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STANDARD QUALITY PLAN For CONTROL PANEL					
QUALITY SERVICES DEPARTMENT					
Prepared by		Checked by		Approved by	
Suvendu Kumar Sethy		K Panchala Prasad		V V N Raju	
				Rev. No.	Date:
				00	27.11.2014

VENDOR'S NAME & ADDRESS:			TYPICAL MANUFACTURING QUALITY PLAN						QP. NO.:				
									REV NO:		DATE:		
			CUSTOMER: PROJECT: PRODUCT:			BHEL P.O.NO.: P.O.DATE: BHEL SPEC:			REV:			PAGE 2 OF 4	
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												
	CASTING	VERIFICATION OF MATERIAL OF CONSTRUCTION	MAJOR	CHEMICAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	MTC/IR/TC	√	2		1		
	READYMADE COMPONENTS LIKE PB ELEMENT, SELECTOR SWITCH,METER & TERMINAL CONNECTORS etc.	RATING,FUNCTIONAL,HIGH VOLTAGE ,INSULATION RESISTANCE TEST	MAJOR	ELECTRICAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	MTC/IR/TC	√	2		1		
	GASKET & HARDWARE	DIMENSIONS	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	MTC/IR/TC	√	2		1		
2.0	INPROCESS INSPECTION												
	MACHINING	DIMENSIONS	MAJOR	MEASUREMENT	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC		2		1		
		CABLE ENTRY	MAJOR	MEASUREMENT	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC		2		1		
	PAINTING	SHADE	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC		2		1		
3.0	FINAL INSPECTION & TESTING												
	ACCEPTANCE TEST	OVERAL DIMENSION	MAJOR	MEASUREMENT	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			

LEGEND: P: PERFORM, W: WITNESS, V: TEST CERTIFICAT REVIEW. INDICATE 1 FOR BHEL / BHEL NOMINATED INSPECTION AGENCY/END USER/END USER'S REPRESENTATIVE & 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.

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		CUSTOMER: PROJECT: PRODUCT:				BHEL P.O.NO.: P.O.DATE: BHEL SPEC:			REV NO:		DATE:		
									PAGE 3 OF 4				
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		CABLE ENTRY	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		CHECK FOR JOINTS,SURFACE & GAP/CLEARANCE	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		TERMINAL ARRANGEMENT	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		LOCATION OF COMPONENTS(ASS EMBLY)	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		PAINT SHADE,PAINT THICKNESS & FINISHING	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		DIELECTRIC TEST	MAJOR	ELECTRICAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		INSULATION RESISTANCE TEST	MAJOR	ELECTRICAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		PRESSURE TEST	MAJOR	PRESSURE TEST	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
		BOM CHECK	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2	1			
	TYPE TEST	DEGREE OF PROTECTION TEST OF ENCLOSURE	MAJOR	ELECTRICAL	---	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2		1		

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SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY			REMARKS
										P	W	V	
		FLAME PROOFNESS OF ENCLOSURE	MAJOR	ELECTRICAL	---	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2			1	
	STATUTORY APPROVAL	CCOE/PESO APPROVALS	MAJOR	ELECTRICAL	---	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2			1	
		BIS LICENCE FOR FLAMEPROOF EQUIP.	MAJOR	ELECTRICAL	---	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2			1	
4.0	PRESERVATION & PACKING												
		PACKING	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2			1	
		PACKING LIST	MAJOR	VISUAL	100%	AS PER BHEL SPEC. /APPD. DRG. /APPD. DATA SHEET	IR/TC	√	2			1	

Notes:-

1. This Standard 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. All type test reports submitted shall not be older than 5 years from the date of purchase order.
4. Any project/customer specific requirements which shall be notified have to be fulfilled by the vendor at the time of execution of order.
5. The applicability of End Customer's scope of Inspection (Legend-'3') will be communicated by BHEL during execution stage.

Abbreviations:-

MTC – Material Test certificate
IR - Inspection Report

TC – Test Certificate

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