



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI - 620 014, INDIA.
QUALITY ASSURANCE DEPARTMENT

STANDARD QUALITY PLAN FOR SS WIRE MESH ROPE

SQP:SD:31 Rev No: 00

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Prepared By
Quality Assurance

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30/11/2018

Reviewed by	Signature
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Rev No	Date	Approved by	Signature
00	30/11/2018	AGM / QA & BE	 30/11/18

Record of Revisions

Rev No	Details of Revision	Remarks
00	Fresh Issue	

Proprietary Data - For Internal Use Only

		MANUFACTURER'S NAME & ADDRESS: BHEL: TIRUCHIRAPPALLI APPROVED SUPPLIERS		STANDARD QUALITY PLAN					QWI NO:SQP:SD:31 REV NO: 00 DATE: 30/11/2018 PAGE: 2 OF 2					
				PRODUCT: SS WIRE MESH ROPE										
				SUB-SYSTEM :Steam Generator and Auxiliaries										
SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS	
1	2	3	4	5	M	C/N	7	8	9	D*	M	C	N	11

1.0	RAW MATERIALS & BOUGHT OUT ITEMS												
1.1	Wire for SS Core Mesh	Chemical & Mechanical Properties	A	TC Review	100%	100%	Material Specification, BHEL Technical Specification	MTC	√	P	V	-	
1.2	Aluminum Alkyd Resin Cover	Chemical & Mechanical Properties	A	TC Review	100%	100%	Material Specification, BHEL Technical Specification	MTC	√	P	V	-	
2.0	IN-PROCESS INSPECTION												
2.1	SS Core Braiding	Material Construction	B	Visual	100%	100%	As per manufacturer's standard & BHEL Tech Specification	IR	√	P	V	-	
3.0	FINAL ASSEMBLY & TESTING												
3.1	Dimensional Check	Measurement	A	Measurement	100%	100%	BHEL Technical Specification, Purchase Order	IR	√	P	W	-	
3.2	Visual Examination	Visual Appearance	A	Visual	100%	100%	BHEL Technical Specification	IR	√	P	W	-	
3.3	Testing at service temperature	Temperature Withstand ability	A	Lab Analysis	One sample per lot		BHEL Technical Specification, Purchase Order	TC	√	P	W	-	
3.4	Density of SS Core	Weight per unit Volume	A	Measurement	100%	10%	BHEL Technical Specification, Purchase Order	IR	√	P	W	-	
4.0	PACKING & MARKING												
4.1	Packing	Tightness and Completeness	B	Visual	100%	100%	As per BHEL Purchase Order & BHEL Technical Specification	Photos, IR	√	P	V	-	
4.2	Marking/ Identification	Purchase Order No., Sl. No, Supplier name etc.	B	Visual	100%	100%	As per BHEL Purchase Order & BHEL Technical Specification	IR	√	P	V	-	
4.3	Certification	Conformation to specifications	A	Review of documents	100%	100%	BHEL SQP, Purchase Order, BHEL Technical Specification, MTCs and Inspection/Test reports	COC	√	P	V	-	

NOTES:

1. BHEL Technical specification – 4-28-220-00609 (Latest revision)

LEGEND: * RECORDS IDENTIFIED WITH "TICK" (√) SHALL BE ESSENTIALLY INCLUDED BY THE SUPPLIER IN QA DOCUMENTATION;
**** M:** MANUFACTURER, **C:** BHEL QC/BHEL AIA, **N:** CUSTOMER; **P:** PERFORM. **W:** WITNESS, **V:** VERIFICATION; **CLASS:** A - CRITICAL ; B - MAJOR ; C – MINOR;
MTC: Manufacturer's Test Certificate; **IR-** Inspection/Test Report; **COC:** Certificate of Compliance; **(R):** Routine test; **(I)/(Ts):** Type test.