

 MANUFACTURER'S NAME & ADDRESS M/S BHEL / BAP / RANIPET TAMIL NADU-632 406	STANDARD QUALITY PLAN				
	ITEM/SUB SYSTEM: Air Receiver		Doc. No		SDP APH 103
			Rev. No/Date		01/17 01 07
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SL NO	COMPONENT & OPERATION	CHARACTERISTICS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORDS	Agency	REMARKS
1	2	3	4	5	6	7	8	9 M B	10

1.0	Raw material								
1.1	Plates, Dished end, Flanges, Nozzles.	Chemical and mechanical properties	Chemical and Mechanical	100%	Respective material specification as per approved drawing		TC	P	V
1.2	NDE for above plates	Soundness for plates ≥ 25 mm thick	UT	100%	SA 435		TC	P	V
2.0	In process Control								
2.1	Welding	Welders & Procedures shall be qualified to ASME Sec IX. BHEL will review procedures and welders qualification							
2.2	Butt weld	Soundness	RT	100%	ASME VIII DIV 1/ UHT 57		NDT Report	P	V
2.3	Attachment fillet weld	Soundness	MP/LPI	100%	ASME VIII DIV 1/ UHT 57		NDT Report	P	V

LEGENDS: M - Manufacturer, BHEL Shop / Subcontractor, B - BHEL QC/ Authorised Inspection agency P - Performed By, V - Verification Of Reports, W - Witness T C - Test Certificate R- report, HT-Heat treatment	Prepared by		APPROVED BY:
	Reviewed by		

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2.5	Shell	Dimension	Measurement	100%	As per approved drawing		DR	P	V	
2.6	Dished end	Thinning at knuckle DP check at knuckle	Measurement by D Meter DP check	100%	As per approved drawing ASME VIII DIV I /UHT 57		Report NDT Report	P	V	
3.0	Final Inspection	Heat treatment (##)	Review of HT chart	100%	ASME VIII DIV I /UHT 57		HT Chart	P	V	CHP-Record verification along with Clause 3.1
3.1	Dimensional Inspection of air receiver	Circumference, ovality, length, orientation of nozzles, wall thickness.	Measurement	100%	As per approved drawing/ PRQA 500/Latest		DR	P	W	

- (##) (a) Stress relieving will be done in case of cold forming of dished ends, as there is no micro structural change.
(b) Normalizing will be done in case of hot forming of dished ends as there is micro structural change.

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	Reviewed by <i>B. Suresh</i>		



MANUFACTURER'S NAME & ADDRESS Ranipet	STANDARD QUALITY PLAN	
	ITEM/SUB SYSTEM: Air Receiver	
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3.2	Hydro test	Leak proof test of weld	Pressure test	100%	As per approved drawing/ Engineering specification & (Ref. note 1.0, 2.0)		DR	P W	CHP
3.3	Painting and finish, Identification	Paint Finish	Visual	100%	BHEL Engineering Technical specification & Note 3.0		--	P V	CHP

NOTE:

- 1.0 Hydro test details shall be punched & Bordered with white paint.
- 2.0 After hydro test, the water in Air receiver shall be completely drained and dried. All openings shall be closed with suitable end covers.
- 3.0 W.O details shall be punched and the same details shall be stenciled with paint.

Record of revision	Rev 00 / DT 19 11 2001	Original Issue
	Rev 01/ DT 17 01 07	Painting requirement corrected
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	Reviewed by <i>B. Subramanian</i>	