

QUALITY PLAN

Item:- STUB BOLT (THREAD ROLLING)
QAP No. :- QP/QA/190001 Rev. 00 Date: 08.04.2019
Page 1 of 2

Sl. No	Component Operation	Characteristics	Class	Type Of Check	Quantum Of Check	Reference Documents	Acceptance Norms	Format Of Record	Agency			Remarks
									D	S	B	C

1	Material Receiving Inspection	Review of Supplier Test Certificate of Material for 1) Chemical composition 2) Mechanical Properties 3) Heat treatment 4) NDT	Major	Visual inspection	100%	As per Spec.	As per Spec.	TC	✓	P	V	-	All party material to be procured from BHEL, Haridwar approved sources with following conditions 1) In all the cases a mill test certificate correlateable with the component for verification of conformance of the material as per the requirement is essential. 2) In case the vendor is unable to purchase material along with original test certificate due to very low quantity, the TC must be from a NABL accredited laboratory and, should be correlateable with the component.
2	In-process inspection	Positive material identification (PMI)	Major	PMI	100%	As per Spec.	As per Drg.	Obs. sheet	✓	P	V	-	

[Signature] / 04.04.2019

Legend :-

D: documents with tick mark shall be submitted by sub-contractor to BHEL, Haridwar.,
S: Sub-contractor, B: BHEL, Haridwar, C: Customer
P: Perform, W: Witnessed V: Records Verification./Review

For BHEL Haridwar
कुमार / L. B. KUMAR
इंजीनियरिंग / Sr. Engineer
गुणवत्ता आश्वासन / Quality Assurance
डी. पी. ओ. ई. एल. ०, हरिद्वार
BHEL, Haridwar

Project:- BHEL Contractor:- BHEL Indent no. 20180981 Rev. dated 04.04.2019		QUALITY PLAN										
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3		Hardness of bar	Major	NDT	100%	As per Drg.	As per Drg.	Report	✓	P	V	-	
4		Complete machining and thread to be made through thread rolling	Major	Process	100%	As per Drg.	As per Drg.	Report	✓	P	W	-	Random witness by BHEL.
5		Verification of machined and thread rolled dimensions and visual inspection	Major	Visual and measurement	100%	As per Drg.	As per Drg.	Obs. Sheet	✓	P	W	-	
6	Final inspection	Check for Identification, cleanliness and completeness of job	Major	Visual	100%	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.

Remarks:

- All requirements of Standards, P.O., and drawing to be fulfilled

Handwritten signature and date: 08.04.19
BHEL, HEEL, Haridwar

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इन्द्र भूषण कुमार/L. B. KUMAR
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BHEL, HEEL, Haridwar