

FIRST ANGLE PROJECTION

FORM



QC-148

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-58052LS

VAR.
SL. NO.

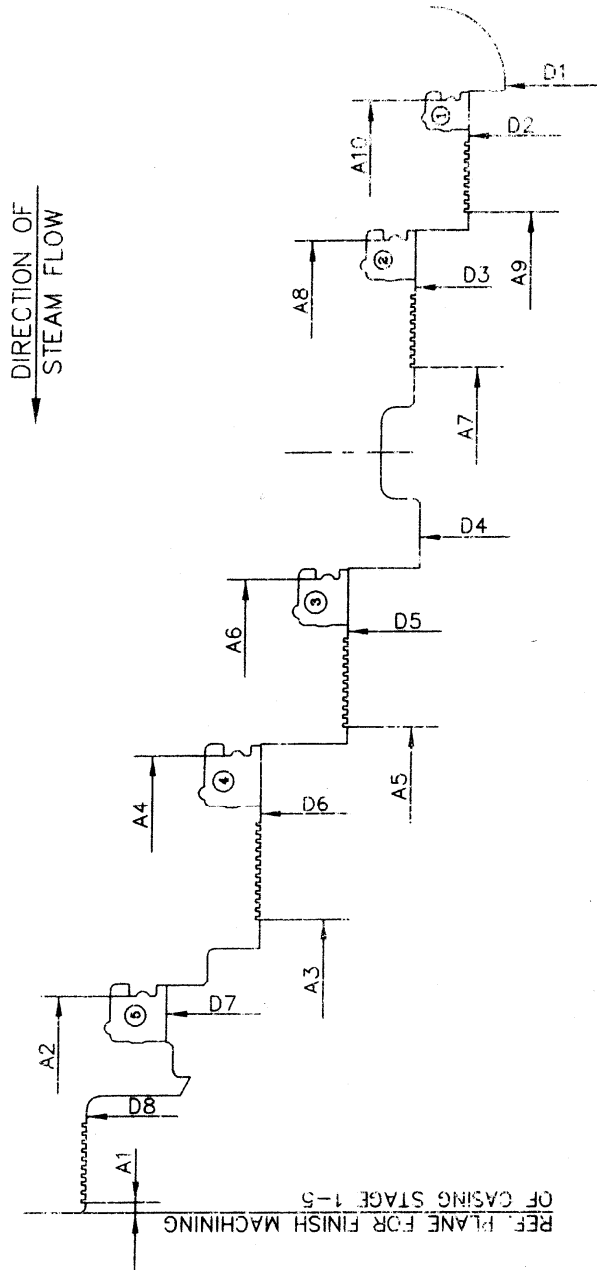
SHEET No. 01 No. OF SHEETS 04

ISSUING DEPT. QAX
NAME VKS
SIGN. [Signature]
DATE 17.01.13

GROOVE PLAN LPT (CASING)
(MACHINING)

WORK ORDER No.
TYPE OF PRODUCT STEAM TURBINE
P.N. No.

DIAMETERS & AXIAL DISTANCES IN CASING



REF. PLANE FOR FINISH MACHINING
OF CASING STAGE 1-5

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SIGN & DATE

INVENTORY NO. 0314276
REF. NO. [Handwritten]

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	CH. ADV. No.
DRN.	VKS	[Signature]	17.01.13	STE	BPS	[Signature]	25/13	FILLED IN BY				NAME SIGN.
CHD.	RK	[Signature]	17.01.13	QCX	HCF	[Signature]	4/13	CHD.				CH. ADV. No.
APPD.	GKP	[Signature]	09.02.13					APPD.				NAME SIGN.

ALTERED	NAME	SIGN.
RWN No.	DATE	CHECKED
ALTERED	NAME	SIGN.
PVN No.	DATE	CHECKED

SIZE A1

FIRST ANGLE PROJECTION

FORM



QC-14B

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-53052LS

VAR.
SL. NO.

ISSUING DEPT. QAX
DEPT. CODE 4700

GROOVE PLAN LPT (CASING)
(MACHINING)

SHEET No. 02 No. OF SHEETS 04

WORK ORDER No.

TYPE OF PRODUCT

RVN. No.

