

		MANUFACTURER'S NAME & ADDRESS: BHEL (BAP) - Ranipet Approved Suppliers		MANUFACTURING QUALITY PLAN PRODUCT: Thinner (for Epoxy Paints, Inorganic Ethyl Zinc Silicate Paints & Aliphatic Paints : Application as per BHEL PO)				MQP NO: TNR:GP REV NO: 00 DATE: 06/08/2020 PAGE: 1 OF 1					
												SUB-SYSTEM : ---	
				SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS					TYPE OF CHECK	QUANTUM OF CHECK
1	2	3	4	5	6	7	8	9	D**	M	C	N	11

1.0 RAW MATERIALS:													
1.1	Solvents & additives	Composition	B	Review	Supplier's Procedure	Supplier's Procedure & BHEL PO	TC	-	V	-	-		
2.0 INPROCESS CONTROLS:													
2.1	Manufacturing	Proper mixing of Solvents & Additives	A	Measure	Supplier's Procedure		Log	-	P	-	-		
3.0 FINAL INSPECTION & TESTING (Refer Notes 1, 2 & 3):													
3.1	Finished Thinner	Colour / Appearance#	A	Visual	Supplier's Procedure & IS 82: 1973 (Reaffirmed: 2017)	Supplier's Procedure & IS 82: 1973 (Reaffirmed: 2017)	Supplier's Procedure & BHEL PO	TC	√	P	W	-	#Clear, transparent, free from sediments & suspended matter
3.2		Specific Gravity (g/ml)	B	Measure				TC	√	P	W	-	
3.3		Flash Point	A	Measure				TC	√	P	W	-	
3.4		Compatibility with various types of paints#	A	Visual				TC	√	P	W	-	#Types: Epoxy, Ethyl Zinc Silicate, Aliphatic
3.5		Sulphur, percent by mas	B	Measure				TC	√	P	V	-	
3.6		Distillation Test	B	Measure				TC	√	P	V	-	
3.7		Copper Strip Corrosion	B	Visual				TC	√	P	V	-	
3.8		Residue on evaporation	B	Visual & Measure				TC	√	P	W	-	
4.0 MARKING, PACKING & CERTIFICATION:													
4.1	Identification & Packing	Stenciling & Packing	B	Visual	Supplier's Procedure & BHEL PO		TC	√	P	V	-		
4.2	Certification	Compatibility & Compliance	A	Review	Supplier's Procedure & BHEL PO		TC	√	P	V	-		

Record of Revisions

Rev No	Date	Clauses revised	Description of Revision
00	06/08/2020	--	Original Issue.

Notes:

1. Latest editions / versions of the referred standards shall be used.
2. Sample selection for testing to be done in the presence of BHEL / BHEL AIA.
3. Apart from above indicated tests, any other requirement(s) specified in BHEL PO shall be complied with by the supplier.

 06/08/2020		 06/08/2020		LEGEND: * RECORDS IDENTIFIED WITH "TICK" (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER, C: BHEL / BHEL AIA, N: CUSTOMER; P: PERFORM, W: WITNESS, V: VERIFICATION; CLASS: A - CRITICAL; B - MAJOR; C - MINOR; MTC: MILL /MANUFACTURER'S TEST CERTIFICATE; IR- INSPECTION REPORT.
PREPARED BY		REVIEWED & APPROVED BY		
K.S. GOPAKUMAR, DE/QA		VENKANNA RUPANI, DM/QA		
SIGNATURE & SEAL				