


QUALITY PLAN

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	QP NO.	SQP_F_CSTP	REV.	00	DESCRIPTION				LEGENDS				
	SPEC. NO.	AS PER BHEL P.O.	REV.	AS PER PO	CONDENSER TUBE PLATE				P- PERFORMED BY W- WITNESSED BY V- VERIFIED BY D- DOCUMENTS REQUIRED			1- BHEL/INSPECTION AGENCY	
	DRG. NO.	AS PER BHEL P.O.	REV.	AS PER PO								2- VENDOR	
												3- SUBVENDOR	
SL. NO.	COMPONENT OPERATION	CHARACTERISTICS	CLASSIFI- CATION	TYPE OF CHECK	QUANTUM	REFERENCE DOCUMENT	ACCEPTANC E NORMS	FORMAT OF RECORDS	D	AGENCY			REMARKS
										P	W	V	
1.0	Material at receiving inspection												
1.1		Verification of supplier's certificate	Major	TC review	100 %	AA 10119	AA 10119	Receiving inspection record	√	2	-	1	
2.0	In process Inspection												
2.1		Out of flatness of Tube Plate	Major	Measurement	100%	Drawing	Drawing	TC	√	2	1	-	
2.2		Diameter of tube plates holes & ovality	Major	Measurement	Random	Drawing	Drawing	TC	√	2	1	-	*
2.3		Ligament thickness	Major	Measurement	Random	Drawing	Drawing	TC	√	2	1	-	*
2.4		Surface finish of holes	Minor	Measurement	Random	Drawing	Drawing	TC	√	2	1	-	*
2.5		Verification of dimensions & visual inspection	Major	Visual & dimensional	100%	Drawing	Drawing	TC	√	2	1	-	*
3	Final Inspection												
3.1		Check for cleanliness & completeness & painting	Major	Visual	100%	Drawing	Drawing	TC		2	1	-	

Note : * In addition to BHEL, customer will witness for Goindwal & Amravati project.

N K Manwani
DGM (QAX)
BHEL

8/3/10

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