STEAM TURBINE

DIAMETERS & AXIAL DISTANCES IN CASING

DIMENSION	AS PER DRG.	AS OBSERVED	
		TURBINE SIDE	GENERATOR SIDE
D1	∅1864±0.2		
D2	∅1908 ^{+0.150}		
D3	∅1971 ^{+0.150}		
D4	∅1963±0.2		
D5	∅2047 ^{+0.175}		
D6	∅2148 ^{+0.175}		
D7	∅2256 ^{+0.175}		
D8	∅2348.8 ^{+0.175}		

AXIAL DISTANCES

DIMENSION	AS PER DRG.	AS OBSERVED	
		TURBINE SIDE	GENERATOR SIDE
A1	6 ±0.1		
A2	127.7±0.1		
A3	171.9±0.1		
A4	268.9±0.1		
A5	285.5±0.1		
A6	372.2±0.1		
A7	497.2±0.1		
A8	571.4±0.1		
A9	587.4±0.1		
A10	654.5±0.1		

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INVENTORY NO. 53-1676
 REF. NO. 17/01/13
 SIGN & DATE *[Signature]* 17/01/13

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	CH. ADV. No.
DRN	VKS	<i>[Signature]</i>	17-01-13	STE	BB	<i>[Signature]</i>	25/01/13	FILLED IN BY				NAME SIGN
CHD.	RK	<i>[Signature]</i>	17-01-13	QAX	HEP	<i>[Signature]</i>	12/1	CHD.				CH. ADV. No.
APPD.	UKP	<i>[Signature]</i>	09-02-13					APPD.				NAME SIGN

ALTERED
 RVN No. DATE CHECKED
 ALTERED
 RVN No. DATE CHECKED

SIZE A4

FIRST ANGLE PROJECTION

FORM



CC-148

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-58052LS

VAR.
SL. NO.

ISSUING DEPT. QAX
DEPT. CODE 4700

GROOVE PLAN LPT (CASING)
(MACHINING)

SHEET No. 03 No. OF SHEETS 04

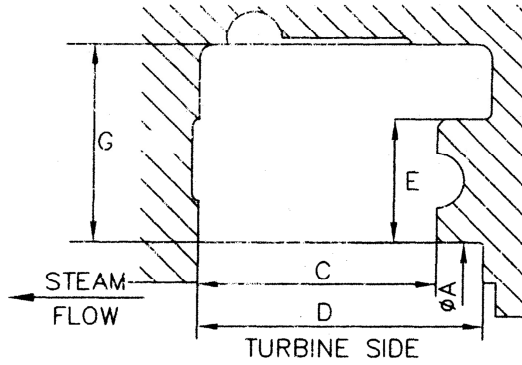
WORK ORDER No.

TYPE OF PRODUCT

RVN. No.

STEAM TURBINE

GROOVE FOR GUIDE BLADES



TURBINE SIDE

STAGE NO.	DIMENSIONS	φA	C	D	E	G
01	AS PER DRG.	φ1918+0.150	17.1+0.110 0	21.6+0.040 +0.007	12 -0.050 -0.160	21 ±0.1
	AS OBSERVED					
02	AS PER DRG.	φ1981+0.150	22.8+0.130 0	28.3+0.040 +0.007	14 -0.050 -0.160	24 ±0.1
	AS OBSERVED					
03	AS PER DRG.	φ2057+0.175	26.7+0.130 0	32.2+0.048 +0.009	14 -0.050 -0.160	24 ±0.1
	AS OBSERVED					
04	AS PER DRG.	φ2160+0.175	30.2+0.160 0	36.2+0.048 +0.009	16 -0.050 -0.160	27 ±0.1
	AS OBSERVED					
05	AS PER DRG.	φ2268+0.175	26.8+0.130 0	32.8+0.048 +0.009	16 -0.050 -0.160	27 ±0.1
	AS OBSERVED					

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SIGN & DATE
 INVENTORY NO. 52.4676
 REF. NO.

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	CH. ADV. No.
DRN.	VKS	<i>[Signature]</i>	17-01-13	STE	BPS	<i>[Signature]</i>	25/01/13	FILLED IN BY				NAME SIGN.
CHD.	RK	<i>[Signature]</i>	17-01-13	QCX	HKT	<i>[Signature]</i>	4 2/13	CHD.				CH. ADV. No.
APPD.	UKP	<i>[Signature]</i>	05-02-13					APPD.				ALTERED NAME SIGN.

