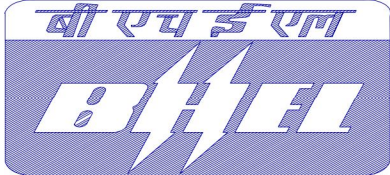
 PROJECT ENGINEERING & SYSTEM DIVISION		STANDARD MANUFACTURING QUALITY PLAN							QP. NO.:PESD/QA/ GASKET/01/18-19					
		PRODUCT: GASKET				BHEL SPEC: AS PER P.O			REV NO: 00		DATE: 22-02-2019			
									PAGE 1 OF 2					
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY			REMARKS	
										P	W	V		
1.0	RAW MATERIALS & BOUGHT OUT ITEMS													
	Raw Material	Material Identification	Major	TC Review	100%	Approved BHEL Spec./Drawing/ datasheet	Approved BHEL Spec./Drawing/ datasheet	MTC	√	2	1	1		
2.0	FINAL INSPECTION & TESTING													
		Visual ,Dimension, Marking	Major	Visual	100%				IR	√	2	1	1	10% shall be witnessed by "1"
		Chemical & Mechanical properties	Major	TC Review	One per lot/batch				MTC	√	2	1	1	
		Compressibility, Recovery	Major	Testing	Random				TC	√	2	1	-	
		Residual Stress, Gas permeability & Resistance to fluid test	Major	Testing	Random				TC	√	2	2	1	Applicable for NAB gasket
		BOM check	Major	Visual	100%				IR	√	2	1	-	
4.0	PRESERVATION & PACKING													
	Gasket	Packing, Marking	Major	Visual	100%	Approved BHEL Spec./Drawing/ datasheet	Approved BHEL Spec./Drawing/ datasheet	IR	√	2	2	1		

LEGEND: P: PERFORM, W: WITNESS, V: TEST CERTIFICATE REVIEW. INDICATE 1 FOR BHEL / 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	APPROVED BY	APPROVED BY
	 BHEL QA SIGNATURE & STAMP	 BHEL QA SIGNATURE & STAMP	 CUSTOMER'S SIGNATURE & STAMP (IF APPLICABLE)

 PROJECT ENGINEERING & SYSTEM DIVISION		STANDARD MANUFACTURING QUALITY PLAN								QP. NO.: PESD/QA/ GASKET/01/18-19					
		PRODUCT: GASKET						BHEL SPEC: AS PER P.O				REV NO: 00		DATE: 22-02-2019	
												PAGE 2 OF 2			
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	*	AGENCY			REMARKS		
									D	P	W	V			

Notes:-

1. This MQP should be read along with specification, approved drawings & approved datasheet. (Latest revisions to be considered as per PO).
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.
4. Seaworthy packing shall be **witnessed** BHEL/BHEL nominated inspection agency for overseas project.
5. End Customer/Consultant inspection if any shall be intimated during quality plan approval.
6. **NACE requirement:** For items coming under **NACE category**, all tests, reports, MTC and certificates shall be submitted as per **NACE MR0103** requirements.

Abbreviations:-

MTC	–	Material Test certificate	WPS	–	Welding Procedure Specification
IBR	–	Indian Boiler Regulations	PQR	–	Procedure Qualification Record
DFT	–	Dry Film Thickness	WPQ	–	Welder Performance Qualification
TC	–	Test Certificate	NDE	–	Non Destructive Examination
IS	–	Indian Standards	UTS	–	Ultimate Tensile Strength
Appd.			YS	–	Yield Strength
Dwg.	–	Approved Drawing	EL.	–	Elongation
PMI	–	Positive Material Identification	OD	–	Outer Diameter
G.I	–	Galvanized Iron	ID	–	Internal Diameter

LEGEND: P: PERFORM, W: WITNESS, V: TEST CERTIFICATE REVIEW. INDICATE 1 FOR BHEL / 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  BHEL QA SIGNATURE & STAMP	APPROVED BY  BHEL QA SIGNATURE & STAMP	APPROVED BY CUSTOMER'S SIGNATURE & STAMP (IF APPLICABLE)
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