

	MANUFACTURER'S NAME & ADDRESS:		MANUFACTURING QUALITY PLAN					MQP NO: TNR:SLV REV NO: 01			
	BHEL (BAP) - Ranipet Approved Suppliers		PRODUCT: Thinner (Petroleum Hydrocarbon Solvents) to IS 1745 : 2018 (Grade as per BHEL PO)					DATE: 22/07/2020 PAGE: 1 OF 1			
			SUB-SYSTEM : ---								

SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY			REMARKS
										M	C	N	
1	2	3	4	5	6	7	8	9	D**	**	10	11	

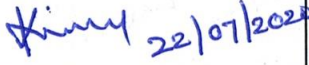
1.0	RAW MATERIALS:												
1.1	Solvents & additives	Composition	M	Review	IS 1745	IS 1745	IS 1745 & BHEL PO	TC	-	V	-	-	
2.0	INPROCESS CONTROLS:												
2.1	Manufacturing	Proper mixing of Solvents & Additives	A	Measure	IS 1745	Supplier's Procedure and IS 1745		Log	-	P	-	-	
3.0	FINAL INSPECTION & TESTING (Refer Notes 1, 2 & 3):												
3.1	Finished Paint	Colour	A	Visual	IS 1745 / IS 1447	IS 1745 / IS 1448	IS 1745 & BHEL PO	TC	√	P	W	-	
3.2		Density (g/ml)	M	Measure			IS 1745	TC	√	P	V	-	
3.3		Flash Point	A	Measure			IS 1745	TC	√	P	W	-	
3.4		Distillation Range	A	Measure			IS 1745 & BHEL PO	TC	√	P	W	-	
3.5		Aromatic Content	A	Measure			IS 1745	TC	√	P	V	-	
3.6		Sulphur, percent by mass, max	A	Measure			IS 1745	TC	√	P	V	-	
3.7		Copper Strip Corrosion	A	Visual			IS 1745 & BHEL PO	TC	√	P	V	-	
3.8		Residue on evaporation	A	Visual & Measure			IS 1745 & BHEL PO	TC	√	P	W	-	
4.0	MARKING, PACKING & CERTIFICATION:												
4.1	Identification & Packing	Stenciling & Packing	M	Visual	IS 1745	IS 1745	IS 1745 & BHEL PO	TC	√	P	V	-	
4.2	Certification	Grade & Compliance	A	Review	IS 1745	IS 1745	IS 1745 & BHEL PO	TC	√	P	V	-	

Record of Revisions

Rev No	Date	Clauses revised	Description of Revision
00	19/08/2015	--	Original Issue.
01	22/07/2020	All	QP No changed from QP:Thinner:1745 to TNR:SLV. MQP Completely reorganized and revised.

Notes:

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

		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		