RVN No.	DATE	CHECKED

SIZE A4

FIRST ANGLE PROJECTION

FORM



QC-148

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-58052LS

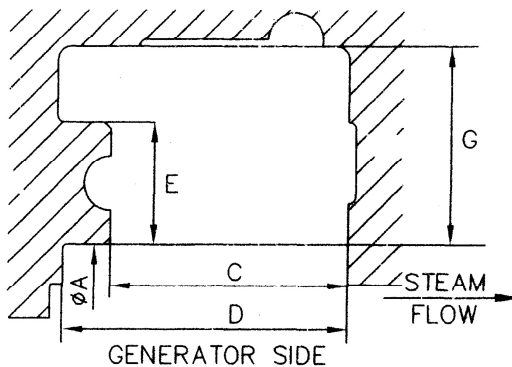
VAR.
SL. NO.

ISSUING DEPT. QAX
DEPTT. CODE 4700

GROOVE PLAN LPT (CASING)
(MACHINING)

SHEET No. 04 No. OF SHEETS 04
WORK ORDER No.
TYPE OF PRODUCT STEAM TURBINE
RVN. No.

GROOVE FOR GUIDE BLADES



GENERATOR SIDE

STAGE NO.	DIMENSIONS	ϕA	C	D	E	G
01	AS PER DRG.	$\phi 1918^{+0.150}$	$17.1^{+0.110}_0$	$21.6^{+0.040}_{+0.007}$	$12^{-0.050}_{-0.160}$	21 ± 0.1
	AS OBSERVED					
02	AS PER DRG.	$\phi 1981^{+0.150}$	$22.8^{+0.130}_0$	$28.3^{+0.040}_{+0.007}$	$14^{-0.050}_{-0.160}$	24 ± 0.1
	AS OBSERVED					
03	AS PER DRG.	$\phi 2057^{+0.175}$	$26.7^{+0.130}_0$	$32.2^{+0.048}_{+0.009}$	$14^{-0.050}_{-0.160}$	24 ± 0.1
	AS OBSERVED					
04	AS PER DRG.	$\phi 2160^{+0.175}$	$30.2^{+0.160}_0$	$36.2^{+0.048}_{+0.009}$	$16^{-0.050}_{-0.160}$	27 ± 0.1
	AS OBSERVED					
05	AS PER DRG.	$\phi 2268^{+0.175}$	$26.8^{+0.130}_0$	$32.8^{+0.048}_{+0.009}$	$16^{-0.050}_{-0.160}$	27 ± 0.1
	AS OBSERVED					

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SIGN DATE


INVENTORY NO. REF. NO.

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPTT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	CH. ADV. No.
DRN.	VKS		17.01.13	STE	BPS		25.01.13	FILLED IN BY				ALTERED NAME SIGN.
CHD.	RK		17.01.13	QCX	HEP		17.01.13	CHD.				ALTERED NAME SIGN.
APPD.	UKP		09.02.13					APPD.				ALTERED NAME SIGN.

