

VENDOR'S NAME & ADDRESS:		STANDARD MANUFACTURING QUALITY PLAN							QP. NO.:SQAP/				
		CUSTOMER: BHEL, HYDERABAD – 32.				BHEL P.O.NO.:			REV NO: 00		DATE:		
		PROJECT: PRODUCT: MVWS NOZZLE SPARY				P.O.DATE:			PAGE 1 OF 2				
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY P W V			REMARKS
1.0		RAW MATERIALS & BOUGHT OUT ITEMS											
	HOUSING (BRASS)	CHEMICAL	MAJOR	CHEM. ANALYSIS	ONE PER HEAT OR BATCH	AS PER APPROVED DRG/TDS//SPEC.	AS PER APPROVED DRG/TDS//SPEC.	Lab./Mfg. TC	√	2	-	1	
		DIMENSION	MAJOR	MEASUREMENT	ONE PER HEAT OR BATCH	AS PER APPROVED DRG/TDS//SPEC.	AS PER APPROVED DRG/TDS//SPEC.	IR	-	2		1	
		SURFACE DEFECTS	MINOR	VISUAL	100%	SURFACE FREE FROM DEFECTS	SURFACE FREE FROM DEFECTS	IR	-	2		1	
	DEFLECTOR	MECH. & CHEMICAL	MAJOR	MECH & CHEM. ANALYSIS	ONE PER HEAT OR BATCH	AS PER APPROVED DRG/TDS//SPEC.	AS PER APPROVED DRG/TDS//SPEC.	Lab./Mfg. TC	√	2	-	1	
	DEFLECTOR PIN	MECH. & CHEMICAL	MAJOR	MECH & CHEM. ANALYSIS	ONE PER HEAT OR BATCH	AS PER APPROVED DRG/TDS//SPEC.	AS PER APPROVED DRG/TDS//SPEC.	Lab./Mfg. TC	√	2	-	1	
2.0		INPROCESS INSPECTION											
	HOUSING	MECH. & DIMENSION CHECK	MAJOR	MEASUREMENT & GAUGE CHECK	100%	AS PER APPROVED DRG.	AS PER APPROVED DRG.	IR	-	2		1	
	DEFLECTOR & DEFLECTOR PIN	DIMENSION CHECK	MAJOR	MEASUREMENT & GAUGE CHECK	100%	ASS PER APPROVED DRG.	AS PER APPROVED DRG.	IR	-	2		1	
	ASSY	FITMENT & ASSEMBLY CHECK	MAJOR	VISUAL	100%	AS PER APPROVED DRG.	AS PER APPROVED DRG.	IR	-	2		1	
LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL CQS (OR BHEL NOMINATED INSPECTION AGENCY) & 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.					PREPARED BY VENDOR'S SIGNATURE & STAMP		APPROVED BY BHEL QA SIGNATURE & STAMP		APPROVED BY CUSTOMER'S SIGNATURE & STAMP				

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		CLEANING & FLOW TESTING	MAJOR	FLOW TEST	100%	AS PER APPROVED DRG.	AS PER APPROVED DRG.	IR	-	2	2	1	
3.0	FINAL INSPECTION & TESTING												
	MVWS NOZZLE (Complete Assy)	PHYSICAL OBSERVATION & DIMN. CHECK	MAJOR	VISUAL & MEASURE MENT	100% for 2, 10% for 1	AS PER APPROVED DRG/TDS//S PEC.	AS PER APPROVED DRG/TDS//SP EC.	IR	√	2	1	-	
		PERFORMANCE (FLOW,SPRAY ANGLE,SPRAY PATTERN TEST)	CRITIC AL	FLOW TEST	100% for 2, 10% for 1	AS PER APPROVED DRG/TDS//S PEC.	AS PER APPROVED DRG/TDS//SP EC.	IR / TC	√	2	1	-	
		MARKING & FINISH	MAJOR	VISUAL	100% for 2, 10% for 1	AS PER APPROVED DRG/TDS//S PEC.	AS PER APPROVED DRG/TDS//SP EC.	IR	√	2	1	-	
4.0	PRESERVATION & PACKING												
	MVWS NOZZLE ASSY	PROPERLY PACKING WITH NECESSARY MARKING	MAJOR	VISUAL	100%	AS PER APPROVED DRG/TDS//S PEC.	AS PER APPROVED DRG/TDS//SP EC.	PACKING NOTE	-	2		1	
		PRESERVATION MUST BE MAINTAINED IN PROPER PLACE	MAJOR	VISUAL	100%	AS PER APPROVED DRG/TDS//S PEC.	AS PER APPROVED DRG/TDS//SP EC.	PACKING NOTE	-	2		1	

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	VENDOR'S SIGNATURE & STAMP	BHEL QA SIGNATURE & STAMP	CUSTOMER'S SIGNATURE & STAMP