



Vendor's Name & Address:		<b>VENDOR MANUFACTURING QUALITY PLAN</b>							QP. No.:				
		Customer : BHEL, HYDERABAD -32				BHEL P. O .No.:			Rev.:		Date :		
		Project :				P.O.Date :			Page 1 of 1				
Product :				BHEL Spec :			Rev :						
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	AGENCY P   W   V			REMARKS

**Annexure – I**  
**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
<b><u>Visual Inspection:</u></b>  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: <b>P</b> : PERFORM, <b>W</b> : WITNESS, <b>V</b> : 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	APPROVED BY
	VENDOR'S SIGNATURE & STAMP	BHEL QA 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 (√) 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 per quality plan
14. Vendor shall ensure to offer log sheets containing actual measured values instead of saying OK/Not OK to TPIA