SIZE A4

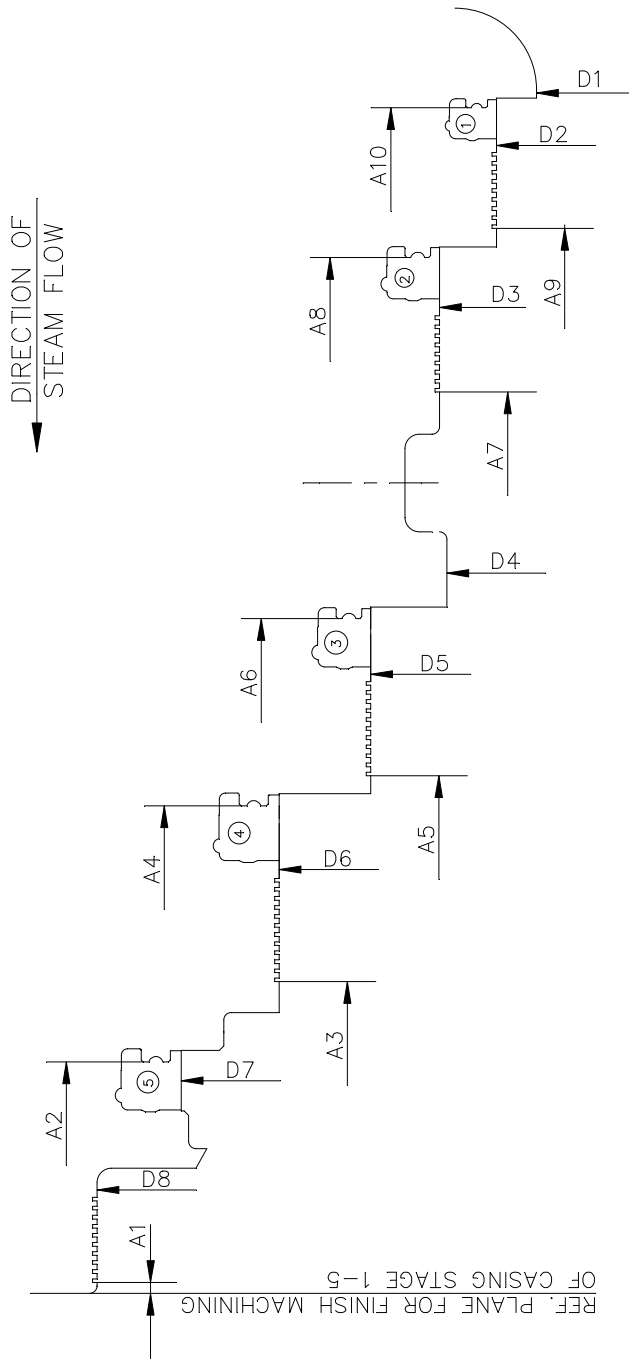
FIRST ANGLE PROJECTION

FORM

SIGN. & DATE			QC-148	(LOG SHEET MANUFACTURING) HEEP-HARDWAR				0-10304-58054LS		VAR.		
	ISSUING DEPT.	DEPT. CODE						SHEET No. 01	No. OF SHEETS	04		SL. NO.
SUPERSEDES INVENTORY NO.	QAX	4700	GROOVE PLAN LPT (CASING) (MACHINING)				WORK ORDER No.		RVN. No.			
	ID NO.						QP NO.	TYPE OF PRODUCT		STEAM TURBINE		
	CLAUSE NO.											

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DIAMETERS & AXIAL DISTANCES IN CASING



INVENTORY NO. S3-4674	SIGN & DATE		SUPERSEDES THE OLD LOGSHEET UNDER THE SAME NUMBER												CH. ADV. No. QAX-19-F0028				
	SD/-	11.02.13	ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPTT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	03	04.07.19	ALTERED	NAME	SIGN.
REF.NO.	DRN.	VKS	sd/-	17.1.13	STE	BPS	sd/-	25.1.13	FILLED IN BY					RVN No.	DATE	CHECKED	SKR	sd/-	
	CHD.	RK	sd/-	17.1.13	QCX	HKT	sd/-	04.2.13	CHD.								IBK	sd/-	
	APPD.	UKP	sd/-	09.2.13					APPD.								ALTERED	NAME	SIGN.
														RVN No.	DATE	CHECKED			

