

VENDOR'S NAME & ADDRESS:		TYPICAL MANUFACTURING QUALITY PLAN						QP. NO.:				
								CUSTOMER: BHEL, HYDERABAD – 32.		BHEL P.O.NO.:		REV NO:00
		PROJECT:		P.O.DATE:		BHEL SPEC:		REV:		PAGE1 OF 2		
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT & ACCEPTANCE NORMS	FORMAT OF RECORD	* D	P	W	V	REMARKS

1.0	RAW MATERIALS & BOUGHT OUT ITEMS												
1.1	Body, Top Cover, Air vent	Chemical & Mech. properties	Major	Chemical & mech. testing	One per Heat/Batch	BHEL Specification / Appd. Drawings / Appd Data sheet	MTC	√	2	2	1 & 3	Note:4	
1.2		Surface defects	Major	Visual	100%		IR	√	2	2	1 & 3		
1.3	Washer & Ball	Mech. properties	Major	Mech. testing	One per Lot		MTC	√	2	2	1 & 3		
1.4		Dimensions	Major	Measurement	100%		IR	√	2	2	1 & 3		
1.5		Hardness value	Major	Hardness test	As per spec		TC	√	2	2	1 & 3		
2.0	INPROCESS INSPECTION												
2.1	Body, Cover, Cowl, Joint support ring	Surface finish	Major	Visual	100%	BHEL Specification / Appd. Drawings / Appd Data sheet	IR		2	2	1 & 3		
2.2		LPI For Seating Surfaces	Major	LPI	As per BHEL Spec		NDE Report	√	2	2	1 & 3	as applicable	
2.3		Dimensions	Major	Measurements	100%		ITR		2	2	1 & 3		
3.0	FINAL INSPECTION & TESTING												
3.1	Valve Assembly	Visual Inspection, Dimensional check	Major	Visual & measurement	100%	BHEL Specification / Appd. Drawings / Appd Data sheet	IR	√	2	1 & 3	-	10% shall be witnessed by “1&3”	
3.2		a) Body (Hydro test) b) Seat test c) Functional test	Critical	Testing	100%		TC	√	2	1 & 3	-		

LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL/BHEL NOMINATED TPIA 2 FOR VENDOR/SUB VENDOR AND 3 FOR END USER/CUSTOMER 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
	VENDOR'S SIGNATURE & STAMP	BHEL QA SIGNATURE & STAMP	CUSTOMER'S SIGNATURE & STAMP

VENDOR'S NAME & ADDRESS:			TYPICAL MANUFACTURING QUALITY PLAN						QP. NO.:			
			CUSTOMER: BHEL, HYDERABAD – 32.			BHEL P.O.NO.:			REV NO:00		DATE:	
			PROJECT: PRODUCT: AIR RELEASE VALVE (Gun Metal)			P.O.DATE: BHEL SPEC: REV:			PAGE2 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
4.0	PRESERVATION & PACKING											
4.1	Valve Assembly	Painting (Shade, DFT), Marking	Major	Visual & DFT Measurement	Random	BHEL Specification / Appd. Drawings / Appd Data sheet	IR	✓	2	1 & 3	-	If applicable
4.2		Packing	Major	Visual	Random		Packing list	✓	2	2	1 & 3	

Notes:-

1. This Typical MQP should be read along with specification (Latest revision as per PO), approved drawings & approved datasheet (as applicable).
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. Elongation at Break before and after ageing to be carried out.

Abbreviations:-

MTC – Material Test certificate

IR - Inspection Report

TC – Test Certificate

ITR - Internal Test Report

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