



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

STANDARD QUALITY PLAN FOR HEAT RESISTANT GLASS

SQP:SD:30 Rev No: 00

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Prepared By  
Quality Assurance

ABDUR RAHMAN SULTAN

*Abdur Rahman Sultan*  
25.10.2018

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Rev No	Date	Approved by	Signature
00	25/10/18	AGM / QA & BE	<i>[Signature]</i>

Record of Revisions

Rev No	Details of Revision	Remarks
00	Fresh Issue	

Proprietary Data - For Internal Use Only

 <b>MANUFACTURER'S NAME &amp; ADDRESS:</b> BHEL: TIRUCHIRAPPALLI APPROVED SUPPLIERS		<b>STANDARD QUALITY PLAN</b>							QWI NO:SQP:SD:30 REV NO: 00 DATE: 25/10/2018 PAGE: 2 OF 2				
		PRODUCT: HEAT RESISTANT GLASS											
		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
					M	C/N				M	C	N	
1	2	3	4	5	M	C/N	7	8	9	D*	**	10	11

<b>1.0 RAW MATERIALS &amp; BOUGHT OUT ITEMS</b>													
1.1	Raw Material - Heat Resistant Glass	Chemical and Mechanical Properties	A	TC Review	100%	100%	Material Spec, BHEL approved drawing/ Specification	MTC	√	P	V	-	
<b>2.0 INPROCESS CONTROL</b>													
2.1	Testing at service temperature	Temperature withstand ability	A	TC Review	10%	10%	BHEL Data Sheet & BHEL Engg. Specification 4-28-220-00626 (latest)	Test Certificate*	√	P	V*	-	*From NABL approved Lab**
<b>3.0 FINAL INSPECTION</b>													
3.1	Visual and Dimensions	Overall Dimension and Finish	A	Visual, Dimensions	100%	10%	BHEL Data Sheet & BHEL Engg. Specification 4-28-220-00626 (latest)	IR	√	P	W*	-	*10% by BHEL/BHEL AIA
<b>4.0 PACKING &amp; CERTIFICATION</b>													
4.1	Packing & Identification	Good Packing	B	Visual	100%	100%	Purchase Order, BHEL Engg. Specification, Manufacturer's procedure	IR	√	P	V	-	
4.2	Compilation of records	BHEL PO and BHEL Purchase Specification, MTCs and Inspection records	A	Completion of Documentation	100%	100%	Purchase Order, Approved Data sheet & BHEL Engg. Specification 4-28-220-00626 (latest), MTCs and IRs	Data Folder	√	P	V	-	

\*\* If the tests are carried out at other than NABL/Government approved Lab, then 10% Witness by BHEL QC/AIA shall be done

**NOTES:**

1. Purchase Specification — 4-28-220-00626 (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; (T)/(T's): Type test.