FIRST ANGLE PROJECTION

FORM

SIGN. & DATE			QC-148	(LOG SHEET MANUFACTURING) HEEP-HARDWAR								0-10304-58054LS			VAR.			
												SHEET No. 02		No. OF SHEETS		04		SL. NO.
SUPERSEDES INVENTORY NO.	ISSUING DEPT.	DEPT. CODE	GROOVE PLAN LPT (CASING) (MACHINING)								WORK ORDER No.			RVN. No.				
	QAX	4700									TYPE OF PRODUCT		STEAM TURBINE					
DIAMETERS & AXIAL DISTANCES IN CASING																		
COPYRIGHT AND CONFIDENTIAL The Information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in any way detrimental to the interest of the company	DIMENSION		AS PER DRG.		AS OBSERVED													
					TURBINE SIDE				GENERATOR SIDE									
	D1		∅1864 ±0.2															
	D2		∅1908 +0.150															
	D3		∅1971 +0.150															
	D4		∅1963 ±0.2															
	D5		∅2047 +0.175															
	D6		∅2148 +0.175															
	D7		∅2256 +0.175															
	D8		∅2348.8 +0.175															
AXIAL DISTANCES																		
DIMENSION		AS PER DRG.		AS OBSERVED														
				TURBINE SIDE				GENERATOR SIDE										
A1		6 ±0.1																
A2		127.7 ±0.1																
A3		171.1 ±0.1																
A4		271.5 ±0.1																
A5		294.0 ±0.1																
A6		386.8 ±0.1																
A7		481.8 ±0.1																
A8		562.0 ±0.1																
A9		585.7 ±0.1																
A10		654.5 ±0.1																
SIGN & DATE	sd/- 11.02.13	ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPTT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	SUPERSEDES THE OLD LOGSHEET UNDER THE SAME NUMBER		CH. ADV. No.		
		DRN.	VKS	sd/-	17.1.13	STE	BPS	sd/-	25.1.13	FILLED IN BY					03	04.07.19	ALTERED	NAME
INVENTORY NO.	S3-4674	REF. NO.	CHD.	RK	sd/-	17.1.13	QAX	HKT	sd/-	04.2.13	CHD.						CH. ADV. No.	
			APPD.	UKP	sd/-	09.2.13					APPD.							ALTERED

SIZE A4

FIRST ANGLE PROJECTION

FORM



QC-148

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-58054LS

VAR.

SL. NO.

SHEET No. **03** No. OF SHEETS **04**

ISSUING DEPT. QAX
DEPTT. CODE 4700

GROOVE PLAN LPT (CASING)
(MACHINING)

WORK ORDER No.

TYPE OF PRODUCT

RVN. No.

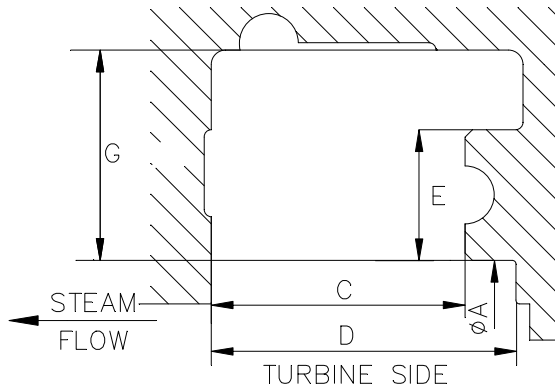
STEAM TURBINE

SIGN. & DATE

SUPERSEDES INVENTORY NO.

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GROOVE FOR GUIDE BLADES



TURBINE SIDE

STAGE NO.	DIMENSIONS	φA	C	D	E	G
01	AS PER DRG.	φ1918 +0.150	16.2 ^{+0.110} / ₀	20.7 ^{+0.040} / _{+0.007}	12 ^{-0.050} / _{-0.160}	21 ±0.1
	AS OBSERVED					
02	AS PER DRG.	φ1981 +0.150	22.8 ^{+0.130} / ₀	28.3 ^{+0.040} / _{+0.007}	14 ^{-0.050} / _{-0.160}	24 ±0.1
	AS OBSERVED					
03	AS PER DRG.	φ2057 +0.175	26.7 ^{+0.130} / ₀	32.2 ^{+0.048} / _{+0.009}	14 ^{-0.050} / _{-0.160}	24 ±0.1
	AS OBSERVED					
04	AS PER DRG.	φ2160 +0.175	28.8 ^{+0.130} / ₀	34.8 ^{+0.048} / _{+0.009}	16 ^{-0.050} / _{-0.160}	27 ±0.1
	AS OBSERVED					
05	AS PER DRG.	φ2268 +0.175	26.8 ^{+0.130} / ₀	32.8 ^{+0.048} / _{+0.009}	16 ^{-0.050} / _{-0.160}	27 ±0.1
	AS OBSERVED					

SIGN & DATE

sd/- 11.02.13

INVENTORY NO.

S3-4674

REF. NO.

