VENDOR'S NAME & ADDRESS:				MANUFACTURING QUALITY PLAN QP. NO.:									
CUSTOME		OMER: BHEL, HYDERABAD – 32.			BHEL P.O.NO.:			REV NO:		D	ATE:		
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JINEIN I S	CHARACTI	EKISTICS	CLASS	CHECK	OF CHECK	DOCUMENT	NORMS	RECOR	D I) F	W	V	REMARKS
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											-		
2.0 INPROCESS INSPECTION													
-33 INSFL	CTION												
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	E PREPAR	ESS INSPECTION SPECTION & TESTING E PREPARATION & PAIL VATION & PACKING	CUSTOME PROJECT: PRODUCT ONENTS CHARACTERISTICS TERIALS & BOUGHT OUT ITEMS ESS INSPECTION SPECTION & TESTING E PREPARATION & PAINTING	CUSTOMER: BHEL, PROJECT: PRODUCT: DNENTS CHARACTERISTICS CLASS TERIALS & BOUGHT OUT ITEMS ESS INSPECTION SPECTION & TESTING E PREPARATION & PAINTING VATION & PACKING	CUSTOMER: BHEL, HYDERABAD PROJECT: PRODUCT: DNENTS CHARACTERISTICS CLASS TYPE OF CHECK TERIALS & BOUGHT OUT ITEMS ESS INSPECTION SPECTION & TESTING E PREPARATION & PAINTING VATION & PACKING	CUSTOMER: BHEL, HYDERABAD – 32. PROJECT: PRODUCT: ONENTS CHARACTERISTICS CLASS TYPE OF CHECK TERIALS & BOUGHT OUT ITEMS ESS INSPECTION SPECTION & TESTING E PREPARATION & PAINTING VATION & PACKING	CUSTOMER: BHEL, HYDERABAD – 32. PROJECT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PROPURCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PRODUCT: PROPURCT: PRODUCT: PRODU	CUSTOMER: BHEL, HYDERABAD – 32. PROJECT: PRODUCT: BHEL SPEC: BHEL SPEC: REV: BHEL SPEC: BHEL SP	CUSTOMER: BHEL, HYDERABAD – 32. PROJECT: PRODUCT: BHEL SPEC: BRITERIALS & BOUGHT OUT ITEMS SES INSPECTION SPECTION SPECTION & TESTING E PREPARATION & PAINTING VATION & PACKING	CUSTOMER: BHEL, HYDERABAD - 32. PROJECT: PROJECT: PRODUCT: BHEL PEC: BHEL PE	CUSTOMER: BHEL, HYDERABAD - 32. PROJECT: PRODUCT: PRODUCT	CUSTOMER: BHEL, HYDERABAD - 32. BHEL P.O.NO.: P.O.DATE: BHEL P.O.NO.: P.O.DATE: PRODUCT: P.O.DATE: P.O.DATE:	CUSTOMER: BHEL, HYDERABAD - 32. BHEL PO NO. PO DATE: PRODUCT: PRODUCT: PRODUCT: BHEL SPEC: REV: PAGE 1 OI OI OI DATE: PAGE 1 OI

VENDOR TO NOTE & DELETE THIS INFORMATION

THIS FORMAT IS IN MICROSOFT WORD. HEADER & FOOTER SHALL BE AVAILABLE IN EACH PAGE OF QP. QP SHALL BE IN LANDSCAPE & A4 SIZE ONLY. FONT SIZE SHALL BE MIN 10. VENDOR SHALL SIGN & STAMP IN EACH PAGE OF QP. P.O.NO. & DATE SHALL BE INDICATED. QP NO. SHOULD BE UNIQUE AND SHALL NOT REPEAT. ALL THE TESTS / CHECKS INDICATED IN THE BHEL SPEC. SHALL BE INDICATED IN THE QP.

LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1 FOR BHEL CQS	PREPARED BY	APPROVED BY	APPROVED BY
(OR BHEL NOMINATED INSPECTION AGENCY) & 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.	VENDOR'S SIGNATURE & STAMP	BHEL QA SIGNATURE & STAMP	CUSTOMER'S SIGNATURE & STAMP

Vendor's Name & Address:			VENDOR MANUFACTURING QUALITY PLAN						(QP. No.:			
			Customer : BHEL, HYDERABAD -32			BHEL P. O .No.:			Rev.:		Date :		
			Project :			P.O.Date:							
			Product :			BHEL Spec :	HEL Spec: Rev:			Page 1 of 1			
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		CHARACII	ENISTICS	CLASS	CHECK	OF CHECK	DOCUMENT	NORMS	RECORD) D	Р	WV	REMARKS

<u> Annexure – I</u>

Sampling Plan for Inspection

SI NO.	Lot Size (Numbers)	Sample Size	Acceptance Number (Maximum number of permissible defectives)			
1.	2 - 8	Sample size = Lot Size	0			
2.	9 - 15	Sample size = Lot Size	0			
3.	16 - 25	8	0			
4.	26 - 50	13	0			
5.	51 - 90	20	0			
6.	91 - 150	32	0			
7.	151 - 280	50	0			
8.	281 - 500	80	0			
9.	501 - 1200	125	0			
10.	1201 - 3200	200	0			

Visual Inspection:

Vendor: 100% BHEL / BHEL TPIA:

A) 1 - 200 numbers lot size, 100% to be visually inspected.

B) > 200 numbers lot size, 200 numbers to be visually inspected.

LEGEND: P: PERFORM, W: WITNESS, V: VERIFICATION. INDICATE 1: BHEL / BHEL NOMINATED INSPECTION AGENCY; 2: VENDOR; 3: SUB-VENDOR; 4: BHEL'S CUSTOMER / CONSULTANT AS APPROPRIATE AGAINST EACH COMPONENT / CHARACTERISTICS UNDER THE COLUMNS P W & V. * FOR ITEMS MARKED ✓ (TICK) UNDER COLUMN 'D', TEST CERTIFICATES SHALL BE SUBMITTED TO BHEL FOR RECORDS.

PREPARED BY

REVIEWED BY

APPROVED BY

VENDOR'S SIGNATURE & STAMP

CUSTOMER'S SIGNATURE & STAMP

CUSTOMER'S SIGNATURE & STAMP

Format no.: HYQA/QP/VMQP Rev.03

GENERAL NOTES:

- 1. Vendor shall submit complete inspection and test and documentation whichever is identified with $(\sqrt{})$ under column D of approved quality plan shall be enclosed with the inspection Report
- 2. Vendor shall submit Original copies of all inspection and test documents authenticated by TPIA
- 3. Latest version of Standards/Drawings/Tolerances etc to be mentioned in Quality Plan/Drawing
- 4. BHEL reserves the right for conducting repeat test, if required
- 5. BHEL approved inspection engineers to be deployed for inspection
- 6. Only Level II & above qualified person in respective NDE (as applicable as per PO) to verify or witness the NDT test report/results
- 7. Inspection to be offered only after ensuring that all documents (Quality Plan, Drawings, Data Sheet, Purchase Specifications, etc) are available as per Purchase order
- 8. Vendor to offer original Test Certificates issued by Third Party laboratories or Suppliers
- 9. Vendor to ensure TPIA that a note' Compared with Original Test Certificate. Reviewed, verified and found in order' shall contain with every inspection report
- 10. Only valid and calibrated measuring instruments and equipment shall be used
- 11. Vendor to ensure that material Test Certificate & Traceability Records are available for use of correct material
- 12. Qualification of equipment, process & personnel for special processes like welding, or painting & metal coating etc.(as applicable as per PO) shall be ensured
- 13. Vendor to ensure that all certificates are endorsed by TPIA with comments (Witnessed or Verified), as applicable pert quality plan
- 14. Vendor shall ensure to offer log sheets containing actual measured values instead of saying OK/Not OK to TPIA