



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

STANDARD QUALITY PLAN FOR CORRUGATED ALUMINIUM SHEET

SQP:SD:32 Rev No: 00

Page: 1 of 3

Prepared By
Quality Assurance

ABDUR RAHMAN SULTAN

[Signature]
19/02/2019

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Rev No	Date	Approved by	Signature
00	19/02/2019	AGM / QA & BE	<i>[Signature]</i> 19/2/19

Record of Revisions

Rev No	Details of Revision	Remarks
00	Fresh Issue	

Proprietary Data - For Internal Use Only

 MANUFACTURER'S NAME & ADDRESS: BHEL: TIRUCHIRAPPALLI APPROVED SUPPLIERS		STANDARD QUALITY PLAN							QWI NO:SQP:SD:32 REV NO: 00 DATE: 19/02/2019 PAGE: 2 OF 3				
		PRODUCT: CORRUGATED ALUMINIUM SHEET											
		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

1.0 RAW MATERIALS & BOUGHT OUT ITEMS													
1.1	Ingot	Chemical Properties	A	TC Review	1/Heat	IS 1254/ IS 737, BHEL Technical Specification	IS 1254/ IS 737, BHEL Technical Specification	MTC	√	P	V	-	
2.0 INPROCESS CONTROL													
2.1	Rolling Process	Hot Rolling/ Cold Rolling	B	In-process record review	100%	IS 737	IS 737	IR	√	P	V	-	
2.2	Roll Forming	Thickness	B	Measurement	Each Coil	IS 1254	IS 1254	Log/	-	P	-	-	
		Length/ Width	B	Measurement	Each Coil	IS 1254	IS 1254	Internal	-	P	-	-	
		Surface Quality	B	Visual	Each Coil	IS 1254	IS 1254	records	-	P	-	-	
2.3	Heat Treatment	Temperature Vs Time Characteristics, HT Condition	A	Verification	100%	IS 737	IS 737, PO, BHEL Technical Specification	HT Chart	√	P	V	-	
3.0 FINAL ASSEMBLY & TESTING													
3.1	Surface Quality	Free From Defects	A	Visual	One sheet of each mother coil	IS 737 / IS 1254	IS 1254 / IS 737	IR	√	P	W	-	
3.2	Mechanical Property	Tensile & Percent Elongation	A	Visual and Measurement	One per Each coil per Heat	IS 737 / IS 1254	IS 1254/ IS 737 & BHEL Technical Specification	Lab Test Report	√	P	W	-	
		Bend Test	A		No				√	P	W	-	
3.3	Dimensions	Profile (Depth & Pitch of corrugation), Thickness, Width, Length, Squareness	A	Measurement	One sheet of each mother coil	IS 1254 / IS 737, PO, BHEL Technical Specification	IS 1254/ IS 737, PO, BHEL Technical Spec.	MTC	√	P	W	-	
4.0 MARKING, PACKING AND PRESERVATION:													
4.1	Marking/ Identification	Name of Manufacturer, Grade, Thickness, Width, length, Condition of material (Temper)	A	Visual	100%	100%	IS 1254 / IS 737, BHEL Purchase Order	IS 1254 / IS 737, BHEL Purchase Order	IR	√	P	V	-
4.2	Packing	Tightness & Completion	B	Visual	100%	100%	IS 1254 / IS 737, BHEL Technical Specification	IS 1254 / IS 737, BHEL Technical Specification	IR	√	P	V	-

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)/(Ts): Type test.

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5.0 CERTIFICATION:													
5.1	Certification	Conformation to specifications	A	Review of documents	100%	100%	Purchase Order, BHEL Technical Specification, BHEL SQP, MTCs and Inspection/Test reports	IR	√	P	V	-	

NOTES:

- The latest editions/ revisions of the above mentioned/ referred standards/ procedures/ specifications shall be used.
- BHEL Technical Specification – 4-00-235-20110 (Latest revision)

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