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPTT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	SUPERSEDES THE OLD LOGSHEET UNDER THE SAME NUMBER			CH. ADV. No. QAX-19-F0028		
DRN.	VKS	sd/-	17.1.13	STE	BPS	sd/-	25.1.13	FILLED IN BY				03	04.07.19	ALTERED	NAME	SIGN.	
CHD.	RK	sd/-	17.1.13	QCX	HKT	sd/-	04.2.13	CHD.				RVN No.	DATE	CHECKED	SKR	sd/-	
APPD.	UKP	sd/-	09.2.13					APPD.						ALTERED	IBK	sd/-	
																CH. ADV. No.	
																NAME	SIGN.

FIRST ANGLE PROJECTION

FORM



QC-148

(LOG SHEET MANUFACTURING)
HEEP-HARDWAR

0-10304-58054LS

VAR.

SL. NO.

SHEET No. **04** No. OF SHEETS **04**

ISSUING DEPT. QAX
DEPTT. CODE 4700

GROOVE PLAN LPT (CASING)
(MACHINING)

WORK ORDER No.

TYPE OF PRODUCT

RVN. No.

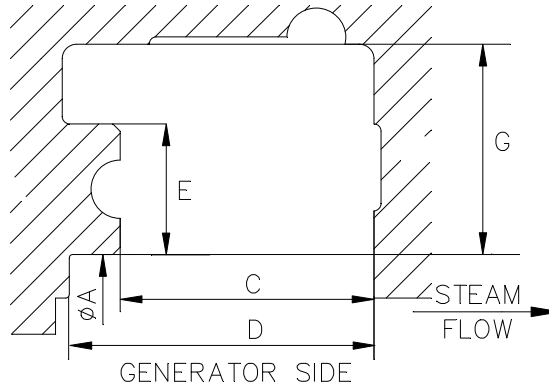
STEAM TURBINE

SIGN. & DATE

SUPERSEDES INVENTORY NO.

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GROOVE FOR GUIDE BLADES



GENERATOR SIDE

STAGE NO.	DIMENSIONS	øA	C	D	E	G
01	AS PER DRG.	ø1918 +0.150	16.2 ^{+0.110} / ₀	20.7 ^{+0.040} / _{+0.007}	12 ^{-0.050} / _{-0.160}	21 ±0.1
	AS OBSERVED					
02	AS PER DRG.	ø1981 +0.150	22.8 ^{+0.130} / ₀	28.3 ^{+0.040} / _{+0.007}	14 ^{-0.050} / _{-0.160}	24 ±0.1
	AS OBSERVED					
03	AS PER DRG.	ø2057 +0.175	26.7 ^{+0.130} / ₀	32.2 ^{+0.048} / _{+0.009}	14 ^{-0.050} / _{-0.160}	24 ±0.1
	AS OBSERVED					
04	AS PER DRG.	ø2160 +0.175	28.8 ^{+0.130} / ₀	34.8 ^{+0.048} / _{+0.009}	16 ^{-0.050} / _{-0.160}	27 ±0.1
	AS OBSERVED					
05	AS PER DRG.	ø2268 +0.175	26.8 ^{+0.130} / ₀	32.8 ^{+0.048} / _{+0.009}	16 ^{-0.050} / _{-0.160}	27 ±0.1
	AS OBSERVED					

SIGN & DATE

sd/- 11.02.13

INVENTORY NO.


S3-4674

REF. NO.

ISSUING DEPT.	NAME	SIGN.	DATE	AGREED DEPTT.	NAME	SIGN.	DATE	QCX	NAME	SIGN.	DATE	SUPERSEDES THE OLD LOGSHEET UNDER THE SAME NUMBER			CH. ADV. No. QAX-19-F0028	
DRN.	VKS	sd/-	17.1.13	STE	BPS	sd/-	25.1.13	FILLED IN BY				03	04.07.19		NAME	SIGN.
CHD.	RK	sd/-	17.1.13	QCX	HKT	sd/-	04.2.13	CHD.				RVN No.	DATE	CHECKED	SKR	sd/-
APPD.	UKP	sd/-	09.2.13					APPD.						ALTERED	IBK	sd/-
														ALTERED		CH. ADV. No.
														ALTERED		NAME
														ALTERED		SIGN.
														ALTERED		

