

		STANDARD MANUFACTURING QUALITY PLAN						MQP. NO.: PESD/QA/MP/0020					
								REV NO: 00		DATE: 24.09.2017			
		PROJECT ENGINEERING & SYSTEMS DIVISION BHEL, RC PURAM, HYD-502032			PRODUCT: FASTENERS BHEL SPEC : REFER PO			PAGE 1 OF 2					
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY			REMARKS
										P	W	V	

1.0	BOUGHT OUT ITEMS												
1.1	FASTENERS	Material batch identification, dimensions and GO & NO-GO check	Major	Visual, dimensional, GO & NO-GO check	Sampling plan IS 1367 : Part 17 (AQL=1, LQ10 = 12, sample size = 32, Ac = 1)	BHEL specification or IS Standard IS 1367 : Part 17	BHEL specification or IS Standard IS 1367 : Part 17	MTC and inspection reports	√	2	2	--	Inspection shall be carried out by main supplier.
2.0	FINAL INSPECTION & TESTING												
2.1	FASTENERS	Visual, Dimensions, GO & NO-GO check	Major	Visual, dimensional, GO & NO-GO check	Sampling plan IS 1367 : Part 17 (AQL=0.65, LQ10 = 25, sample size = 8, Ac = 0)	BHEL Specification /BOQ/ IS Standard	BHEL Specification /BOQ/ IS Standard	Inspection reports	√	2	1	--	
2.2		Chemical & Mechanical Properties and Heat Treatment (heat treatment if applicable)	Major	TC Review	One sample per Lot			MTC	√	2	--	1	

LEGEND: P: PERFORM, W: WITNESS, V: TC REVIEW. INDICATE 1 FOR BHEL CQS /BHEL NOMINATED INSPECTION AGENCY/END USER & 2 FOR VENDOR/SUB VENDOR AS APPROPRIATE AGAINST EACH COMPONENT /CHARACTERISTIC UNDER P, W & V COLUMNS. * FOR ITEMS MARKED ✓ (TICK) IN COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.	APPROVED BY ASHWINI KUMAR NAYAK		APPROVED BY -NA-
	BHEL QA SIGNATURE & STAMP		CUSTOMER'S SIGNATURE & STAMP (if applicable)

		STANDARD MANUFACTURING QUALITY PLAN						MQP. NO.: PESD/QA/MP/0020					
								REV NO: 00		DATE: 24.09.2017			
		PROJECT ENGINEERING & SYSTEMS DIVISION BHEL, RC PURAM, HYD-502032				PRODUCT: FASTENERS BHEL SPEC : REFER PO			PAGE 2 OF 2				
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY			REMARKS
										P	W	V	
2.4		PMI#	Major	PMI test	Random			IR/TC	√	2	1	1	# If applicable 10 sets shall be witnessed randomly by "1"
2.5		BOM Check	Major	Visual	100%			Inspection reports	√	2	1	--	
3.0 PRESERVATION & PACKING													
3.1	FASTENERS	Packing and markings	Major	Visual	Random	BHEL Specification	BHEL Specification	Packing List	√	2	--	1	

Notes:-

1. This Standard MQP should be read along with specification (Latest revision as per PO), approved drawings & approved datasheet.
2. Drawing/datasheet shall prevail over quality plan for contradiction if any.
3. Any project/customer specific requirements which shall be notified have to be fulfilled by the vendor at the time of execution of order.

Abbreviations:-

MTC - Material Test certificate
 NDE - Non Destructive Examination
 PMI - Positive Material Identification
 SS - Stainless Steel
 IR - Inspection Report

TC - Test Certificate
 CS - Carbon Steel

LEGEND: P: PERFORM, W: WITNESS, V: TC REVIEW. INDICATE 1 FOR BHEL CQS /BHEL NOMINATED INSPECTION AGENCY/END USER & 2 FOR VENDOR/SUB VENDOR AS APPROPRIATE AGAINST EACH COMPONENT /CHARACTERISTIC UNDER P, W & V COLUMNS. * FOR ITEMS MARKED ✓ (TICK) IN COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.	APPROVED BY ASHWINI KUMAR NAYAK  BHEL QA SIGNATURE & STAMP	APPROVED BY -NA- CUSTOMER'S SIGNATURE & STAMP (if applicable)
--	---	--