√) shall be essentially included by Supplier in QA documentation. NMEJ- Non-Metallic Expansion Joint.	Prepared by	Reviewed by	Approved by
	 Sanjib Pandit (AE/QA)	 Rakesh Kumar Madhu (Dy Manager / QA)	 K C Gandhiparimalam (DGM/QA)

 बी एच ई एल Ranipet		MANUFACTURER'S NAME & ADDRESS BHEL/ BHEL APPROVED SOURCE		STANDARD QUALITY PLAN				PROJECT: AS PER PO.				
				ITEM: NON-METALLIC EXPANSION JOINT		QP. NO.: NMEJ:738 Rev No. :00 Date: 07.03.2020 Page 2 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
1	2	3	4	5	6		7	8	9	D	10	11

- Note: 1. Latest version of standards & Specification shall be applied.
2. All the critical Drawing & Dimension 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 approved Drawing / Data sheet.
5. Gauges and measuring 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. In case of Vendor Drawing, it needs approval by BHEL Engineering.
9. This QP is applicable for Mandatory spare also as applicable.
10. This QP shall be read along with relevant PO, Approved drawing/Specification/Approved datasheet as applicable.
11. Loose Items/Items minor in nature, which are not covered under this QP.Manufacture COC/TC Shall, be reviewed by Inspection agency.

Record of revision

Rev no	Date	Description
00	07.03.2020	Original Issue (First Submission)

M – Manufacturer / Subcontractor, B - BHEL /BHEL Authorized Inspection Agency, C - Customer, P - perform, V - Verification of reports, COC – Certificate of compliance. W - Witness, TC - Test certificate “D” – Record, identified with tick (✓) shall be essentially included by Supplier in QA documentation. NMEJ- Non-Metallic Expansion Joint.	Prepared by	Reviewed by	Approved by
	 Sanjib Pandit (AE/QA)	 Rakesh Kumar Madhu (Dy Manager / QA)	 K C Gandhiparimalam (DGM/QA)