Manufacturer Name and Address		MANUFACTURING QUALITY PLAN					APPLICABILITIES TO													
BHEL Haridwar approved SUB-CONTRACTORS only		ITEM	Machining of "GUIDE BLADE CARRIER for LP1 and LP2"					PROJECT												
			WO. No.	CHARACTERISTIC CHECKED	CATE-GORY	TYPE/METHED OF CHECKED	QUANT-UM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	FORMAT OF RECORD	PAGE NO.	CONTRACTOR	INDENT	REMARK						
															Q.P. NO.	Q.P/QA/190043	DATE	10.07.19	REV. NO.	01
															YADADRI	BHEL (HEEP) HWR	20190201 rev 03	dated 05.07.19		
1	2	3	4	5	6	7	8	9	10	11	12	13	14							

S. No.	COMPONENT OPERATION	CHARACTERISTIC CHECKED	CATE-GORY	TYPE/METHED OF CHECKED	QUANT-UM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	FORMAT OF RECORD	D	M	B	C	REMARK
1.0	Pre-qualifying requirements for machining of guide blade carrier as per TDC.	Verification of records	Major	Record review	100 %	As per drg./ Standard	As per drg./ Standard	Record	✓	P	V	-	For BHEL material, transfer of identification to be ensured.
1.1	Material Receiving Inspection	Verification of identification of material	Major	Visual inspection	100 %	As per drg./ Standard	As per drg./ Standard	Q.No.	✓	P	V	-	For BHEL material, transfer of identification to be ensured.
2.0	INPROCESS INSPECTION												
2.1	Before finish machining of groove	Stage inspection (on machine dimensions including half bore error, joint plane and alignment points)	Major	Visual and measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	- Guide blade carrier shall be finished machined as per machining details and technical requirements furnished in Drg. No. 01112158100 and 01030458052 for LPT-1 & Drg. No. 01112158100 and 01030458054 for LPT-2



 इच्छा सुधार / L. B. KUMAR
 बरिओ अभियन्ता / Sr. Engineer
 गुणता अध्यापन / Quality Assurance
 श्री. हरिद्वार
 श्री. हरिद्वार, हरिद्वार
 BHEL, HEEP, Haridwar

Manufacturer/Subcontractor **For BHEL Use**
 Legends: P Perform by; W Witness by; V Record review; C Customer ; B BHEL ; M Manufacturer/ sub-contractor; D: documents with tick mark shall be submitted by vendor to BHEL.

Manufacturer Name and Address		MANUFACTURING QUALITY PLAN						APPLICABILITIES TO						
BHEL Haridwar approved SUB-CONTRACTORS only		ITEM	Machining of "GUIDE BLADE CARRIER for LP1 and LP2"				Q.P. NO	QP/QA/190043	PROJECT					
			WO. No.	10836A11501	TYPE/METHOD OF CHECKED	QUANT-UM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	DATE	10.07.19	YADADRI			
									REV. NO.	01	CONTRACTOR			
									PAGE NO.	Page 2 of 3	Indent			
S. No.		COMPONENT OPERATION	CHARACTERISTIC CHECKED	CATE-GORY	5	6	7	8	9	10	11	12	13	REMARK
1	2	3	4	5	6	7	8	9	10	11	12	13	14	

S. No.	COMPONENT OPERATION	CHARACTERISTIC CHECKED	CATE-GORY	TYPE/METHOD OF CHECKED	QUANT-UM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE DOCUMENT	FORMAT OF RECORD	D	M	B	C	REMARK
2.2		Dimensional check and visual inspection (including joint plane gap measurement, color matching of joint plane, surface roughness of joint plane.)	Major	Visual and measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	V/ W	-	-Witness of all 'dimensions with specified tolerance', rest for verification by BHEL. -All the axial dimensions in specified tolerances are to be maintained from reference plane.
2.3		Stage inspection (on machine dimensions)	Major	Visual and measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	
2.4	After/ During finish machining of groove	Dimensional check and visual inspection	Major	Visual and measurement	100%	As per Drg.	As per Drg.	Obs. Sheet and logsheet	✓	P	V/ W	V	-Witness of all 'dimensions with specified tolerance', rest for verification by BHEL. -All the axial dimensions in specified tolerances are to be maintained from reference plane. - Customer verification as per logsheet after finish machining of groove.
3.0	FINAL INSPECTION												

Manufacturer/Subcontractor	For BHEL Use
Legends: P Perform by; W Witness by; V Record review; C Customer ; B BHEL ; M Manufacturer/ sub-contractor; D: documents with tick mark shall be submitted by vendor to BHEL.	

इन्द्र मूषण कुमार/L. B. KUMAR
 बरिण अभियन्ता/Sr. Engineer
 गुणता आश्वासन/Quality Assurance
 श्री १०८० ई. ए. रोड, सी. पी. ए. ए.
 BHEL, HEPP, Haridwar

Manufacturer Name and Address		MANUFACTURING QUALITY PLAN						APPLICABILITIES TO					
ITEM		Machining of "GUIDE BLADE CARRIER for LPI and LP2"						Q.P. NO		QP/QA/190043		PROJECT	
BHEL Haridwar approved SUB-CONTRACTORS only		WO. No.		10836A11501		ACCEPTANCE DOCUMENT		DATE		10.07.19		YADADRI	
CHARACTERISTIC CHECKED		TYPE/METHOD OF CHECKED		QUANTUM OF CHECK		REFERENCE DOCUMENT		REV. NO.		01		CONTRACTOR	
COMPONENT OPERATION		CATE-GORY		100%		10836A11501		PAGE NO.		Page 3 of 3		BHEL (HEEP) HWR	
S. No.		3		4		5		6		7		8	
1		2		3		4		5		6		7	
		CHARACTERISTIC CHECKED		CATE-GORY		TYPE/METHOD OF CHECKED		QUANTUM OF CHECK		ACCEPTANCE DOCUMENT		FORMAT OF RECORD	
		3		4		5		6		7		8	
		2		3		4		5		6		7	
		1		2		3		4		5		6	
		10		11		12		13		14		15	
		D		M		B		C		REMARK			
		10		11		12		13		14		15	
		9		8		7		6		5		4	
		Page 3 of 3		Indent		20190201 rev 03 dated 05.07.19		BHEL (HEEP) HWR					

S. No.	Dimensions (as per Drg. No. 01112158100) finish machining of groove	Dimensional check and visual inspection	Major	Visual and measurement	100%	As per Drg.	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	-All machined surface must be protected against rust/corrosion by steam washable rust/ corrosion by steam washable rust preventive suitable for six months.
3.1	Dimensions (as per Drg. No. 01112158100) finish machining of groove	Dimensional check and visual inspection	Major	Visual and measurement	100%	As per Drg.	As per Drg.	As per Drg.	Obs. Sheet	✓	P	V	-	-All machined surface must be protected against rust/corrosion by steam washable rust/ corrosion by steam washable rust preventive suitable for six months.
3.2	Preservation	Preservation	Major	Visual and measurement	100%	As per Drg.	As per Drg.	As per Drg.	Obs. Sheet	✓	P	V	-	-Item shall be dispatched to BHEL after acceptance by BHEL after duly identifying by P.O.No., drg no. and I.R.No.
3.3	Check for Identification, cleanliness and completeness of job	Check for Identification, cleanliness and completeness of job	Major	Visual	100%	As per Drg.	As per Drg.	As per Drg.	Obs. Sheet	✓	P	V	-	-Item shall be dispatched to BHEL after acceptance by BHEL after duly identifying by P.O.No., drg no. and I.R.No.

Note: 1) All requirements of P.O., drawing, TDC and standard shall be fulfilled. 2) Dimensions, which are not covered in logsheets, shall be furnished in observation sheet.

[Handwritten Signature] 10.07.19

शुभम कुमार / L. B. KUMAR

उप-सूचना/ Sr. Engineer
 वरिष्ठ अभियन्ता/ Quality Assurance
 गुणता आश्वासन/ Quality Assurance
 बीएचएल, हरिद्वार
 BHEL, HEER, Haridwar

For BHEL Use

Legends: P Perform by; W Witness by; V Record review; C Customer ; B BHEL ; M Manufacturer/ sub-contractor; D: documents with tick mark shall be submitted by vendor to BHEL.

Manufacturer/Subcontractor